



Riteflex® 672A

Celanese Corporation - Thermoplastic Elastomer

Tuesday, November 5, 2019

General Information

Product Description

Riteflex 672A is a 72 Shore D Hardness thermoplastic polyester elastomer with a high modulus.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
Features	• Asia Pacific • Latin America • High Stiffness		

ASTM & ISO Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Molding Shrinkage			ISO 294-4
Across Flow	1.7 to 2.2	%	
Flow	1.7 to 2.2	%	
Mechanical			
Tensile Stress (Break)	3190	psi	ISO 527-2/1A/50
Nominal Tensile Strain at Break	> 50	%	ISO 527-2/1A/50
Impact			
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	2.4	ft-lb/in ²	
73°F	9.0	ft-lb/in ²	
Thermal			
Heat Deflection Temperature (66 psi, Unannealed)	203	°F	ISO 75-2/B
Vicat Softening Temperature	401	°F	ISO 306/A50
Melting Temperature ²	419	°F	ISO 11357-3

Processing Information

	Nominal Value	Unit	Test Method
Injection			
Drying Temperature	212 to 230	°F	
Drying Time	4.0	hr	
Suggested Max Moisture	0.050	%	
Hopper Temperature	68 to 122	°F	
Rear Temperature	419 to 446	°F	
Middle Temperature	419 to 446	°F	
Front Temperature	419 to 446	°F	
Nozzle Temperature	419 to 446	°F	
Processing (Melt) Temp	428 to 455	°F	
Mold Temperature	68 to 131	°F	
Injection Rate	Moderate-Fast		

Injection Notes

Feeding zone temperature: 200 to 215°C

Zone4 temperature: 215 to 230°C

Hot runner temperature: 220 to 235°C

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Notes

¹ Typical properties: these are not to be construed as specifications.

² 10°C/min