

Retpol® C3 200 TF HS

Polypropylene Copolymer

PolyPacific Pty. Ltd.

Message:

Propak C3 200 TF HS is a 20% talc filled copolymer polypropylene compound. It is a low to medium flow injection moulding grade developed for rigid components and is manufactured in accordance with Australian Standard AS 2070, "Plastic Materials for Food Contact Use". The ingredients used in this formulation are referenced in the US Code of Federal Regulations, Volume 21.

General Information			
Filler / Reinforcement	Talc,20% Filler by Weight		
Features	Copolymer		
	Food Contact Acceptable		
	Low Flow		
Uses	Closures		
	Household Goods		
Agency Ratings	AS 2070-1999		
Forms	Granules		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	4.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	1.0 to 1.4	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 3.00 mm)	86		ASTM D785
Durometer Hardness			ASTM D2240
Shore D, 3.00 mm	73		
Shore D, 15 sec, 3.00 mm	65		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.00 mm)	25.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.00 mm)	50	%	ASTM D638
Flexural Modulus (3.00 mm)	2200	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.00 mm)	55	J/m	ASTM D256
Unnotched Izod Impact (3.00 mm)	900	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.00 mm	118	°C	
1.8 MPa, Unannealed, 3.00 mm	60.0	°C	

CLTE - Flow (-30 to 30°C, 3.00 mm)	8.0E-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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