

Safron® H504-12M

Polypropylene Homopolymer

Safrinol (PTY) LTD

Message:

Safron® H504-12M Polypropylene Resin is recommended for the spinning of staple fibre in the range 2 - 25 denier. It is also used for the manufacture of BCF yarns.

Safron® H504-12M Polypropylene Resin is a medium to high flow injection moulding grade for applications where rigidity and fast cycle times are essential.

General Information			
Features	Homopolymer		
	Fast molding cycle		
	Good liquidity		
	Compliance of Food Exposure		
	Medium hardness		
Uses	BCF line		
	Monochrome high toughness line		
	Floor maintenance/repair		
	staple fiber		
	Fiber		
Agency Ratings	FDA 21 CFR 177.1520(c) 1.1a		
	Europe 10/1/2011 12:00:00 AM		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.900	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	12	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, Injection Molded)	30.0	MPa	ISO 527-2
Tensile Strain (Yield, Injection Molded)	7.5	%	ISO 527-2
Flexural Modulus (Injection Molded)	1360	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C, Injection Molded)	2.3	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ¹			
0.45 MPa, not annealed	83.0	°C	ISO 75-2/B
1.8 MPa, not annealed	55.0	°C	ISO 75-2/A
Vicat Softening Temperature ²	85.0	°C	ISO 306/B

Injection	Nominal Value	Unit
Rear Temperature	180 - 200	°C
Middle Temperature	220 - 230	°C
Front Temperature	240 - 260	°C
Nozzle Temperature	240	°C

Injection instructions

Zone 4 Temperature: 250°C

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	180 - 240	°C
Cylinder Zone 2 Temp.	230 - 250	°C
Cylinder Zone 3 Temp.	240 - 270	°C
Cylinder Zone 4 Temp.	270	°C
Die Temperature	240 - 260	°C

NOTE

1. Injection Molded
2. Injection Molded

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