

# FERREX® GPP30CN33HB-NA

Polypropylene

Ferro Corporation

## Message:

FERREX® GPP30CN33HB-NA is a Polypropylene material filled with 30% calcium carbonate. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America for injection molding. Primary attribute of FERREX® GPP30CN33HB-NA: High Gloss.

| General Information                       |                                        |                   |             |
|-------------------------------------------|----------------------------------------|-------------------|-------------|
| Filler / Reinforcement                    | Calcium Carbonate,30% Filler by Weight |                   |             |
| Features                                  | High Gloss                             |                   |             |
| Appearance                                | Natural Color                          |                   |             |
| Forms                                     | Pellets                                |                   |             |
| Processing Method                         | Injection Molding                      |                   |             |
| Physical                                  | Nominal Value                          | Unit              | Test Method |
| Specific Gravity                          | 1.13                                   | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 25                                     | g/10 min          | ASTM D1238  |
| Molding Shrinkage - Flow                  | 1.2                                    | %                 | ASTM D955   |
| Hardness                                  | Nominal Value                          | Unit              | Test Method |
| Durometer Hardness (Shore D)              | 70                                     |                   | ASTM D2240  |
| Mechanical                                | Nominal Value                          | Unit              | Test Method |
| Tensile Strength (Yield)                  | 22.1                                   | MPa               | ASTM D638   |
| Tensile Elongation (Break)                | 85                                     | %                 | ASTM D638   |
| Flexural Modulus                          | 1590                                   | MPa               | ASTM D790   |
| Flexural Strength (Yield)                 | 34.5                                   | MPa               | ASTM D790   |
| Impact                                    | Nominal Value                          | Unit              | Test Method |
| Notched Izod Impact (23°C)                | 59                                     | J/m               | ASTM D256   |
| Unnotched Izod Impact (23°C)              | 800                                    | J/m               | ASTM D256   |
| Gardner Impact                            | 26.0                                   | J                 | ASTM D3029  |
| Thermal                                   | Nominal Value                          | Unit              | Test Method |
| Deflection Temperature Under Load         |                                        |                   | ASTM D648   |
| 0.45 MPa, Unannealed                      | 104                                    | °C                |             |
| 1.8 MPa, Unannealed                       | 60.0                                   | °C                |             |
| Injection                                 | Nominal Value                          | Unit              |             |
| Drying Temperature                        | 93.3                                   | °C                |             |
| Drying Time                               | 2.0 to 3.0                             | hr                |             |
| Rear Temperature                          | 199 to 204                             | °C                |             |
| Middle Temperature                        | 204 to 210                             | °C                |             |
| Front Temperature                         | 210 to 216                             | °C                |             |
| Nozzle Temperature                        | 216 to 221                             | °C                |             |
| Mold Temperature                          | 46.1 to 60.0                           | °C                |             |

|                         |                |                    |
|-------------------------|----------------|--------------------|
| Back Pressure           | 0.138 to 0.345 | MPa                |
| Screw Speed             | 100 to 150     | rpm                |
| Clamp Tonnage           | 2.8 to 4.1     | kN/cm <sup>2</sup> |
| Screw L/D Ratio         | 20.0:1.0       |                    |
| Screw Compression Ratio | 2.0:1.0        |                    |

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