

# XR630

Extrusion Molding

## Description

- Profile Extrusion, Heat Resistance

## Applications

- Profile Extrusion

Properties	Method	Unit	XR630
<b>Physical</b>			
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
<b>Mechanical</b>			
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)	15
Izod Impact Strength , Notched, 3.2mm, 23°C	ASTM D256	J/m	310
Izod Impact Strength , Notched, 6.4mm, 23°C	ASTM D256	J/m	250
Rockwell Hardness , R-Scale	ASTM D785		104
<b>Thermal</b>			
HDT , Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	102
HDT , Edgewise, 0.46MPa, 6.4mm, Unannealed	ASTM D648	°C	112
VICAT , 10N, 120°C/h	ASTM D1525	°C	112

## 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.

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### Processing Guide (Extrusion Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 90
Drying Time	hrs	3 ~ 4
Moisture Content	%	0.04 ~
Melt Temperature	°C	200 ~ 230
Barrel Temperature, Zone 1	°C	180 ~ 200
Barrel Temperature, Zone 2	°C	190 ~ 210
Barrel Temperature, Zone 3	°C	190 ~ 210
Barrel Temperature, Zone 4	°C	200 ~ 220
Adapter Temperature	°C	200 ~ 220
Die Temperature	°C	200 ~ 220

## 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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