

Ravago Compounds GFP-4413

Polypropylene

Ravago Manufacturing Americas, LLC

Message:

GFP-4413 is 30% glass fiber reinforced, chemically coupled, polypropylene homopolymer. GFP-4413 is designed for injection molding applications requiring superior stiffness and good dimensional stability.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Good dimensional stability		
	Rigidity, high		
	Chemical coupling		
	Homopolymer		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.20 - 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (23°C)	82.7	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	3.5	%	ASTM D638
Flexural Modulus - Tangent (23°C)	5850	MPa	ASTM D790
Flexural Strength (23°C)	134	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Unnotched Izod Impact (23°C)	470	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	157	°C	ASTM D648
1.8 MPa, not annealed	152	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	71.1 - 87.8	°C	
Rear Temperature	193 - 204	°C	
Middle Temperature	204 - 232	°C	
Front Temperature	204 - 232	°C	
Nozzle Temperature	193 - 221	°C	
Mold Temperature	46.1 - 60.0	°C	
Injection Rate	Slow-Moderate		

Back Pressure	0.00 - 0.689	MPa
Screw Speed	100 - 150	rpm
Injection instructions		

Drying: Not usually needed

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