

Retpol® 1236

Polypropylene Homopolymer

PolyPacific Pty. Ltd.

Message:

Propak 1236 is a 40% talc filled homopolymer polypropylene compound. It is a low flow extrusion grade developed for rigid thermoformed components, and is manufactured in accordance with Australian Standard AS 2070, "Plastic Materials for Food Contact Use". The ingredients used in this formulation are referenced in the US Code of Federal Regulations, Volume 21.

General Information	
Filler / Reinforcement	Talc,40% Filler by Weight
Features	Food Contact Acceptable
	Homopolymer
	Low Flow
Agency Ratings	AS 2070-1999
Forms	Granules
Processing Method	Extrusion
	Thermoforming

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	2.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.60 to 1.0	%	ASTM D955

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 3.00 mm)	99		ASTM D785
Durometer Hardness			ASTM D2240
Shore D, 3.00 mm	79		
Shore D, 15 sec, 3.00 mm	72		

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.00 mm)	32.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.00 mm)	15	%	ASTM D638
Flexural Modulus (3.00 mm)	4430	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.00 mm)	24	J/m	ASTM D256
Unnotched Izod Impact (3.00 mm)	230	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.00 mm	135	°C	
1.8 MPa, Unannealed, 3.00 mm	84.0	°C	
CLTE - Flow (-30 to 30°C, 3.00 mm)	6.0E-5	cm/cm/°C	ASTM D696

Injection	Nominal Value	Unit
Suggested Max Regrind	10	%
Extrusion	Nominal Value	Unit
Drying Temperature	100 to 120	°C
Drying Time	2.0 to 4.0	hr
Cylinder Zone 1 Temp.	180 to 240	°C
Cylinder Zone 2 Temp.	180 to 240	°C
Cylinder Zone 3 Temp.	180 to 240	°C
Cylinder Zone 4 Temp.	180 to 240	°C
Cylinder Zone 5 Temp.	180 to 240	°C
Melt Temperature	200 to 220	°C
Die Temperature	200 to 220	°C
NOTE		
1.	50 mm/min	
2.	50 mm/min	

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