

RheTech Polypropylene GC20P104-08

Polypropylene

RheTech, Inc.

Message:

20% Glass Fiber Reinforced, Chemically Coupled, Polypropylene, Black, FDA Compliant

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Features	Chemical coupling		
Agency Ratings	FDA not rated		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	75		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	75.8	MPa	ASTM D638
Flexural Modulus	4140	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	80	J/m	ASTM D256
Dart Drop Impact	0.565	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	160	°C	ASTM D648
1.8 MPa, not annealed	143	°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	199 - 227	°C	
Middle Temperature	204 - 232	°C	
Front Temperature	210 - 238	°C	
Nozzle Temperature	216 - 227	°C	
Mold Temperature	26.7 - 48.9	°C	
Injection Pressure	2.76 - 10.3	MPa	
Holding Pressure	2.07 - 8.27	MPa	
Back Pressure	0.345 - 1.03	MPa	

Injection instructions

Injection Speed: Variable - application dependent Screw RPM: Recovery 3 seconds before mold opens Cycle Time: Variable - wall thickness dependent

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Recommended distributors for this material

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