

XR410

Description

XR410 has low VOC content and low gloss with high heat properties, targeted for interior parts

Key Features

High Heat Resistance, Non Painting, Low TVOC, Low Gloss

Application

Cockpit, Door Trim, Interior ETC

Properties	Condition	Method	Unit	XR410
Physical				
Specific Gravity	23°C	ASTM D792		1.05
Mold Shrinkage	23°C, 3.2mm	ASTM D955	%	0.4 ~ 0.8
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	7
Mechanical				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	48
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)	10
Flexural Strength	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	75
Flexural Modulus	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	2400
Izod Impact Strength	Notched, 3.2mm, 23°C	ASTM D256	J/m	155
Izod Impact Strength	Notched, 3.2mm, -30°C	ASTM D256	J/m	80
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	J/m	145
Izod Impact Strength	Notched, 6.4mm, -30°C	ASTM D256	J/m	80
Rockwell Hardness	R-Scale	ASTM D785		107
Thermal				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	97
Heat Deflection Temperature	Edgewise, 0.46MPa, 6.4mm, Unannealed	ASTM D648	°C	105
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Annealed	ASTM D648	°C	103
Heat Deflection Temperature	Edgewise, 0.46MPa, 6.4mm, Annealed	ASTM D648	°C	108
Vicat Softening Temperature	50N, 50°C/h	ASTM D1525	°C	107
Flammability	1.5mm	UL 94		HB
Flammability	3.0mm	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 : 2021-09-23

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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 ~ 290
Mold Temperature	°C	40 ~ 80
Screw Speed	rpm	30 ~ 60

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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