Formolene® 6535N

Polypropylene Impact Copolymer

Formosa Plastics Corporation, U.S.A.

Message:

Impact Copolymer Designed to Meet the Requirement of Automotive Interior Trim

Formolene © 6535N is a specially formulated, high impact copolymer of polypropylene designed for interior trim applications such as those described by Ford Motor Company's Specifications WSS-M4D638-A and WSS-M4D638-B. Formolene © 6535N is suitable for many injection molding applications requiring toughness such as bins, crates, outdoor tools, machinery and toys. Material has been approved under GM-PP-033 and DCX MSB-500 for interior trim.

General Information			
Features	Good Impact Resistance		
	Good Stiffness		
	Impact Copolymer		
Uses	Automotive Interior Parts		
	Automotive Interior Trim		
	Crates		
	Industrial Applications		
	White Goods & Small Appliances		
Agency Ratings	EC 1907/2006 (REACH)		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	0.900	g/cm³	ISO 1183, ASTM D1505
Melt Mass-Flow Rate (MFR) (230°C/2.16			
kg)	35	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ISO 2577
Across Flow : 80°C, 48 hr	1.6	%	
Flow : 80°C, 48 hr	1.6	%	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			
Shore D, Injection Molded	63		ASTM D2240
	63		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, Injection Molded)	23.4	MPa	ASTM D638
Tensile Strain			
Yield	86	%	ISO 527-2/50
Break, Injection Molded ²	100	%	ASTM D638
Flexural Modulus			
1% Secant : Injection Molded ³	1070	MPa	ASTM D790
	1130	МРа	ISO 178

Films	Nominal Value	Unit	Test Method
Tensile Strength	23.4	MPa	ISO 527-3/50
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
-30°C, Injection Molded	64	J/m	ASTM D256
-18°C, Injection Molded	80	J/m	ASTM D256
23°C, Injection Molded	130	J/m	ASTM D256
-40°C	5.5	kJ/m²	ISO 180
-18°C	6.5	kJ/m²	ISO 180
23°C	14	kJ/m²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, Injection Molded	97.0	°C	ASTM D648
0.45 MPa, Unannealed	101	°C	ISO 75-2/B
1.8 MPa, Unannealed, Injection Molded	52.0	°C	ASTM D648
1.8 MPa, Unannealed	53.0	°C	ISO 75-2/A
CLTE - Flow	1.2E-4	cm/cm/°C	ASTM D696
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	1.3 mm/min		

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