MULTIFLEX™ TPO 4004 SW

POLYOLEFIN THERMOPLASTIC ELASTOMER

Rheological properties

Melt volume-flow rate	6	cm³/10min	ISO 1133
Temperature	230	°C	ISO 1133
Load	2.16	kg	ISO 1133
Moulding shrinkage, parallel	1.3	%	ISO 294-4, 2577

Typical mechanical properties

Stress at break	14	MPa	ISO 527-1/-2 or ISO 37
Elongation at break	>300	%	ISO 527-1/-2 or ISO 37
Flexural Modulus	430	MPa	ISO 178
Shore D hardness, 15s	44		ISO 48-4 / ISO 868
Tear strength, parallel	100	kN/m	ISO 34-1

Other properties

Density	890	kg/m³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	65	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Melt Temperature Optimum	230	°C
Mold Temperature Optimum	45	°C
Min. mould temperature	35	°C
Max. mould temperature	50	°C
Injection speed	High	mm/s

Storage and stability

Shelf life	1800	days

Characteristics

Compatibility	Polyolefins

Additional information

Injection molding	Drying before moulding is normally not required, but may be needed if the product is stored in a high humidity environment. Lower temperature on the moving part of the mould is prefered.

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