

# RheTech Polypropylene F22-01

Polypropylene

RheTech, Inc.

Message:

20% Glass Fiber / Mineral Co-Reinforced, Polypropylene, Black.

| General Information                       |                                      |                   |             |
|-------------------------------------------|--------------------------------------|-------------------|-------------|
| Filler / Reinforcement                    | Glass \mineral, 20% filler by weight |                   |             |
| Appearance                                | Black                                |                   |             |
| Processing Method                         | Injection molding                    |                   |             |
| Physical                                  | Nominal Value                        | Unit              | Test Method |
| Specific Gravity                          | 1.06                                 | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 18                                   | g/10 min          | ASTM D1238  |
| Hardness                                  | Nominal Value                        | Unit              | Test Method |
| Durometer Hardness (Shore D)              | 74                                   |                   | ASTM D2240  |
| Mechanical                                | Nominal Value                        | Unit              | Test Method |
| Tensile Strength                          | 37.2                                 | MPa               | ASTM D638   |
| Flexural Modulus                          | 3100                                 | MPa               | ASTM D790   |
| Impact                                    | Nominal Value                        | Unit              | Test Method |
| Notched Izod Impact                       | 27                                   | J/m               | ASTM D256   |
| Dart Drop Impact                          | 0.339                                | J                 | ASTM D5420  |
| Thermal                                   | Nominal Value                        | Unit              | Test Method |
| Deflection Temperature Under Load         |                                      |                   | ASTM D648   |
| 0.45 MPa, not annealed                    | 143                                  | °C                | ASTM D648   |
| 1.8 MPa, not annealed                     | 96.1                                 | °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 DependantScrew RPM: Recovery 3 seconds before mold opensCycle Time: Wall Thickness Dependant

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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

