

SolutionPartner


TR580

Injection Molding

Description

- Transparency, Chemical Resistance

Applications

- Medical Products

Properties	Method	Unit	TR580
Physical			
Specific Gravity , 23°C	ASTM D792		1.06
Mold Shrinkage , 23°C, 3.2mm , 23°C	ASTM D955	%	0.4 ~ 0.7
Melt Flow Rate , 220°C, 10kg	ASTM D1238	g/10min	2.5
Mechanical			
Tensile Strength at Yield , 23°C, 50mm/min, 3.2mm	ASTM D638	Mpa	39
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	1600
Flexural Strength , 23°C, 15mm/min, 3.2mm	ASTM D790	Mpa	64
Flexural Modulus , 23°C, 15mm/min, 3.2mm	ASTM D790	MPa	1800
Izod Impact Strength , Notched, 3.2mm, 23°C	ASTM D256	J/m	80
Izod Impact Strength , Notched, 3.2mm, -30°C	ASTM D256	J/m	20
Izod Impact Strength , Notched, 6.4mm, 23°C	ASTM D256	J/m	80
Izod Impact Strength , Notched, 6.4mm, -30°C	ASTM D256	J/m	20
Thermal			
HDT , Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	79
VICAT , 50N, 50°C/h	ASTM D1525	°C	87
Optical			
Haze	ASTM D1003	%	1.2
Luminous Transmittance , 3.2mm	ASTM D1003	%	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 : 9-Aug-17 Issued Date : 6-Mar-18

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 90
Drying Time	hrs	2 ~ 4
Minimum Moisture Content	%	~ 0.1
Melt Temperature	°C	220 ~ 250
Cylinder Temperature , Rear	°C	210 ~ 230
Cylinder Temperature, Middle	°C	220 ~ 240
Cylinder Temperature , Front	°C	230 ~ 250
Nozzle Temperature	°C	230 ~ 260
Mold Temperature	°C	50 ~ 70
Back Pressure, Hydraulic Type	kg/cm ²	30 ~ 60
Screw Speed	rpm	30 ~ 80

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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