

# XR630

## Description

XR630 is a Heat Resistant ABS product for extrusion, designed to have chemical resistance to cleaning agents and high heat resistance.

## Key Features

High Heat Resistance, Chemical Resistance

## Application

Window Profile Insulation Bar

Properties	Condition	Method	Unit	XR630
<b>Physical</b>				
Specific Gravity	23°C	ASTM D792		1.06
Mold Shrinkage	23°C, 3.2mm	ASTM D955	%	0.4 ~ 0.7
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	2.5
<b>Mechanical</b>				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	42
Tensile Elongation at Break	23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	15
Flexural Strength	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	68
Flexural Modulus	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	2150
Izod Impact Strength	Notched, 3.2mm, 23°C	ASTM D256	J/m	310
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	J/m	250
Rockwell Hardness	R-Scale	ASTM D785		104
<b>Thermal</b>				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	102
Heat Deflection Temperature	Edgewise, 0.46MPa, 6.4mm, Unannealed	ASTM D648	°C	112
Vicat Softening Temperature	50N, 50°C/h	ASTM D1525	°C	112

## 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
Moisture Content	%	~ 0.01
Extrusion Temperature	°C	180 ~ 250

## Note

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