

RheTech Polypropylene HP531-680UV

Polypropylene Copolymer

RheTech, Inc.

Message:

22% Talc Reinforced, High Performance, Medium Scrath Resistant, UV Stabilized, Polypropylene Copolymer, BJAA Light Parchment.

General Information			
Filler / Reinforcement	Talc filler, 22% filler by weight		
Additive	UV stabilizer		
Features	Copolymer		
	Good UV resistance		
	Scratch resistance		
Appearance	White-like		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	23	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	71		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	26.0	MPa	ASTM D638
Flexural Modulus	2140	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	43	J/m	ASTM D256
Dart Drop Impact	6.78	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	112	°C	ASTM D648
1.8 MPa, not annealed	67.8	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	65.6 - 82.2	°C	
Drying Time	1.0 - 2.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	199 - 227	°C	
Middle Temperature	204 - 232	°C	
Front Temperature	210 - 238	°C	
Nozzle Temperature	216 - 227	°C	
Mold Temperature	26.7 - 48.9	°C	

Injection Pressure	2.76 - 10.3	MPa
Holding Pressure	2.07 - 8.27	MPa
Back Pressure	0.345 - 1.03	MPa

Injection instructions

Injection Speed: Variable -- Application DependantScrew RPM: Recovery 3 seconds before mold opensCycle Time: Wall Thickness Dependant

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