

Daicel PP PG4N1

Polypropylene
Daicel Polymer Ltd.

Message:
Daicel PP PG4N1 is a Polypropylene material filled with 20% glass fiber. It is available in Asia Pacific. Primary attribute of Daicel PP PG4N1: Flame Rated.

General Information			
UL YellowCard	E47773-570024		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	6.0	g/10 min	ISO 1133
Molding Shrinkage - Flow	0.50 to 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	70.0	MPa	ISO 527-2
Flexural Modulus	4200	MPa	ISO 178
Flexural Stress	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	10	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	160	°C	ISO 75-2/B
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 120	°C	
Drying Time	3.0 to 5.0	hr	
Rear Temperature	140 to 190	°C	
Middle Temperature	160 to 210	°C	
Front Temperature	180 to 230	°C	
Nozzle Temperature	180 to 230	°C	
Mold Temperature	40.0 to 60.0	°C	
Back Pressure	5.00 to 20.0	MPa	
Screw Speed	70 to 90	rpm	

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