

RheTech Polypropylene FRP300-01

Polypropylene Copolymer

RheTech, Inc.

Message:

20% Talc Reinforced, Flame Retardant, Polypropylene Copolymer, Black.

General Information			
Filler / Reinforcement	Talc filler, 20% filler by weight		
Features	Copolymer		
	Flame retardancy		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.16	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	22	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	70		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	26.2	MPa	ASTM D638
Flexural Modulus	2210	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	27	J/m	ASTM D256
Dart Drop Impact	2.37	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	104	°C	ASTM D648
1.8 MPa, not annealed	65.6	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	51.7 - 65.6	°C	
Drying Time	1.0 - 2.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	191 - 199	°C	
Middle Temperature	199 - 210	°C	
Front Temperature	199 - 210	°C	
Nozzle Temperature	204	°C	
Mold Temperature	23.9 - 35.0	°C	
Injection Pressure	2.76 - 8.27	MPa	
Injection Rate	Slow		

Holding Pressure	2.07 - 6.89	MPa
Back Pressure	0.345 - 0.689	MPa
Screw Speed	50 - 100	rpm

Injection instructions

Injection Speed: Slow, 0.5 to 1.0 in/minScrew RPM: Slow to Moderate, 50 to 100 RPM; Note: Purge the machine with polypropylene or polyethylene prior to shut down or change over.Cycle Time: Variable; Note: Do not leave material in the barrel for extended periods of down time. The flame retardant is temperature sensitive and will degrade when exposed to elevated temperatures for extended periods. Noxious gasses may be evolved.

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