Sindustris PP LW4406

Polypropylene

Sincerity Australia Pty Ltd.

Message:

Sindustris PP LW4406 is a Polypropylene material filled with 40% glass\mineral. It is available in Asia Pacific for injection molding. Primary attribute of Sindustris PP LW4406: Warp Resistant. Typical applications include: Automotive Electrical/Electronic Applications

| Filler / Reinforcement Glassi Mineral.40% Filler by Weight Features Low Warpage Uses Automotive Applications Electrical/Electronic Applications ULF le Number E306922 Processing Method Injection Molding Physical Nominal Value Unit Specific Gravity 120 g/cm ³ Meld Mass-Flow Rate (MF) (230°C/2.16 (%) J g/10 min Kg) 3.0 g/10 min ASTM D792 Melding Shrinkage - Flow (3.20 mm) 0.20 to 0.40 % ASTM D793 Melding Shrinkage - Flow (3.20 mm) 85.3 MPa ASTM D638 Tensile Strengh ¹ (Yrield, 3.20 mm) 85.3 MPa ASTM D638 Tensile Isongston ² (Reak, 3.20 mm) 700 MPa ASTM D638 Flexural Modulus ³ (6.40 mm) 7060 MPa ASTM D638 Tensile Isongston ² (Serak, 3.20 mm) 8.3 MPa ASTM D638 Flexural Modulus ³ (6.40 mm) 7060 MPa ASTM D790 Nominal Value Unit Test Method Noticed Log Impact (23°C, 6.40 mm) 83 Moltina (23°C) ASTM D648 Themal Nominal Value Unit Test Method Deffection Temperature (Mort (33°C) Nominal Valu | General Information | | | |
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| UseAutomotive Applications Electrical/Electronic ApplicationsUL Fle NumberElectrical/Electronic ApplicationsProcessing MethodInfection MoldingProcessing MethodNorinal ValueUnitPhysicalRominal ValueUnitSpecific Gravity1.0org of mainMeth Mass-Flow Rate (MFR) (2307/216)3.0g/10 minMolding Shrinkage - Flow (23.0 mm)0.20 to 0.40% 0MethanicalNorinal ValueUnitTensile Strengh ¹ (vield, 3.20 mm)8.5.3MPaMethanicalSoft Org Of MarkonASTM D538Tensile Strengh ¹ (vield, 3.20 mm)8.5.3MPaPlexural Strengh ⁴ (640 mm)706MPaPlexural Strengh ⁴ (640 mm)107Notchel Coll Inpact (25°C 640 mm)8.3JmaNotchel Coll Inpact (25°C 640 mm)8.3JmaMethod Internet (25°C 640 mm)15rcMethod Inpact (25°C 640 mm)10Norinal ValueMethod Inpact (25°C 640 mm)10Norinal ValueMethod Inpact (25°C 640 mm)10rcMethod Inpact (25°C 640 mm)10rcMethod Inpact (25°C 640 mm)10rcMethod Inpact (25°C 640 mm) <t< td=""><td>Filler / Reinforcement</td><td>Glass\Mineral,40% Filler by Weigh</td><td>t</td><td></td></t<> | Filler / Reinforcement | Glass\Mineral,40% Filler by Weigh | t | |
| ULFIENUMEYFactoral ColspaceProcessing MethodIncontonPhysicalNomina ValueIntPhysicalNomina ValueIntSpecific Gravity120gon ³ ASM D792Mgls Sprinkarge Mitholic Specific Gravity120gon ³ ASM D792Mgls Sprinkarge Mitholic Specific Gravity2010 0.00%100000Start D792Mgls Sprinkarge Triange Mitholic Specific Gravity2010 0.00%100000Start D793Mgls Sprinkarge Triange Mitholic Specific Gravity0210 0.00%100000Start D793MechanicalNominal ValueManoASM D693Metholic Specific Gravity630M200000Start D793Factard Modular ³ (Adom)127M2010000000M20100000000000000000000000000000000000 | Features | Low Warpage | | |
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| Processing MethodInjection MoldingPhysicalNominal ValueUnitTest MethodSpecific Gravity1.02g/cm³ASTM D792Melt Mass-Flow Rate (MFR) (230°C/2.163.0g/10 minASTM D792Molding Shrinkage - Flow (3.20 mm)0.20 to 0.40% 0.4ASTM D955MechanicalNominal ValueUnitTest MethodTensile Strength ¹ (Yield, 3.20 mm)85.3MPaASTM D638Tensile Strength ¹ (Yield, 3.20 mm)706MPaASTM D638Flexural Modulus ³ (6.40 mm)102MPaASTM D790Flexural Strength ⁴ (6.40 mm)127MPaASTM D790InpactNominal ValueUnitTest MethodNothed Izod Impact (23°C, 640 mm)83J/mASTM D256ThematNominal ValueUnitTest MethodDeflection Temperature Under Load (18 MPa, Unannealed, 3.20 mm)15CASTM D648May Unannealed, 3.20 mm)15CASTM D648Injection Temperature Under Load (18 MPa, Unannealed, 3.20 mm)Nominal ValueUnitDrig Temperature0.10 to 8.0CCDrig Temperature0.10 to 8.0CCStruggested Max Moisture1010 to 2.0CCMing Temperature100 to 2.00CCMing Temperature100 to 2.00CCMing Temperature100 to 2.00CCMing Temperature100 to 2.00CCMing Temperature100 to 2.00 <t< td=""><td></td><td></td><td></td><td></td></t<> | | | | |
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| Specific Gravity120g/cm³ASTM D792Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)3.0g/10 minASTM D1238Molding Shrinkage - Flow (3.20 mm)0.20 to 0.40%ASTM D955MechanicalNominal ValueUnitTest MethodTensile Strength ¹ (Yield, 3.20 mm)85.3MPaASTM D638Tensile Elongation ² (Break, 3.20 mm)<10 | Processing Method | Injection Molding | | |
