

RheTech Polypropylene T28P100-01EG

Polypropylene

RheTech, Inc.

Message:

28% Talc Reinforced Polypropylene, Black, Extrusion Grade.

General Information			
Filler / Reinforcement	Talc filler, 28% filler by weight		
Appearance	Black		
Processing Method	Extrusion Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	1.0	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	27.6	MPa	ASTM D638
Flexural Modulus	2690	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	43	J/m	ASTM D256
Dart Drop Impact	1.13	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	129	°C	ASTM D648
1.8 MPa, not annealed	79.4	°C	ASTM D648
Injection	Nominal Value	Unit	Test Method
Drying Temperature	65.6 - 82.2	°C	
Drying Time	1.0 - 2.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	204 - 232	°C	
Middle Temperature	210 - 238	°C	
Front Temperature	216 - 243	°C	
Nozzle Temperature	221 - 232	°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 Dependant
Screw RPM: Recovery 3 seconds before mold opens
Cycle Time: Wall Thickness Dependant

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Recommended distributors for this material

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