

INNOPOL® PP CS 4-8000

Polypropylene Random Copolymer

Inno-Comp Ltd.

Message:

INNOPOL ® CS 4-8000 is a polypropylene random copolymer. This grade is available in nature and custom coloured form.

Recommended application

INNOPOL ® CS 4-8000 is highly suitable for pressure pipe manufacturing, including hot, drinking water systems and floor-heating application.

General Information			
Features	Random copolymer		
Uses	Piping system		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Pipeline extrusion molding		
	Injection molding		
Resin ID (ISO 1043)	PP-R		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	0.900	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.30	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	850	MPa	ISO 527-2/1
Tensile Stress (Yield)	25.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	12	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-20°C	2.5	kJ/m ²	ISO 179/1eA
23°C	20	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-20°C	70	kJ/m ²	ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	70.0	°C	ISO 75-2/B
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	0.050	%	

Rear Temperature	190 - 250	°C
Middle Temperature	190 - 250	°C
Front Temperature	190 - 250	°C
Processing (Melt) Temp	240 - 260	°C
Mold Temperature	15.0 - 50.0	°C
Injection Rate	Slow-Moderate	

Injection instructions

Hold pressure: 50 to 100 % of actual injection pressure

Extrusion	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	2.0	hr
Suggested Max Moisture	0.050	%
Cylinder Zone 1 Temp.	180 - 220	°C
Cylinder Zone 2 Temp.	180 - 220	°C
Cylinder Zone 3 Temp.	180 - 220	°C
Cylinder Zone 4 Temp.	180 - 220	°C
Cylinder Zone 5 Temp.	180 - 220	°C
Melt Temperature	200 - 220	°C
Die Temperature	200 - 220	°C

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