

Retpol® PDR 1619/4 HS

Polypropylene Homopolymer

PolyPacific Pty. Ltd.

Message:

Corton PDR 1619/4 HS is a 11% barium sulphate filled homopolymer polypropylene compound. It is a high flow injection moulding grade developed for high gloss appliance applications requiring improved rigidity and greater dimensional stability than provided by unfilled grades. It has been stabilized for continuous use at elevated temperature.

General Information			
Filler / Reinforcement	Barium Sulfate, 11% Filler by Weight		
Features	Good Dimensional Stability		
	High Flow		
	High Gloss		
	Homopolymer		
Uses	Appliances		
	Housings		
Forms	Granules		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.988	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	28	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	1.4 to 1.6	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 3.00 mm)	100		ASTM D785
Durometer Hardness			ASTM D2240
Shore D, 3.00 mm	77		
Shore D, 15 sec, 3.00 mm	68		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.00 mm)	33.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.00 mm)	88	%	ASTM D638
Flexural Modulus (3.00 mm)	1740	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.00 mm)	25	J/m	ASTM D256
Unnotched Izod Impact (3.00 mm)	570	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.00 mm	116	°C	
1.8 MPa, Unannealed, 3.00 mm	55.0	°C	

CLTE - Flow (-30 to 30°C, 3.00 mm)	9.0E-5	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Regrind	10	%	
Processing (Melt) Temp	200 to 260	°C	
Mold Temperature	20.0 to 60.0	°C	
Injection Rate	Moderate-Fast		
NOTE			
1.	50 mm/min		
2.	50 mm/min		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

