

Topolymer® 6231-451N0262000**Description:**

Topolymer® 6231-451N0262000 is an easy processing compound. It was designed specially for ABS/SAN/PC/PET-G/PCTA overmolding.

Features:

Excellent tear resistant、flexibility and heat resistant
Good handfeel
Good solvent resistance

Color:

Natural

Processing Method:

Injection molding

Typical property:

Mechanical Properties	Test Method	Value	Unit
Hardness Shore A	ASTM D-2240 1 dwell	45±2	--
Specific Gravity	ASTM D-792	1.09±0.02	g/cm ³
MI,190°C/2.16Kg	ASTM D-1238	35.6	g/10min
Tensile Strength	ASTM D-412	>32	kgf/cm ²
Elongation at Break		>650	%
Tear Strength	ASTM D-624	16	Kgf/cm

Regulation Information Yes/No

FDA Yes

EN-71 Yes

RoHS Yes

Coloring:

The pigment which take PP,EVA or LDPE but PVC as carrier can be used as **Topolymer® 6231-451N0262000** 's coloring pigment. Top Polymer can supply high density color matching; The final ratio of pigment should be judged by customers themselves.

东莞顶塑实业有限公司 Dongguan Top Polymer Enterprise Ltd.

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Purging:

Before or after operation with **Topolymer® 6231-451N0262000**, the machines should be cleaned with PP or PE material of MFR 0.5 to 2.5.

Regrind:

The property of the recycled resin of **Topolymer® 6231-451N0262000** may alter somewhat. The ratio equal or less than 20% of the recycled resin can be added to the new material, please keep the recycled resin away from contamination; and the injection temperature should be lower reasonably in order to reducing the loss. The final recycle effect should be judged by customer themselves after trial.

Drying Time:

No need.

Manufacture:

Topolymer® 6231-451N0262000 has excellent melt stability. The maximum residence time of it in the barrel depends on the size of the barrel. The barrel should be cleaned entirely if the machines shut down for over 8-10 minutes.

Injection		
Zone Temp.	Rear	150°C-180°C
	Center	200°C-220°C
	Front	210°C-225°C
	Nozzle	200°C-210°C
Mold Temp.	40°C-60°C	
Speed	30rpm-80rpm	
Pressure	3MPa-10MPa	
Screw L/D 22:1		

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