

# Optimum® 800

Copolyester  
RAUH Polymers, Inc.

Message:

Optimum® 800 is a Copolyester product. It can be processed by injection molding and is available in North America. Primary characteristic: flame rated.

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	40 to 50	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup> (Yield)	53.1	MPa	ASTM D638
Tensile Elongation <sup>2</sup> (Break)	150	%	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	910	J/m	ASTM D256
Instrumented Dart Impact	36.2	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 3.18 mm)	125	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	76.7 to 82.2	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	260 to 266	°C	
Middle Temperature	266 to 271	°C	
Front Temperature	266 to 271	°C	
Nozzle Temperature	274 to 277	°C	
Processing (Melt) Temp	232 to 266	°C	
Mold Temperature	82.2 to 93.3	°C	
Injection Pressure	55.2 to 68.9	MPa	
Injection Rate	Moderate		
Holding Pressure	41.4 to 55.2	MPa	
Back Pressure	0.00 to 2.76	MPa	
NOTE			
1.	Type I		

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