

RheTech Polypropylene T12P600-430UVBG

Polypropylene Copolymer

RheTech, Inc.

Message:

12% Talc Reinforced, UV Stabilized, Polypropylene Copolymer, Interior 848 Black, Blow Molding Grade.

General Information			
Filler / Reinforcement	Talc filler, 12% filler by weight		
Additive	UV stabilizer		
Features	Copolymer		
	Good UV resistance		
Appearance	Black		
Processing Method	Blow molding		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.988	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.60	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	72		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	31.0	MPa	ASTM D638
Flexural Modulus	1930	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	100	J/m	ASTM D256
Dart Drop Impact	10.2	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	113	°C	ASTM D648
1.8 MPa, not annealed	60.0	°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	199 - 227	°C	
Middle Temperature	204 - 232	°C	
Front Temperature	210 - 238	°C	
Nozzle Temperature	216 - 227	°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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