

EL-Pro™ P640J

Polypropylene Impact Copolymer

SCG Chemicals Co., Ltd.

Message:

EL-Pro P640J is an impact copolymer polypropylene resin suitable for injection molding process. This resin is recommended for product that requires high stiffness with good processibility.

General Information			
Features	Rigidity, high		
	Impact copolymer		
	Impact resistance, good		
	Workability, good		
	Compliance of Food Exposure		
Uses	Electrical components		
	Industrial application		
	Application in Automobile Field		
	Toys		
Agency Ratings	FDA 21 CFR 177.1520		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.910	g/cm ³	ASTM D1505
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow: 2.00mm	1.3	%	ASTM D955
Transverse flow: 2.00mm	1.1	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	70		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength - Across Flow ¹			ASTM D638
Yield	27.5	MPa	ASTM D638
Fracture	19.6	MPa	ASTM D638
Flexural Modulus	1180	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-20°C	39	J/m	ASTM D256
0°C	49	J/m	ASTM D256
23°C	98	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	105	°C	ASTM D648
1.8 MPa, not annealed	55.0	°C	ASTM D648
Brittleness Temperature	-20.0	°C	ASTM D746
Vicat Softening Temperature	150	°C	ASTM D1525
Melting Temperature	120 - 163	°C	ASTM D2117
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Processing (Melt) Temp	230 - 270	°C	
Mold Temperature	25.0 - 70.0	°C	
Injection Rate	Fast		
Screw Speed	40 - 70	rpm	
Injection instructions			
Injection Pressure: 40 to 80% of max. pressurePacking and Holding Pressure: 30 to 60% of max. pressureBack Pressure: 10% of max. pressure			
NOTE			
1.	50 mm/min		

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