

# RS681

## Description

RS681 is an ABS specially used for extrusion. It has the chemical properties of cyclopentane resistance, high strength and vacuum blister performance.

## Key Features

Hot Stamping, Paintability, Chemical Resistance to Cyclopentane, Multi-axial Impact Strength, High Impact Strength, Curve Destruction Weight

## Application

Extruded Board, refrigerator liners, home profiles

## Plant

China(Huizhou)

Properties	Condition	Method	Unit	RS681
<b>Physical</b>				
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	4
<b>Mechanical</b>				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	52
Flexural Strength	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	77
Flexural Modulus	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	2500
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	J/m	33
Rockwell Hardness	R-Scale	ASTM D785		105
<b>Thermal</b>				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	88

## 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 index are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

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## Processing Guide (Extrusion)

Processing Parameters	Unit	Value
Drying Temperature	°C	80~90
Drying Time	hrs	3~4

## Note

Recommend initial lower temperatures settings to avoid material degradation/hang-up in die & purge material from extruder prior to shutdown.