

RheTech Polypropylene RCC233-01

Polypropylene Copolymer

RheTech, Inc.

Message:

33% Calcium Carbonate Reinforced, Recycled Content, Polypropylene Copolymer, Black.

General Information			
Filler / Reinforcement	Calcium carbonate filler, 33% filler by weight		
Recycled Content	Yes		
Features	Copolymer		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	15	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	66		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	15.9	MPa	ASTM D638
Flexural Modulus	1240	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	130	J/m	ASTM D256
Dart Drop Impact	18.2	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	85.0	°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	204 - 232	°C	
Middle Temperature	210 - 238	°C	
Front Temperature	216 - 243	°C	
Nozzle Temperature	221 - 232	°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: Recovery 3 seconds before mold opensCycle Time: Wall Thickness Dependant

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

