

RheTech Polypropylene P249-01UV

Polypropylene Copolymer

RheTech, Inc.

Message:

UV Stabilized, Polypropylene Copolymer, General Purpose Black.

General Information			
Additive	UV stabilizer		
Features	Copolymer		
	Good UV resistance		
	General		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.918	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	67		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	22.1	MPa	ASTM D638
Flexural Modulus	1070	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	110	J/m	ASTM D256
Dart Drop Impact	16.9	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	90.6	°C	ASTM D648
1.8 MPa, not annealed	50.6	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	65.6 - 82.2	°C	
Drying Time	1.0 - 2.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	188 - 216	°C	
Middle Temperature	193 - 221	°C	
Front Temperature	199 - 227	°C	
Nozzle Temperature	204 - 216	°C	
Mold Temperature	26.7 - 48.9	°C	
Injection Pressure	2.76 - 10.3	MPa	

Holding Pressure	2.07 - 8.27	MPa
Back Pressure	0.345 - 1.03	MPa

Injection instructions

Injection Speed: Variable - Application DependantScrew RPM: Recover 3 seconds before mold opensCycle Time: Wall Thickness Dependant

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