

098 338 0198

RANDOM

Technical Data Sheet

Issue date: May 2024 RANDOM production and trading company limited

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.10
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.8
Melt Flow Rate	230°C/2.16kg	ASTM D1238	g/10min	10
Water Absorption	23°C, 24hrs	ASTM D570	%	0.8
Mechanical				
Tensile Strength, 2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	
@ Break	50mm/min		kg/cm ²	190
Tensile Elongation, 2mm		ASTM D638		
@ Yield	50mm/min		%	
@ Break	50mm/min		%	700
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm ²	
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm ²	
Tear Strength @ Break	50mm/min	ASTM D624	kg/cm	
IZOD Impact Strength, 6.4mm (Notched)		ASTM D256		
	23°C		kg·cm/cm	No break
	-40°C		kg·cm/cm	No break
Shore Hardness	Shore D	ASTM D2240	-	
Shore Hardness	Shore A	ASTM D2240	-	80
Thermal				
Melt Temperature @ Peak		ASTM D3418	°C	165
Flame retardant	3.0mm	UL94		HB
Processing				
			Unit	Value
Injection Molding	Drying Temperature		°C	80 ~ 90
	Drying Time		hrs	1 ~ 2
	Maximum Moisture Content		%	0.08
	Melt Temperature		°C	170 ~ 210
		Rear	°C	170 ~ 190
	Cylinder Temperature	Middle	°C	180 ~ 200
		Front	°C	190 ~ 210
	Nozzle Temperature		°C	190 ~ 210
	Mold Temperature		°C	10 ~ 35
	Processing Parameters			
			Unit	Value
Extrusion Molding	Drying Temperature		°C	80 ~ 90
	Drying Time		hrs	3 ~ 4
	Maximum Moisture Content		%	0.06
	Melt Temperature		°C	170 ~ 210
		Zone 1	°C	170 ~ 190
	Barrel Temperature	Zone 2	°C	180 ~ 200

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Zone 3	°C	180 ~ 200
Zone 4	°C	180 ~ 200
Adapter Temperature	°C	180 ~ 200
Die Temperature	°C	180 ~ 200

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