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| Molding Shrinkage - Flow (3.20 mm)0.20 to 0.40%ASTM D955MechanicalNominal ValueUnitTest MethodTensile Strength ¹ (Yield, 3.20 mm)85.3MPaASTM D638Tensile Elongation ² (Break, 3.20 mm)<10 | | | | |
| MechanicalNominal ValueUnitTest MethodTensile Strength ¹ (Yield, 3.20 mm)85.3MPaASTM D638Tensile Elongation ² (Break, 3.20 mm)<10 | - | | - | |
| Tensile Strength ¹ (Yield, 3.20 mm)85.3MPaASTM D638Tensile Elongation ² (Break, 3.20 mm)< 10 | Molding Shrinkage - Flow (3.20 mm) | 0.20 to 0.40 | % | ASTM D955 |
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| Flexural Strength ⁴ (6.40 mm)127MPaASTM D790ImpactNominal ValueUnitTest MethodNotched Izod Impact (23°C, 6.40 mm)83J/mASTM D256ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (1.8) MPa, Unannealed, 3.20 mm)155°cASTM D648InjectionNominal ValueUnitUnitDrying TemperatureNoto 80.0°cCDrying Temperature3.0 to 4.0NrUnitSuggested Max Moisture0.010%CNiddle Temperature20 to 230°cCFront Temperature20 to 230°cCNotale Temperature20 to 230°c | Tensile Elongation ² (Break, 3.20 mm) | < 10 | % | ASTM D638 |
| ImpactNominal ValueUnitTest MethodNotched Izod Impact (23°C, 6.40 mm)83//mASTM D256ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)155°CASTM D648InjectionNominal ValueUnitUnitDrying TemperatureNominal ValueUnitUnitDrying Temperature7.0 to 80.0°CCDrying Time3.0 to 4.0hrCSuggested Max Moisture0.010%CRear Temperature190 to 210°CCMiddle Temperature200 to 230°CCFront Temperature200 to 230°CCNozze Temperature210 to 230°CCNozze Temperature210 to 230°CCNozze Temperature210 to 230°CNozze Temperature210 to 230°C <td>Flexural Modulus ³ (6.40 mm)</td> <td>7060</td> <td>MPa</td> <td>ASTM D790</td> | Flexural Modulus ³ (6.40 mm) | 7060 | MPa | ASTM D790 |
| Notched Izod Impact (23°C, 6.40 mm)83//mASTM D256ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)155°CASTM D648InjectionNominal ValueUnitDrying Temperature70.0 to 80.0°CDrying Time3.0 to 4.0hrSuggested Max Moisture0.010%Rear Temperature190 to 210°CMiddle Temperature200 to 230°CFront Temperature200 to 230°CNozzle Temperature210 to 230°C | Flexural Strength ⁴ (6.40 mm) | 127 | MPa | ASTM D790 |
| ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)155°CASTM D648InjectionNominal ValueUnitCDrying Temperature70.0 to 80.0°CCDrying Time3.0 to 4.0hrCSuggested Max Moisture0.010%CRear Temperature190 to 210°CCMiddle Temperature200 to 230°CCFront Temperature200 to 230°CCNozzle Temperature210 to 230°CC | Impact | Nominal Value | Unit | Test Method |
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| MPa, Unannealed, 3.20 mm)155°CASTM D648InjectionNominal ValueUnitDrying Temperature70.0 to 80.0°CDrying Time3.0 to 4.0hrSuggested Max Moisture0.010%Rear Temperature190 to 210°CMiddle Temperature200 to 230°CFront Temperature200 to 230°CNozzle Temperature210 to 230°C | Thermal | Nominal Value | Unit | Test Method |
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| Drying Time3.0 to 4.0hrSuggested Max Moisture0.010%Rear Temperature190 to 210°CMiddle Temperature200 to 230°CFront Temperature200 to 230°CNozzle Temperature210 to 230°C | Injection | Nominal Value | Unit | |
| Suggested Max Moisture0.010%Rear Temperature190 to 210°CMiddle Temperature200 to 230°CFront Temperature200 to 230°CNozzle Temperature210 to 230°C | Drying Temperature | 70.0 to 80.0 | °C | |
| Rear Temperature190 to 210°CMiddle Temperature200 to 230°CFront Temperature200 to 230°CNozzle Temperature210 to 230°C | Drying Time | 3.0 to 4.0 | hr | |
| Middle Temperature200 to 230°CFront Temperature200 to 230°CNozzle Temperature210 to 230°C | Suggested Max Moisture | 0.010 | % | |
| Front Temperature200 to 230°CNozzle Temperature210 to 230°C | Rear Temperature | 190 to 210 | °C | |
| Nozzle Temperature 210 to 230 °C | Middle Temperature | 200 to 230 | °C | |
| | Front Temperature | 200 to 230 | °C | |
| Processing (Melt) Temp 200 to 230 °C | Nozzle Temperature | 210 to 230 | °C | |
| | Processing (Melt) Temp | 200 to 230 | °C | |

| Mold Temperature | 40.0 to 60.0 | °C |
|------------------|--------------------------|-----|
| Back Pressure | 29.4 to 58.8 | MPa |
| Screw Speed | 30 to 60 | rpm |
| NOTE | | |
| | | |
| 1. | 5.0 mm/min | |
| 1. 2. | 5.0 mm/min 5.0 mm/min | |
| 1. 2. 3. | | |

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