

FERREX® GPP20CF21HB-NA

Polypropylene

Ferro Corporation

Message:

FERREX® GPP20CF21HB-NA is a Polypropylene material filled with 22% calcium carbonate. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America for injection molding. Primary attribute of FERREX® GPP20CF21HB-NA: High Gloss.

General Information			
Filler / Reinforcement	Calcium Carbonate,22% Filler by Weight		
Features	High Gloss		
Appearance	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.4	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	74		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	31.0	MPa	ASTM D638
Tensile Elongation (Break)	45	%	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Flexural Strength (Yield)	48.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	43	J/m	ASTM D256
Unnotched Izod Impact (23°C)	1100	J/m	ASTM D256
Gardner Impact	7.34	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	116	°C	
1.8 MPa, Unannealed	60.6	°C	
Injection	Nominal Value	Unit	
Drying Temperature	93.3	°C	
Drying Time	2.0 to 3.0	hr	
Rear Temperature	199 to 204	°C	
Middle Temperature	204 to 210	°C	
Front Temperature	210 to 216	°C	
Nozzle Temperature	216 to 221	°C	
Mold Temperature	46.1 to 60.0	°C	

Back Pressure	0.138 to 0.345	MPa
Screw Speed	100 to 150	rpm
Clamp Tonnage	2.8 to 4.1	kN/cm ²
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.0:1.0	

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Recommended distributors for this material

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