

POKETONE® M71FR2B

Description

Rubber reinforced tube extrusion grade

Physical Properties	Value	Unit	Test Method & Condition
Density	1.16	g/cm ³	ISO 1183
Melt flow index 220°C/2.16kg	2.8	g/10min	ISO 1133

Mechanical Properties	Value	Unit	Test Method & Condition
Tensile strength at yield	45	MPa	ISO 527-2/1A
Nominal Strain at break	250	%	ISO 527-2/1A
Tensile modulus	300	MPa	ISO 527-2/1A
Flexural strength	21	MPa	ISO 178
Flexural modulus	300	MPa	ISO 178
Notched Charpy impact strength	N.B.	kJ/m ²	ISO 179/1eU, 23°C
	7.9	kJ/m ²	ISO 179/1eU, -40°C

Thermal Properties	Value	Unit	Test Method & Condition
Melting temperature	197	°C	ISO 11357

Flammability Properties	Test Method & Condition	Value
Flame resistance	UL 94	HB (0.8 mm)

Extrusion Processing Conditions		Value	Unit	
Pre-drying	Drying temperature	80	°C	
	Drying time	3 ~ 4	hr	
	Suggested max moisture	0.20	%	
Temperature	Adapter & Die temperature	215	°C	
	Zone 5 temperature	210	°C	
	Zone 4 temperature	210	°C	
	Zone 3 temperature	215	°C	
	Zone 2 temperature	225	°C	
	Zone 1 temperature	230	°C	
	Jacket temperature	< 50	°C	
	Processing temperature	210 ~ 230	°C	
	Screw Design	L/D	> 26	-
		Compression ratio	2.5 ~ 3.0	-

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