

RheTech Thermoplastic Polyolefin FT4200-00

Polyolefin
RheTech, Inc.

Message:
Thermoplastic Polyolefin, 150K Flexural Modulus, Non-UV Stabilized, Natural.

General Information			
Filler / Reinforcement	Filler, 28% filler by weight		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	13	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	61		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	15.9	MPa	ASTM D638
Flexural Modulus	1030	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	160	J/m	ASTM D256
Dart Drop Impact	13.6	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	73.9	°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	204 - 232	°C	
Middle Temperature	210 - 238	°C	
Front Temperature	216 - 243	°C	
Nozzle Temperature	221 - 232	°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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