

Starpylen MF004S

Polypropylene
Eurostar Engineering Plastics

Message:
Starpylen MF004S is 20% Glass Fiber Reinforced Polypropylene Injection Molding Resin

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.05	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	0.30 to 0.50	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4700	MPa	ISO 527-2/1
Tensile Stress (Yield)	78.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	3.1	%	ISO 527-2/50
Flexural Modulus ¹	4100	MPa	ISO 178
Flexural Stress	102	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	8.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	35	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴ (1.8 MPa, Unannealed, 64.0 mm Span)	131	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	4.4E-5	cm/cm/°C	
Transverse : 23 to 60°C	1.3E-4	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	70.0	°C	
Drying Time	3.0	hr	
Rear Temperature	195 to 205	°C	
Middle Temperature	215 to 225	°C	
Front Temperature	225 to 250	°C	
Processing (Melt) Temp	225 to 250	°C	
Mold Temperature	30.0 to 50.0	°C	
NOTE			
1.	2.0 mm/min		
2.	80*10*4		
3.	80*10*4		

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