

Generic PP, Unspecified - Calcium Carbonate

Polypropylene

Generic

Message:

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This information is provided for comparative purposes only.

General Information			
Filler / Reinforcement		Calcium carbonate filler	
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	0.953 - 1.27	g/cm ³	ASTM D792
23°C	0.980 - 1.36	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	7.5 - 27	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow: 23°C	1.0 - 1.6	%	ASTM D955
Transverse flow: 23°C	1.7 - 1.9	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (23°C)	85 - 99		ASTM D785
Durometer Hardness (23°C)	66 - 75		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	1720 - 3100	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield, 23°C	15.2 - 30.5	MPa	ASTM D638
23°C	20.8 - 26.6	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield, 23°C	9.8 - 10	%	ASTM D638
Fracture, 23°C	3.0 - 200	%	ASTM D638
Flexural Modulus (23°C)	1140 - 2840	MPa	ASTM D790
Flexural Strength			ASTM D790
23°C	26.4 - 51.7	MPa	ASTM D790
Yield, 23°C	29.8 - 48.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	25 - 99	J/m	ASTM D256
Unnotched Izod Impact (23°C)	520 - 1600	J/m	ASTM D256
Dart Drop Impact (23°C)	1.87 - 29.0	J	ASTM D3029
Dart Drop Impact (23°C)	2.26 - 32.8	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	84.0 - 122	°C	ASTM D648

1.8 MPa, not annealed	50.2 - 68.5	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	79.3 - 94.1	°C	
Drying Time	1.5 - 3.0	hr	
Rear Temperature	202 - 211	°C	
Middle Temperature	207 - 208	°C	
Front Temperature	210 - 213	°C	
Nozzle Temperature	215 - 218	°C	
Processing (Melt) Temp	209 - 241	°C	
Mold Temperature	37.2 - 53.1	°C	
Injection Pressure	6.55 - 86.5	MPa	
Holding Pressure	5.17 - 7.20	MPa	
Back Pressure	0.241 - 0.694	MPa	
Injection instructions			

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