

Borealis PP PS65T20

Polypropylene

Borealis AG

Message:

PS65T20 is a 20% mineral filled polypropylene compound intended for injection and back injection moulding. This material has excellent balanced mechanical properties and high melt flow rate.

General Information			
Filler / Reinforcement	Mineral filler, 20% filler by weight		
Features	High liquidity		
Uses	Application in Automobile Field		
	Car interior parts		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	23	g/10 min	ISO 1133
Molding Shrinkage	1.2	%	Internal method
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	90.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (Injection Molded)	2600	MPa	ISO 527-2/1
Tensile Stress (Yield, Injection Molded)	32.0	MPa	ISO 527-2/50
Tensile Strain (Yield, Injection Molded)	4.5	%	ISO 527-2/50
Flexural Modulus ¹ (Injection Molded)	2700	MPa	ISO 178
Flexural Stress (Injection Molded)	46.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-20°C, injection molding	1.5	kJ/m ²	ISO 179/1eA
23°C, injection molding	2.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-20°C, injection molding	15	kJ/m ²	ISO 179/1eU
23°C, injection molding	35	kJ/m ²	ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-20°C, injection molding	2.0	kJ/m ²	ISO 180/1A
23°C, injection molding	3.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-20°C, injection molding	12	kJ/m ²	ISO 180/1U
23°C, injection molding	30	kJ/m ²	ISO 180/1U

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	110	°C	ISO 75-2/B
1.8 MPa, not annealed	60.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	154	°C	ISO 306/A50
--	96.0	°C	ISO 306/B50
Melt Energy	85.5	kJ/kg	ISO 11357
Atomization-16 hrs (100°C)	6.0E-4	g	DIN 75201
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Hopper Temperature	40.0 - 80.0	°C	
Processing (Melt) Temp	220 - 260	°C	
Mold Temperature	30.0 - 50.0	°C	
Holding Pressure	30.0 - 60.0	MPa	
Injection instructions			
Back pressure: Low to mediumScrew speed: Low to mediumFlow front speed: 100 - 200 mm/s			
NOTE			
1.	2.0 mm/min		

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