

RheTech Polypropylene T30P200-01BG

Polypropylene Copolymer

RheTech, Inc.

Message:

30% Talc Reinforced Polypropylene Copolymer, Black, Blow Molding Grade

General Information			
Filler / Reinforcement	Talc filler, 30% filler by weight		
Features	Copolymer		
Appearance	Black		
Processing Method	Blow molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.70	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	70		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	29.3	MPa	ASTM D638
Flexural Modulus	2550	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	96	J/m	ASTM D256
Dart Drop Impact	5.65	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	116	°C	ASTM D648
1.8 MPa, not annealed	65.6	°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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