

# RS650

## Description

RS650 is an ABS product for extrusion, designed to have high impact strength and stiffness.

## Key Features

High Impact Strength

## Application

General Extruded Sheet, Pipe, Bathroom Ceiling

Properties	Condition	Method	Unit	RS650
<b>Physical</b>				
Specific Gravity	23°C	ASTM D792		1.04
Mold Shrinkage	23°C, 3.2mm	ASTM D955	%	0.4 ~ 0.7
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	6
<b>Mechanical</b>				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	48
Tensile Elongation at Break	23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	10
Flexural Strength	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	79
Flexural Modulus	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	2500
Izod Impact Strength	Notched, 3.2mm, 23°C	ASTM D256	J/m	340
Izod Impact Strength	Notched, 3.2mm, -30°C	ASTM D256	J/m	150
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	J/m	320
Izod Impact Strength	Notched, 6.4mm, -30°C	ASTM D256	J/m	140
Rockwell Hardness	R-Scale	ASTM D785		108
<b>Thermal</b>				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	90
Vicat Softening Temperature	50N, 50°C/h	ASTM D1525	°C	98

## 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.