

RheTech Polypropylene FRG220-773UV

Polypropylene Copolymer

RheTech, Inc.

Message:

20% Glass Fiber Reinforced, Chemically Coupled, Flame Retardant,UV Stabilized, Polypropylene Copolymer, Pantone Q716-1-5 Light Grey, UL94 V-1.

General Information			
UL YellowCard	E87919-454610		
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	UV stabilizer		
Features	Copolymer		
	Chemical coupling		
	Good UV resistance		
	Flame retardancy		
Appearance	Light gray		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	6.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	75		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	55.8	MPa	ASTM D638
Flexural Modulus	4480	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	96	J/m	ASTM D256
Dart Drop Impact	0.791	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	156	°C	ASTM D648
1.8 MPa, not annealed	139	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating	V-1		UL 94
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 - 210	°C
Mold Temperature	23.9 - 37.8	°C
Injection Pressure	2.76 - 8.27	MPa
Injection Rate	Slow-Moderate	
Holding Pressure	2.07 - 6.89	MPa
Back Pressure	0.345 - 0.689	MPa
Screw Speed	25 - 75	rpm

Injection instructions

Injection Speed: Slow to Moderate, 0.5 to 1.0 in/minScrew RPM: Screw recovery 3 seconds before mold opens; 25-75 rpmCycle Time: Variable - wall thickness dependent

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Recommended distributors for this material

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