

INNOPOL® PP CS 1-3820 MA

Polypropylene Homopolymer

Inno-Comp Ltd.

Message:

INNOPOL® CS 1-3820 MA is a 20 % glass fibre filled polypropylene homopolymer compound. This grade is available in natural and custom coloured form.

INNOPOL® CS 1-3820 MA is recommended for producing injection molded products, where the required properties are high strength and stiffness besides long term heat stability and excellent processability.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Features	Rigidity, high		
	High strength		
	Homopolymer		
	Good processing stability		
	Good heat aging resistance		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Resin ID (ISO 1043)	PPH-GF20		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.03	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	16	g/10 min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.81	%	ISO 294-4
Flow direction	0.50	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4000	MPa	ISO 527-2/1
Tensile Stress (Yield)	63.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	3.5	%	ISO 527-2/50
Nominal Tensile Strain at Break	5.0	%	ISO 527-2
Flexural Modulus ¹	3450	MPa	ISO 178
Flexural Stress ²	92.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-20°C	5.0	kJ/m ²	ISO 179/1eA
23°C	6.3	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength			ISO 179/1eU
-20°C	25	kJ/m ²	ISO 179/1eU
23°C	39	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	155	°C	ISO 75-2/B
1.8 MPa, not annealed	133	°C	ISO 75-2/A
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	0.070	%	
Rear Temperature	190 - 230	°C	
Middle Temperature	190 - 230	°C	
Front Temperature	190 - 230	°C	
Processing (Melt) Temp	210 - 250	°C	
Mold Temperature	10.0 - 50.0	°C	
Injection Rate	Moderate		
Injection instructions			
Hold pressure: 50 to 100 % of actual injection pressure			
NOTE			
1.	2.0 mm/min		
2.	Type 1A		

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