

SolutionPartner


ER462

Injection Molding Grade

Description

- High Flow, Medium High Heat

Applications

- Automotives, E&E, miscellaneous goods

Properties	Method	Unit	ER462
Physical			
Specific Gravity , 23°C	ASTM D792		1.05
Mold Shrinkage , 23°C, 3.2mm , 23°C	ASTM D955	%	0.4 ~ 0.7
Melt Flow Rate , 220°C, 10kg	ASTM D1238	g/10min	50
Mechanical			
Tensile Strength at Yield , 23°C, 50mm/min, 3.2mm	ASTM D638	Mpa	43
Flexural Strength , 23°C, 15mm/min, 3.2mm	ASTM D790	Mpa	60
Flexural Modulus , 23°C, 15mm/min, 3.2mm	ASTM D790	MPa	2100
Izod Impact Strength , Notched, 3.2mm, 23°C	ASTM D256	J/m	240
Izod Impact Strength , Notched, 6.4mm, 23°C	ASTM D256	J/m	160
Thermal			
HDT , Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	90
VICAT , 50N, 50°C/h	ASTM D1525	°C	98

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°C, 50% relative humidity.

Updated Date : 27-Feb-18 Issued Date : 7-Mar-18

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80
Drying Time	hrs	3 ~ 4
Maximum Moisture Content	%	~ 0.05
Melt Temperature	°C	230 ~ 260
Cylinder Temperature , Rear	°C	180 ~ 210
Cylinder Temperature, Middle	°C	210 ~ 230
Cylinder Temperature , Front	°C	230 ~ 240
Nozzle Temperature	°C	230 ~ 240
Mold Temperature	°C	40 ~ 60
Back Pressure, Hydraulic Type	kg/cm ²	10 ~ 30
Screw Speed	rpm	30 ~ 60

Note

Back Pressure & Measuring 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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