

SABIC® PPcompound 8611A resin

Polypropylene

SABIC Innovative Plastics

Message:

SABIC® PPcompound 8611A is a mineral filled, impact modified polypropylene TPO. It was originally designed for painted automotive bumper fascia applications where a combination of low density, good flow, high stiffness, and cold temperature ductility is required. The IMDS is 482236460.

General Information			
Filler / Reinforcement	Mineral		
Additive	Impact Modifier		
Features	Ductile		
	Good Flow		
	High Stiffness		
	Impact Modified		
	Low Density		
Uses	Automotive Applications		
	Automotive Bumper		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	0.968	g/cm ³	ASTM D792
--	0.960	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	34	g/10 min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow : 80°C, 1 hr	1.1	%	
Across Flow : 120°C, 30 min	1.1	%	
Across Flow : 23°C, 48 hr	0.95	%	
Flow : 80°C, 1 hr	0.60	%	
Flow : 120°C, 30 min	0.71	%	
Flow : 23°C, 48 hr	0.55	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1650	MPa	ISO 527-2/1
Tensile Stress			
Yield	19.0	MPa	ISO 527-2/50
Break	13.0	MPa	ISO 527-2/1A/50
Tensile Strain (Break)	100	%	ISO 527-2/50
Flexural Modulus ¹ (64.0 mm Span)	1760	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method

Charpy Notched Impact Strength			ISO 179/1eA
-30°C ²	6.0	kJ/m ²	
23°C ³	34	kJ/m ²	
Notched Izod Impact Strength ⁴			ISO 180/1A
0°C	30	kJ/m ²	
23°C	41	kJ/m ²	
Instrumented Dart Impact ⁵			ASTM D3763
-30°C, Energy at Peak Load	24.0	J	
23°C, Energy at Peak Load	22.0	J	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶			
0.45 MPa, Unannealed	100	°C	ISO 75-2/B
1.8 MPa, Unannealed	53.0	°C	ISO 75-2/A
Coefficient of Linear Thermal Expansion			ISO 11359-2
Flow : -30 to 100°C	49.0	µm/Mk	
Transverse : -30 to 100°C	127	µm/Mk	
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	
Drying Time	2.0 to 4.0	hr	
Rear Temperature	190 to 230	°C	
Middle Temperature	200 to 250	°C	
Front Temperature	210 to 270	°C	
Nozzle Temperature	210 to 270	°C	
Processing (Melt) Temp	210 to 270	°C	
Mold Temperature	15.0 to 60.0	°C	
Back Pressure	1.00 to 1.50	MPa	
NOTE			
1.	2.0 mm/min		
2.	80*10*4mm, Cut		
3.	80*10*4 mm, Cut		
4.	80*10*4mm, Cut		
5.	2.20 m/sec		
6.	80*10*4mm, Cut		

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