MULTIFLEX™ TPO 4404 SI1 BLACK 28164

POLYOLEFIN THERMOPLASTIC ELASTOMER

Product information

Colour	Black		

Rheological properties

Melt volume-flow rate	8	cm³/10min	ISO 1133
Temperature	230	°C	ISO 1133
Load	2.16	kg	ISO 1133
Moulding shrinkage, parallel	0.9	%	ISO 294-4, 2577
Flow length	360	mm	

Typical mechanical properties

Stress at break	14	MPa	ISO 527-1/-2 or ISO 37
Elongation at break	170	%	ISO 527-1/-2 or ISO 37
Flexural Modulus	440	MPa	ISO 178
Izod notched impact strength, -45°C	47	kJ/m²	ISO 180/1A
Shore D hardness, 15s	41		ISO 48-4 / ISO 868
Tear strength, parallel	95	kN/m	ISO 34-1

Other properties

Density	890	kg/m³	ISO 1183

Injection

Drying Recommended	no	
Melt Temperature Optimum	235	°C
Mold Temperature Optimum	30	°C
Min. mould temperature	20	°C
Max. mould temperature	40	°C
Hold pressure range	as low as possible	MPa
Back pressure	1	MPa
Injection speed	Medium	mm/s

Storage and stability

Shelf life	1800	days

Characteristics

Compatibility	Polyolefins

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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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