

# PPR PPCO02

Polypropylene Copolymer  
Premier Plastic Resins, Inc.

Message:

Polypropylene Copolymer 20% Glass Fiber Reinforced Natural

| General Information                       |                                                       |                   |             |
|-------------------------------------------|-------------------------------------------------------|-------------------|-------------|
| Filler / Reinforcement                    | Glass fiber reinforced material, 20% filler by weight |                   |             |
| Features                                  | Copolymer                                             |                   |             |
| Appearance                                | Natural color                                         |                   |             |
| Forms                                     | Particle                                              |                   |             |
| Processing Method                         | Injection molding                                     |                   |             |
| Physical                                  | Nominal Value                                         | Unit              | Test Method |
| Specific Gravity                          | 1.03                                                  | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 12                                                    | g/10 min          | ASTM D1238  |
| Molding Shrinkage - Flow                  | 0.60                                                  | %                 | ASTM D955   |
| Mechanical                                | Nominal Value                                         | Unit              | Test Method |
| Tensile Strength (Yield)                  | 62.1                                                  | MPa               | ASTM D638   |
| Tensile Elongation (Break)                | 5.0                                                   | %                 | ASTM D638   |
| Flexural Modulus - Tangent                | 3100                                                  | MPa               | ASTM D790   |
| Impact                                    | Nominal Value                                         | Unit              | Test Method |
| Notched Izod Impact                       | 70                                                    | J/m               | ASTM D256   |
| Thermal                                   | Nominal Value                                         | Unit              | Test Method |
| Deflection Temperature Under Load         |                                                       |                   | ASTM D648   |
| 0.45 MPa, not annealed                    | 168                                                   | °C                | ASTM D648   |
| 1.8 MPa, not annealed                     | 149                                                   | °C                | ASTM D648   |
| Injection                                 | Nominal Value                                         | Unit              |             |
| Drying Temperature                        | 38.0 - 71.0                                           | °C                |             |
| Drying Time                               | 2.0 - 4.0                                             | hr                |             |
| Suggested Max Moisture                    | 0.20                                                  | %                 |             |
| Rear Temperature                          | 210 - 238                                             | °C                |             |
| Middle Temperature                        | 210 - 238                                             | °C                |             |
| Front Temperature                         | 204 - 243                                             | °C                |             |
| Nozzle Temperature                        | 210 - 238                                             | °C                |             |
| Processing (Melt) Temp                    | 204 - 249                                             | °C                |             |
| Mold Temperature                          | 27.0 - 60.0                                           | °C                |             |
| Injection Pressure                        | 5.00 - 55.0                                           | MPa               |             |
| Injection Rate                            | Slow-Moderate                                         |                   |             |
| Holding Pressure                          | 3.00 - 45.0                                           | MPa               |             |

|                        |             |     |
|------------------------|-------------|-----|
| Back Pressure          | 0.00 - 1.00 | MPa |
| Cushion                | 6.35 - 12.7 | mm  |
| Injection instructions |             |     |

Screw Speed: Slow-ModerateDecompression: 3.81 to 7.6 mm

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