

SolutionPartner


SH625

Extrusion Molding Grade

Description

- High Impact, High Flow

Applications

- Ski Flat, Miscellaneous

Properties	Method	Unit	SH625
Physical			
Specific Gravity , 23°C	ASTM D792		1.04
Mold Shrinkage , 23°C, 3.2mm , 23°C	ASTM D955	%	0.4 ~ 0.7
Melt Flow Rate , 220°C, 10kg	ASTM D1238	g/10min	7
Mechanical			
Tensile Strength at Yield , 23°C, 50mm/min, 3.2mm	ASTM D638	Mpa	34
Tensile Elongation at Yield , 23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	5
Tensile Elongation at Break , 23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	15
Tensile Modulus , 23°C, 50mm/min, 3.2mm	ASTM D638	MPa	1250
Flexural Strength , 23°C, 15mm/min, 3.2mm	ASTM D790	Mpa	49
Flexural Modulus , 23°C, 15mm/min, 3.2mm	ASTM D790	MPa	1450
Izod Impact Strength , Notched, 3.2mm, 23°C	ASTM D256	J/m	540
Izod Impact Strength , Notched, 3.2mm, -30°C	ASTM D256	J/m	250
Izod Impact Strength , Notched, 6.4mm, 23°C	ASTM D256	J/m	460
Izod Impact Strength , Notched, 6.4mm, -30°C	ASTM D256	J/m	210
Rockwell Hardness , R-Scale	ASTM D785		95
Thermal			
HDT , Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	85
VICAT , 50N, 50°C/h	ASTM D1525	°C	90

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

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.

SolutionPartner


SH625

Extrusion Molding Grade

Description

- High Impact, High Flow

Applications

- Ski Flat, Miscellaneous

Processing Guide (Extrusion Molding)

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

Note

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

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

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.