reSound™ REC 3630-801 C 60N

Thermoplastic Elastomer

Key Characteristics

Product Description			
reSound™ REC 3630-801 C 60N is general purpose thermoplastic elastomer with post-consumer-recycled (PCR) content and could overmold onto PC, ABS, PC/ABS, Copolyesters.			
General			
Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific		
Recycled Content	• Post-Consumer (PCR), 45%		
Features	• Specialty Grade		
Uses	• Consumer Applications	• Personal Care	• Power/Other Tools
RoHS Compliance	• RoHS Compliant		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	0.900	0.900	ASTM D792
Elastomers	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Stress [2] (300% Strain, 73°F (23°C))	551 psi	3.80 MPa	ASTM D412
Tensile Strength [2, 3] (Break, 73°F (23°C))	986 psi	6.80 MPa	ASTM D412
Tensile Elongation [2, 3] (Break, 73°F (23°C))	650 %	650 %	ASTM D412
Hardness	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Durometer Hardness (Shore A, 10 sec)	58	58	ASTM D2240
Fill Analysis	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Apparent Viscosity			ASTM D3835
392°F (200°C), 11200 sec^-1	7.20 Pa·s	7.20 Pa·s	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Rear Temperature	331 to 370 °F	166 to 188 °C
Middle Temperature	351 to 379 °F	177 to 193 °C
Front Temperature	370 to 440 °F	188 to 227 °C
Nozzle Temperature	360 to 421 °F	182 to 216 °C
Mold Temperature	61 to 100 °F	16 to 38 °C

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Injection Notes

Purge thoroughly before and after use of this product with a low flow (0.5 - 2.5 MFR) polyethylene (PE) or polypropylene (PP). Regrind levels up to 20% reSound™ REC 3630-801 C 60N can be used with minimal property losses, provided that the regrind is free of contamination. The final determination of regrind effectiveness should be determined by the customer.

To minimize losses during molding, the melt temperature should be as low as possible. Maximum residence times may vary, depending on the size of the barrel. Generally, the barrel should be emptied if it is idle for periods of 8 - 10 minutes or longer. Drying is not required.

Color concentrates with polypropylene (PP), ethylene vinyl acetate (EVA), or low density polyethylene (LDPE) carriers are most suitable for coloring. reSound™ REC 3630-801 C 60N Improved color dispersion can be achieved by using higher melt flow concentrates (with a melt flow from 25 - 40 g/10 min). Typical loadings for color concentrates are 1% to 5% by weight. Liquid color can be used, but mineral oil based carriers may have a significant effect on the final hardness value. Concentrates based on PVC should not be used. A high color match consistency can be obtained by using precolored compounds available from GLS. The final determination of color concentrate suitability should be determined by customer trials.

Drying is not Required.

Notes

[1] Typical values are not to be construed as specifications.

[2] Die C

[3] 2 hr

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