

MAJORIS DE 271

Polypropylene

AD majoris

Message:

DE 271 is a 25% mineral filled, polypropylene compound, elastomer modified intended for injection moulding.

DE 271 is a material with excellent impact/stiffness ratio. The product is UV and heat stabilised.

The product is available in natural and black (DE 271 BLACK 8229) but other colours can be provided on request.

APPLICATION

Automotive parts:

Air ducts

Other injection moulded parts

General Information			
Filler / Reinforcement	Mineral filler, 25% filler by weight		
Additive	heat stabilizer		
	UV stabilizer		
Features	Rigidity, high		
	Impact resistance, high		
	Good UV resistance		
	Thermal Stability		
Uses	Application in Automobile Field		
Appearance	Black		
	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.06	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	5.0	g/10 min	ISO 1133
Molding Shrinkage	0.90	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C, Injection Molded)	20.0	MPa	ISO 527-2/50
Flexural Modulus ¹ (23°C, Injection Molded)	2200	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-20°C, injection molding	2.5	kJ/m ²	ISO 179/1eA
23°C, injection molding	5.0	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength			ISO 179/1eU
-20°C, injection molding	33	kJ/m ²	ISO 179/1eU
23°C, injection molding	100	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	112	°C	ISO 75-2/B
1.8 MPa, not annealed	60.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	143	°C	ISO 306/A
--	59.0	°C	ISO 306/B
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Additional Information			
Fogging, DIN 75201, 100°C/3h: 88%Fogging, DIN 75201, 100°C/16h: 0.4mgEmission, VDA 277: 27 µ gC/g			
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	3.0	hr	
Processing (Melt) Temp	230 - 260	°C	
Mold Temperature	30.0 - 50.0	°C	
Injection Rate	Slow-Moderate		
Injection instructions			
Hold-on Pressure: 50 - 70% of the injection pressureSpeed RPM: slow to medium			
NOTE			
1.	2.0 mm/min		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

