

Product Texts

FXD153 is an Extrusion / Blow molding grade in a Diffusion effect, which is part of the VisualFX family. These effects have been developed to meet increasing Aesthetic demands in the Marketplace. Color Package may affect properties, Application testing always recommended.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	2.5	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Modulus	2340	MPa	ASTM D 638
Tensile Strength at Yield	62	MPa	ASTM D 638
Tensile Strength at Break	66	MPa	ASTM D 638
Elongation at Yield	7	%	ASTM D 638
Elongation at Break	110	%	ASTM D 638
Flexural Modulus	2340	MPa	ASTM D 790
Izod Impact notched, 1/8 in	748	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	3200	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
Coefficient of Thermal Expansion, MD	68	E-6/K	ASTM D 696
DTUL @ 66 psi	138	°C	ASTM D 648
DTUL @ 264 psi	132	°C	ASTM D 648
Vicat Temperature	157	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1200	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	320 - 345	°C	-
Mold temperature	80 - 115	°C	-
Zone 1	300 - 320	°C	-
Zone 2	310 - 330	°C	-
Zone 3	320 - 345	°C	-
Nozzle temperature	315 - 340	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-

Processing Recommendation Extrusion	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	265 - 280	°C	-
Mold temperature	60 - 100	°C	-
Zone 1	260 - 290	°C	-
Zone 2	260 - 290	°C	-
Zone 3	260 - 290	°C	-
Zone 4	260 - 290	°C	-
Zone 5	260 - 290	°C	-

Characteristics

Processing

Injection Molding, Other Extrusion, Blow Molding

Applications

Aircraft and Aerospace, Automotive, Electrical and Electronical

Features

Light Diffusing

Regional Availability

North America, South and Central America