

Generic TPO - Mineral

Compounded Polypropylene

Generic

Message:

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This information is provided for comparative purposes only.

General Information			
Filler / Reinforcement	Mineral filler		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	0.982 - 1.13	g/cm ³	ASTM D792
23°C	0.955 - 1.12	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
230°C/2.16 kg	3.0 - 10	g/10 min	ASTM D1238
230°C/2.16 kg	9.4 - 30	g/10 min	ISO 1133
Molding Shrinkage			
Flow: 23°C	0.82 - 1.5	%	ASTM D955
23°C	0.55 - 1.2	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (23°C)	60 - 66		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield, 23°C	16.5 - 30.7	MPa	ASTM D638
Yield, 23°C	15.9 - 22.2	MPa	ISO 527-2
Fracture, 23°C	12.0 - 20.0	MPa	ISO 527-2
Tensile Elongation			
Fracture, 23°C	5.0 - 100	%	ASTM D638
Fracture, 23°C	20 - 500	%	ISO 527-2
Flexural Modulus			
23°C	1220 - 3450	MPa	ASTM D790
23°C	1.80 - 1710	MPa	ISO 178
Flexural Strength (Yield, 23°C)	15.7 - 46.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0 - 50	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	25 - 490	J/m	ASTM D256
23°C	7.0 - 54	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

0.45 MPa, not annealed	115 - 137	°C	ASTM D648
0.45 MPa, not annealed	89.6 - 111	°C	ISO 75-2/B
Vicat Softening Temperature	53.6 - 137	°C	ISO 306
CLTE - Flow	4.0E-5 - 9.0E-4	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	75.0 - 75.1	°C	
Drying Time	3.4 - 3.5	hr	
Rear Temperature	200	°C	
Middle Temperature	215	°C	
Front Temperature	215	°C	
Nozzle Temperature	220	°C	
Processing (Melt) Temp	215 - 216	°C	
Mold Temperature	49.6 - 50.0	°C	
Back Pressure	43.0 - 44.1	MPa	
Injection instructions			

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