

WeConnectScience



MRC650L2

Description

MRC650L2, a Post-Consumer Recycled ABS product for extrusion molding, contains 20% PCR resin and is designed to carry out light colors with the same physical properties as standard extrusion ABS. (Early stage of development : The data can be changed as a result of the quality improvement of the products)

Key Features

Recycled ABS (PCR 20%), Thermoforming, Chemical Resistance to Cyclopentane, High Impact Strength

Application

Refrigerator

Properties	Condition	Method	Unit	MRC650L2
Physical				
Specific Gravity	23°C	ASTM D792		1.04 ~ 1.08
Mold Shrinkage	23°C, 3.2mm	ASTM D955	%	0.4 ~ 0.7
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	4
Mechanical				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	42
Tensile Elongation at Break	23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	10 ~
Flexural Strength	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	72
Flexural Modulus	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	2550
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	J/m	270
Rockwell Hardness	R-Scale	ASTM D785		104
Thermal				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	85
Flammability	1.5mm	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 index are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

Updated Date: 2021-05-07 Issued Date : 2023-03-09

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Processing Guide (Extrusion)

Processing Parameters	Unit	Value
Drying Temperature	°C	70 ~ 80
Drying Time	hrs	3 ~ 4
Moisture Content	%	~ 0.01
Extrusion Temperature	°C	180 ~ 250

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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