

Retpol® 1085 HS 70104

Polypropylene Homopolymer

PolyPacific Pty. Ltd.

Message:

Corton 1085 HS 70104 is a 40% talc filled homopolymer polypropylene compound. It is a high flow injection moulding grade developed for rigid components and is stabilized to meet long term automotive heat ageing requirements.

General Information			
Filler / Reinforcement	Talc,40% Filler by Weight		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
	High Flow		
	Homopolymer		
Uses	Automotive Applications		
	Automotive Instrument Panel		
Forms	Granules		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	19	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.70 to 0.90	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 3.00 mm)	92		ASTM D785
Durometer Hardness			ASTM D2240
Shore D, 3.00 mm	79		
Shore D, 15 sec, 3.00 mm	71		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.00 mm)	28.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.00 mm)	9.0	%	ASTM D638
Flexural Modulus (3.00 mm)	3950	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.00 mm)	20	J/m	ASTM D256
Unnotched Izod Impact (3.00 mm)	210	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.00 mm	130	°C	
1.8 MPa, Unannealed, 3.00 mm	77.0	°C	
CLTE - Flow (-30 to 30°C, 3.00 mm)	6.0E-5	cm/cm/°C	ASTM D696

Injection	Nominal Value	Unit
Drying Temperature	100 to 120	°C
Drying Time	2.0 to 4.0	hr
Suggested Max Regrind	10	%
Processing (Melt) Temp	200 to 260	°C
Mold Temperature	20.0 to 60.0	°C
Injection Rate	Moderate-Fast	
NOTE		
1.	50 mm/min	
2.	50 mm/min	

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Recommended distributors for this material

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

