

Generic PP Copolymer - Mineral

Polypropylene Copolymer

Generic

Message:

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General Information			
Filler / Reinforcement	Mineral filler		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	0.960 - 2.10	g/cm ³	ASTM D792
23°C	0.975 - 1.17	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
230°C/2.16 kg	4.7 - 35	g/10 min	ASTM D1238
230°C/2.16 kg	0.70 - 28	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	4.65 - 18.3	cm ³ /10min	ISO 1133
Molding Shrinkage			
Flow: 23°C	0.10 - 1.2	%	ASTM D955
23°C	0.81 - 1.2	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.020 - 0.050	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
23°C	40 - 90		ASTM D785
23°C	70 - 76		ISO 2039-2
Durometer Hardness (23°C)	59 - 71		ISO 868
Ball Indentation Hardness	50.0 - 71.4	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	1000 - 3080	MPa	ASTM D638
23°C	1230 - 2620	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	10.0 - 30.7	MPa	ASTM D638
Yield, 23°C	17.0 - 27.5	MPa	ISO 527-2
Fracture, 23°C	17.0 - 45.0	MPa	ASTM D638
Fracture, 23°C	14.5 - 25.0	MPa	ISO 527-2
23°C	16.9 - 24.3	MPa	ASTM D638
23°C	19.9 - 30.0	MPa	ISO 527-2
Tensile Elongation			
Yield, 23°C	3.0 - 5.0	%	ASTM D638

Yield, 23°C	2.8 - 8.1	%	ISO 527-2
Fracture, 23°C	2.3 - 200	%	ASTM D638
Fracture, 23°C	2.5 - 100	%	ISO 527-2
Flexural Modulus			
23°C	800 - 3510	MPa	ASTM D790
23°C	1260 - 2520	MPa	ISO 178
Flexural Strength			
23°C	20.0 - 52.4	MPa	ASTM D790
23°C	19.9 - 50.5	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	2.3 - 25	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	39 - 96	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	30 - 250	J/m	ASTM D256
23°C	3.8 - 46	kJ/m ²	ISO 180
Unnotched Izod Impact Strength (23°C)	18 - 80	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	104 - 153	°C	ASTM D648
0.45 MPa, not annealed	72.0 - 126	°C	ISO 75-2/B
1.8 MPa, not annealed	55.0 - 70.8	°C	ASTM D648
1.8 MPa, not annealed	48.5 - 65.5	°C	ISO 75-2/A
Vicat Softening Temperature			
--	50.0 - 142	°C	ASTM D1525
--	47.9 - 152	°C	ISO 306
Melting Temperature (DSC)	165	°C	ISO 3146
CLTE - Flow			
--	5.0E-5 - 7.3E-5	cm/cm/°C	ASTM D696
--	4.6E-5 - 8.0E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	7.5E+13 - 1.0E+15	ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+13 - 1.0E+15	ohms · cm	IEC 60093
Comparative Tracking Index	595 - 600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Glow Wire Flammability Index	847 - 960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature	550 - 753	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	79.8 - 88.0	°C	
Drying Time	3.0	hr	
Rear Temperature	205 - 210	°C	
Middle Temperature	209 - 226	°C	
Front Temperature	209 - 236	°C	

Processing (Melt) Temp	210 - 245	°C
Mold Temperature	39.8 - 60.6	°C
Injection Pressure	87.3 - 100	MPa
Holding Pressure	52.5 - 52.9	MPa
Back Pressure	0.300 - 0.525	MPa
Screw Speed	50 - 75	rpm
Clamp Tonnage	4.5 - 4.6	kN/cm ²

Injection instructions

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