

RheTech Polypropylene FRP300-00

Polypropylene Copolymer

RheTech, Inc.

Message:

20% Talc Reinforced, Flame Retardant, Polypropylene Copolymer, Natural.

| General Information | | | |
|---|-----------------------------------|-------------------|-------------|
| Filler / Reinforcement | Talc filler, 20% filler by weight | | |
| Features | Copolymer | | |
| | Flame retardancy | | |
| Appearance | Natural color | | |
| Processing Method | Injection molding | | |
| Physical | Nominal Value | Unit | Test Method |
| Specific Gravity | 1.13 | g/cm ³ | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 22 | g/10 min | ASTM D1238 |
| Hardness | Nominal Value | Unit | Test Method |
| Durometer Hardness (Shore D) | 70 | | ASTM D2240 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Strength | 26.2 | MPa | ASTM D638 |
| Flexural Modulus | 2210 | MPa | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact | 27 | J/m | ASTM D256 |
| Dart Drop Impact | 2.37 | J | ASTM D5420 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load | | | ASTM D648 |
| 0.45 MPa, not annealed | 104 | °C | ASTM D648 |
| 1.8 MPa, not annealed | 65.6 | °C | ASTM D648 |
| Injection | Nominal Value | Unit | |
| Drying Temperature | 51.7 - 65.6 | °C | |
| Drying Time | 1.0 - 2.0 | hr | |
| Suggested Max Moisture | 0.050 | % | |
| Rear Temperature | 191 - 199 | °C | |
| Middle Temperature | 199 - 210 | °C | |
| Front Temperature | 199 - 210 | °C | |
| Nozzle Temperature | 204 | °C | |
| Mold Temperature | 23.9 - 35.0 | °C | |
| Injection Pressure | 2.76 - 8.27 | MPa | |
| Injection Rate | Slow | | |

| | | |
|------------------|---------------|-----|
| Holding Pressure | 2.07 - 6.89 | MPa |
| Back Pressure | 0.345 - 0.689 | MPa |
| Screw Speed | 50 - 100 | rpm |

Injection instructions

Injection Speed: Slow, 0.5 to 1.0 in/minScrew RPM: Slow to Moderate, 50 to 100 RPM; Note: Purge the machine with polypropylene or polyethylene prior to shut down or change over.Cycle Time: Variable; Note: Do not leave material in the barrel for extended periods of down time. The flame retardant is temperature sensitive and will degrade when exposed to elevated temperatures for extended periods. Noxious gasses may be evolved.

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