

WeConnectScience



XR401-A

Description

XR401-A has well-balanced properties with high heat, targeted for injection molding

Key Features

High Heat Resistance, Paintability

Application

Exterior ETC, Outside Mirror, Spoiler

Properties	Condition	Method	Unit	XR401-A
Physical				
Specific Gravity	23°C	ISO 1183		1.05
Melt Flow Rate	220°C, 10kg	ISO 1133	g/10min	16
Mechanical				
Tensile Strength at Yield	23°C, 50mm/min, 4mm	ISO 527	MPa	48
Flexural Strength	23°C, 2mm/min, 4mm	ISO 178	MPa	77
Flexural Modulus	23°C, 2mm/min, 4mm	ISO 178	MPa	2650
Izod Impact Strength	Notched, 4mm, 23°C	ISO 180/1A	kJ/m ²	17
Charpy Impact Strength	Notched, 4mm, 23°C	ISO 179/1eA	kJ/m ²	13
Rockwell Hardness	R-Scale	ISO 2039		111
Thermal				
Heat Deflection Temperature	Flatwise, 1.8MPa, 4mm, Unannealed	ISO 75	°C	88
Vicat Softening Temperature	50N, 50°C/h	ISO 306	°C	106

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.

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 90
Drying Time	hrs	3 ~ 4
Injection Temperature	°C	220 ~ 250
Mold Temperature	°C	40 ~ 60
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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