

RheTech Polypropylene T10P250-01

Polypropylene Copolymer

RheTech, Inc.

Message:

10% Talc Reinforced Polypropylene Copolymer, General Purpose Black

General Information			
Filler / Reinforcement	Talc filler, 10% filler by weight		
Features	Copolymer		
	General		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.978	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	6.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	70		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	26.9	MPa	ASTM D638
Flexural Modulus	1520	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	75	J/m	ASTM D256
Dart Drop Impact	10.2	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	104	°C	ASTM D648
1.8 MPa, not annealed	60.0	°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	193 - 221	°C	
Middle Temperature	199 - 227	°C	
Front Temperature	204 - 232	°C	
Nozzle Temperature	210 - 221	°C	
Mold Temperature	26.7 - 48.9	°C	
Injection Pressure	55.2 - 103	MPa	
Holding Pressure	2.76 - 5.17	MPa	

Back Pressure	0.345 - 1.03	MPa
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Injection instructions

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

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