

REPRO PP R410

Polypropylene
Rondo Plast AB

Message:
Injection moulding

General Information			
Filler / Reinforcement	Filler,2.0% Filler by Weight		
Recycled Content	Yes		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	0.930	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20	g/10 min	ISO 1133
Molding Shrinkage			ISO 2577
Across Flow	1.2 to 1.6	%	
Flow	1.2 to 1.6	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strain (Yield)	8.0	%	ISO 527-2
Flexural Modulus (23°C)	1100	MPa	ISO 178
Flexural Stress	40.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-20°C	4.0	kJ/m ²	
23°C	9.0	kJ/m ²	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Ignition Temperature (2.00 mm)	650	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 4.0	hr	
Processing (Melt) Temp	180 to 220	°C	
Mold Temperature	40.0 to 80.0	°C	
Injection Pressure	40.0 to 110	MPa	
Injection Rate	Fast		
Back Pressure	1.00 to 2.00	MPa	

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