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 • Asia Pacific	• Europe • Latin America	• North America
Features	• High Stiffness		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Molding Shrinkage			ISO 294-4
Across Flow	1.7 to 2.2	%	
Flow	1.7 to 2.2	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (Break)	3190	psi	ISO 527-2/1A/50
Nominal Tensile Strain at Break	> 50	%	ISO 527-2/1A/50
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	2.4	ft·lb/in²	
73°F	9.0	ft·lb/in²	
Thermal	**Nominal Value**	**Unit**	**Test Method**
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

Injection	Nominal Value	Unit
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

Riteflex® 672A

Celanese Corporation - Thermoplastic Elastomer

Notes

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

[2] 10°C/min