

# XR474

Injection Molding

## Description

- Heat Resistance

## Applications

- Automotive Interior & Exterior Housing

Properties	Method	Unit	XR474
<b>Physical</b>			
Specific Gravity , 23°C	ASTM D792		1.07
Mold Shrinkage , 23°C, 3.2mm , 23°C	ASTM D955	%	0.4 ~ 0.7
Melt Flow Rate , 220°C, 10kg	ASTM D1238	g/10min	3
<b>Mechanical</b>			
Tensile Strength at Yield , 23°C, 50mm/min, 3.2mm	ASTM D638	Mpa	47
Tensile Elongation at Break , 23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	10
Tensile Modulus , 23°C, 50mm/min, 3.2mm	ASTM D638	MPa	2300
Flexural Strength , 23°C, 15mm/min, 3.2mm	ASTM D790	Mpa	77
Flexural Modulus , 23°C, 15mm/min, 3.2mm	ASTM D790	MPa	2450
Izod Impact Strength , Notched, 3.2mm, 23°C	ASTM D256	J/m	135
Izod Impact Strength , Notched, 3.2mm, -30°C	ASTM D256	J/m	60
Izod Impact Strength , Notched, 6.4mm, 23°C	ASTM D256	J/m	125
Izod Impact Strength , Notched, 6.4mm, -30°C	ASTM D256	J/m	50
Rockwell Hardness , R-Scale	ASTM D785		113
<b>Thermal</b>			
HDT , Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	112
VICAT , 50N, 50°C/h	ASTM D1525	°C	122
RTI Electrical	UL 746B	°C	60
RTI Mechanical with Impact	UL 746B	°C	60
RTI Mechanical without Impact	UL 746B	°C	60
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 rate are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

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## Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 90
Drying Time	hrs	3 ~ 4
Maximum Moisture Content	%	0.05 ~ 0.05
Melt Temperature	°C	220 ~ 250
Cylinder Temperature , Rear	°C	180 ~ 200
Cylinder Temperature, Middle	°C	200 ~ 220
Cylinder Temperature , Front	°C	220 ~ 230
Nozzle Temperature	°C	220 ~ 230
Mold Temperature	°C	40 ~ 60
Back Pressure, Hydraulic Type	kg/cm <sup>2</sup>	10 ~ 30

## Note

Back Pressure & Measuring 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.