

Riteflex® XFR 440

Thermoplastic Copolyester Elastomer

Celanese Corporation

Message:

Riteflex XFR 440 is a nominal 40 Shore D thermoplastic polyester elastomer featuring a halogen-free flame retardant system. It is UL certified to be V-0 at 1.5 mm in all colors. It exhibits an excellent balance of flexibility, flame retardance and processability.

General Information			
UL YellowCard	E45575-100088087		
Additive	Flame retardancy		
Features	Workability, good		
	Good flexibility		
	Flame retardancy		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	7.1	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	15.0	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 15 sec)	40		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	100	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	10.0	MPa	ISO 527-2/1A/50
Tensile Strain (Break)	500	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	> 50	%	ISO 527-2/1A/50
Elastomers	Nominal Value	Unit	Test Method
Tear Strength - Flow ¹	40	kN/m	ISO 34-1
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	25	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Melting Temperature ²	195	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Dielectric Strength	14	kV/mm	IEC 60243-1
Comparative Tracking Index	> 600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Oxygen Index	32	%	ISO 4589-2
Injection	Nominal Value	Unit	

Suggested Max Regrind	25	%
Rear Temperature	185 - 200	°C
Middle Temperature	200 - 210	°C
Front Temperature	200 - 210	°C
Nozzle Temperature	200 - 215	°C
Processing (Melt) Temp	200 - 215	°C
Mold Temperature	20.0 - 55.0	°C
Injection Rate	Fast	
Back Pressure	0.00 - 0.345	MPa

Injection instructions

Zone 4 Temperature: 200 to 215°C Screw Speed: Medium

NOTE

1. Die C
2. 10°C/min

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