

PPR PPCO08

Polypropylene Copolymer
Premier Plastic Resins, Inc.

Message:
Polypropylene Copolymer 30 Melt 2 Izod Black

General Information			
Features	Copolymer		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.908	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	30	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.4	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	24.5	MPa	ASTM D638
Tensile Elongation (Break)	12	%	ASTM D638
Flexural Modulus - Tangent	1100	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	88.0	°C	ASTM D648
1.8 MPa, not annealed	54.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	38.0 - 71.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	193 - 232	°C	
Middle Temperature	188 - 227	°C	
Front Temperature	188 - 227	°C	
Nozzle Temperature	199 - 221	°C	
Processing (Melt) Temp	193 - 232	°C	
Mold Temperature	16.0 - 54.0	°C	
Injection Pressure	3.00 - 55.0	MPa	
Injection Rate	Moderate		
Holding Pressure	3.00 - 45.0	MPa	
Back Pressure	0.00	MPa	

Cushion	6.35 - 12.7	mm
Injection instructions		

Screw Speed: ModerateDecompression: 3.81 to 7.6 mm

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