

RheTech Thermoplastic Polyolefin FT1002-00

Polyolefin

RheTech, Inc.

Message:

Thermoplastic Polyolefin, 120K Flexural Modulus, Non-UV Stabilized, Natural.

General Information			
Appearance	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.898	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	63		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	19.3	MPa	ASTM D638
Flexural Modulus	827	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	800	J/m	ASTM D256
Dart Drop Impact	22.6	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	82.2	°C	ASTM D648
1.8 MPa, not annealed	48.9	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	65.6 - 82.2	°C	
Drying Time	1.0 - 2.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	188 - 216	°C	
Middle Temperature	193 - 221	°C	
Front Temperature	199 - 227	°C	
Nozzle Temperature	204 - 216	°C	
Mold Temperature	26.7 - 48.9	°C	
Injection Pressure	2.76 - 10.3	MPa	
Holding Pressure	2.07 - 8.27	MPa	
Back Pressure	0.345 - 1.03	MPa	
Injection instructions			

Injection Speed: Variable -- Application DependantScrew RPM: Recovery 3 seconds before mold opensCycle Time: Wall Thickness Dependant

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