Celanese
The chemistry inside innovation™

RITEFLEX® 663 - TPC

Description

Riteflex 663 is a nominal 63 Shore D thermoplastic polyester elastomer with medium modulus.

Physical properties	Value	Unit	Test Standard
Density	**1240**	kg/m³	ISO 1183
Melt flow rate, MFR	**19**	g/10min	ISO 1133
MFR temperature	**240**	°C	ISO 1133
MFR load	**2.16**	kg	ISO 1133
Molding shrinkage, parallel	**1.7 - 2.0**	%	ISO 294-4, 2577
Molding shrinkage, normal	**1.7 - 2.1**	%	ISO 294-4, 2577
Water absorption, 23°C-sat	**0.5**	%	ISO 62
Humidity absorption, 23°C/50%RH	**0.2**	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	**350**	MPa	ISO 527-2/1A
Tensile stress at yield, 50mm/min	**21**	MPa	ISO 527-2/1A
Tensile strain at yield, 50mm/min	**24**	%	ISO 527-2/1A
Tensile nominal strain at break, 50mm/min	**>50**	%	ISO 527-2/1A
Tensile stress at 50% strain, 50mm/min	**21**	MPa	ISO 527-2/1A
Tensile stress at break, 50mm/min	**38**	MPa	ISO 527-2/1A
Tensile strain at break, 50mm/min	**>300**	%	ISO 527-2/1A
Flexural modulus, 23°C	**300**	MPa	ISO 178
Flexural modulus, -40°C	**1900**	MPa	ISO 178
Flexural strength, 23°C	**15**	MPa	ISO 178
Charpy impact strength, 23°C	**NB**	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	**NB**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	**105**[P]	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**22**	kJ/m²	ISO 179/1eA
Izod impact notched, 23°C	**74**	kJ/m²	ISO 180/1A
Izod impact notched, -40°C	**7**	kJ/m²	ISO 180/1A
Bayshore resilience	**40**	%	ASTM D 2632
Ross flex	**>1000000**	cycles	ASTM D 1052

P: Partial Break

Mechanical properties (TPE)	Value	Unit	Test Standard
Tensile stress at 5% strain, 1BA	**13**	MPa	ISO 527-1, -2
Tensile stress at 10% strain, 1BA	**18**	MPa	ISO 527-1, -2
Tensile stress at 50% strain, 1BA	**19**	MPa	ISO 527-1, -2
Tensile stress at break, 1BA	**38**	MPa	ISO 527-1, -2
Shore D hardness, 15s	**63**	-	ISO 868
Tear strength, Die C/parallel	**160**	kN/m	ISO 34-1

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	**212**	°C	ISO 11357-1/-3
DTUL at 0.45 MPa	**114**	°C	ISO 75-1, -2
Vicat softening temperature, 50°C/h 10N	**194**	°C	ISO 306
Coeff. of linear therm expansion, parallel	**1.8**	E-4/°C	ISO 11359-2
Flammability at thickness h	**HB**	class	UL 94
thickness tested (h)	**1.50**	mm	UL 94

Electrical properties	Value	Unit	Test Standard
Relative permittivity, 1MHz	**4**	-	IEC 60250
Dissipation factor, 1MHz	**400**	E-4	IEC 60250
Volume resistivity	**2E13**	Ohm*m	IEC 60093
Surface resistivity	**1E16**	Ohm	IEC 60093
Electric strength	**14**	kV/mm	IEC 60243-1

RITEFLEX® 663 - TPC

Comparative tracking index	**PLC 0**	-	IEC 60112

Typical injection moulding processing conditions

Pre Drying	**Value**	**Unit**	**Test Standard**
Necessary low maximum residual moisture content	**0.05**	%	-
Drying time	**4**	h	-
Drying temperature	**100 - 110**	°C	-
Temperature	**Value**	**Unit**	**Test Standard**
Hopper temperature	**20 - 50**	°C	-
Feeding zone temperature	**200 - 215**	°C	-
Zone1 temperature	**200 - 215**	°C	-
Zone2 temperature	**215 - 230**	°C	-
Zone3 temperature	**215 - 230**	°C	-
Zone4 temperature	**215 - 235**	°C	-
Nozzle temperature	**215 - 235**	°C	-
Melt temperature	**215 - 235**	°C	-
Mold temperature	**20 - 55**	°C	-
Hot runner temperature	**215 - 235**	°C	-
Speed	**Value**	**Unit**	**Test Standard**
Injection speed	**medium-fast**	-	-

Other text information

Pre-drying

To avoid hydrolytic degradation during processing, Riteflex resins have to be dried to a moisture level equal to or less than 0.05%. Drying should be done in a dehumidifying hopper dryer capable of dewpoints <-40°F (-40°C) at 225°F (107°C) for 4 hours.

Longer pre-drying times/storage

For subsequent storage of the material in the dryer until processed (<= 60 h) it is necessary to lower the temperature to 100° C.

Injection molding

Rear Temperature 390-420(200-215) deg F (deg C)
Center Temperature 420-450(215-230) deg F (deg C)
Front Temperature 420-450(215-230) deg F (deg C)
Nozzle Temperature 420-450(215-230) deg F (deg C)
Melt Temperature 430-460(220-235) deg F (deg C)
Mold Temperature 75-125(20-55) deg F (deg C)
Back Pressure 0-50 psi
Screw Speed Medium
Injection Speed Fast

Injection speed, injection pressure and holding pressure have to be optimized to the individual article geometry. To avoid material degradation during processing low back pressure and minimum screw speed have to be used. Overheating of the material has to be avoided, in particular for flame retardant grades. Up to 25% clean and dry regrind may be used.

Characteristics

Product Categories	**Processing**
Unfilled	Injection molding