

WeConnectScience



ER460-T

Description

ER460-T has low VOC and is targeted for injection molding.

Key Features

Medium Heat Resistance, Low TVOC

Application

Bumper

Properties	Condition	Method	Unit	ER460-T
Physical				
Melt Flow Rate	220°C, 10kg	ISO 1133	g/10min	22
Mechanical				
Tensile Strength at Yield	23°C, 50mm/min, 4mm	ISO 527	MPa	46
Charpy Impact Strength	Notched, 4mm, 23°C	ISO 179/1eA	kJ/m ²	22
Rockwell Hardness	R-Scale	ISO 2039		110
Thermal				
Heat Deflection Temperature	Flatwise, 1.8MPa, 4mm, Unannealed	ISO 75	°C	82
Vicat Softening Temperature	50N, 50°C/h	ISO 306	°C	100

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 index are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

Updated Date: 2021-05-07 Issued Date : 2023-03-14

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	70 ~ 80
Drying Time	hrs	2 ~ 4
Injection Temperature	°C	210 ~ 240
Mold Temperature	°C	40 ~ 70
Screw Speed	rpm	Low speed

Note

Injection Temperature & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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