RS650

Extrusion Molding Grade

Description

- General Purpose

Applications

- Miscellaneous

Properties	Method	Unit	RS650
Physical			
Specific Gravity , 23℃	ASTM D792		1.04
Mold Shrinkage , 23℃, 3.2mm , 23℃	ASTM D955	%	0.4 ~ 0.7
Melt Flow Rate , 220℃, 10kg	ASTM D1238	g/10min	6
Mechanical			
Tensile Strength at Yield , 23℃, 50mm/min, 3.2mm	ASTM D638	Mpa	48
Tensile Elongation at Yield , 23℃, 50mm/min, 3.2mm	ASTM D638	%, (Min)	5
Tensile Elongation at Break , 23℃, 50mm/min, 3.2mm	ASTM D638	%, (Min)	15
Tensile Modulus , 23℃, 50mm/min, 3.2mm	ASTM D638	MPa	2300
Flexural Strength , 23℃, 15mm/min, 3.2mm	ASTM D790	Mpa	79
Flexural Modulus , 23℃, 15mm/min, 3.2mm	ASTM D790	MPa	2500
Izod Impact Strength , Notched, 3.2mm, 23℃	ASTM D256	J/m	320
Izod Impact Strength , Notched, 3.2mm, -30℃	ASTM D256	J/m	150
Izod Impact Strength , Notched, 6.4mm, 23℃	ASTM D256	J/m	290
Izod Impact Strength , Notched, 6.4mm, -30℃	ASTM D256	J/m	140
Rockwell Hardness , R-Scale	ASTM D785		107
Thermal			
HDT , Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	℃	87
VICAT , 50N, 50℃/h	ASTM D1525	℃	95
RTI Electrical	UL 746B	℃	60
RTI Mechanical with Impact	UL 746B	℃	60
RTI Mechanical without Impact	UL 746B	℃	60
Flammability, 1.5mm	UL 94		HB
Flammability, 3.0mm	UL 94		HB

Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors.Values given should not be interpreted as specification and not be used for designing part or tool.All properties, except melt flow rate are measured by injection molded specimens after 48 hours storage at 23℃, 50% relative humidity.

Updated Date : 16-Nov-17 Issued Date : 6-Mar-18

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Processing Guide (Extrusion Molding)

Processing Parameters	Unit	Value
Drying Temperature	℃	70 ~ 80
Drying Time	hrs	3 ~ 4
Minimum Moisture Content	%	0.01 ~ 0.01
Melt Temperature	℃	200 ~ 250
Barrel Temperature, Zone 1	℃	180 ~ 210
Barrel Temperature, Zone 2	℃	190 ~ 230
Barrel Temperature, Zone 3	℃	200 ~ 250
Barrel Temperature, Zone 4	℃	200 ~ 250
Adapter Temperature	℃	200 ~ 250
Die Temperature	℃	200 ~ 250
Roll Stack Temperature, Top	℃	70 ~ 100
Roll Stack Temperature, Middle	℃	70 ~ 90
Roll Stack Temperature, Bottom	℃	60 ~ 90

Note

Recommend initial lower temperatures settings to avoid material degradation/hang-up in die & purge material from extruder prior to shutdown.

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