

Celstran® PP-GF60-0403 P10/10

Polypropylene

Celanese Corporation

Message:

Material code according to ISO 1043-1:PP

Polypropylene with 60 weight percent ash content, long glass fibers reinforced The fibers are chemically coupled to the polypropylene matrix. The pellets are cylindrical and normally as well as the embedded fibrs 10 mm long.

Parts molded of CELSTRAN have outstanding mechanical properties such as high strength and stiffness combined with high heat deflection. The notched impact strength is increased at elevated and low temperatures due to the fiber skeleton built in the parts. The long fiber reinforcement reduces creep significantly.

The very isotropic shrinkage in the molded parts minimizes the warpage.

Complex parts can be manufactured with high reproducibility by injection molding.

Application field: Functional/structural parts for automotive

General Information			
Filler / Reinforcement	Long glass fiber, 60% filler by weight		
Features	Rigidity, high		
	High strength		
	Chemical coupling		
	Impact resistance, high		
	Good creep resistance		
	Low temperature impact resistance		
Uses	Application in Automobile Field		
Forms	Particle		
Processing Method	Injection molding		
Resin ID (ISO 1043)	PP		
Physical	Nominal Value	Unit	Test Method
Density	1.47	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
--	14400	MPa	ISO 527-2/1A/1
80°C	9500	MPa	ISO 527-2/1A
Tensile Stress			
Fracture	149	MPa	ISO 527-2/1A/5
80°C	90.0	MPa	ISO 527-2/1A
Tensile Strain			
Fracture	1.6	%	ISO 527-2/1A/5
Fracture, 80°C	2.1	%	ISO 527-2/1A
Flexural Modulus			ISO 178
23°C	14400	MPa	ISO 178
80°C	9500	MPa	ISO 178
Flexural Stress			ISO 178

23°C	254	MPa	ISO 178
80°C	140	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	50	kJ/m ²	ISO 179/1eA
23°C	39	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	90	kJ/m ²	ISO 179/1eU
23°C	80	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	160	°C	ISO 75-2/A
Melting Temperature ¹	168	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	90.0 - 100	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	220 - 230	°C	
Middle Temperature	230 - 240	°C	
Front Temperature	240 - 250	°C	
Nozzle Temperature	240 - 250	°C	
Processing (Melt) Temp	230 - 270	°C	
Mold Temperature	30.0 - 70.0	°C	
Injection Pressure	60.0 - 120	MPa	
Injection Rate	Slow		
Holding Pressure	40.0 - 80.0	MPa	
Back Pressure	0.00 - 3.00	MPa	
Injection instructions			
Manifold Temperature: 230 to 270°CZone 4 Temperature: 250°CFeed Temperature: 20 to 50°C			
NOTE			
1.	10°C/min		

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