Celstran® PP-GF30-0501 P8/13

Polypropylene

Celanese Corporation

Message:

Material code according to ISO 1043-1: PP
High impact modified polypropylene reinforced with 30 weight percent long glass fibers. The fibers are chemically coupled to the polypropylene matrix. The impact properties are enhanced.
The pellets are cylindrical and normally as well as the embedded fibers 10 mm long.
Parts molded of CELSTRAN have outstanding mechanical properties such as high strength and stiffness combined with high heat deflection.
The notched impact strength is increased at elevated and low temperatures due to the fiber skeleton built in the parts. The long fiber reinforcement reduces creep significantly.
The very isotropic shrinkage in the molded parts minimizes the warpage.
Complex parts can be manufactured with high reproducibility by injection molding.
Application field: Functional/structural parts for automotive

General Information			
Filler / Reinforcement	Long glass fiber, 30% filler by weight		
Additive	Impact modifier		
Features	Impact modification Low warpage Rigidity, high Chemical coupling Impact resistance, good Good creep resistance Low temperature impact resistance		
Uses	Application in Automobile Field		
RoHS Compliance	Contact manufacturer		
Resin ID (ISO 1043)	PP		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.12	g/cm³	ISO 1183
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			
--	6400	MPa	ISO 527-2/1A/1
80°C	4400	MPa	ISO 527-2/1A
Tensile Stress			
Fracture	95.0	MPa	ISO 527-2/1A/5
80°C	55.0	MPa	ISO 527-2/1A
Tensile Strain			

Fracture	2.6	%	ISO 527-2/1A/5
Fracture, 80°C	3.4	%	ISO 527-2/1A
Flexural Modulus (23°C)	5500	MPa	ISO 178
Flexural Stress (23°C)	140	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	28	kJ/m^2	ISO 179/1eA
23°C	29	kJ/m^2	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	80	kJ/m^2	ISO 179/1eU
23°C	70	kJ/m^2	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
1.8 MPa, not annealed	158	°C	ISO 75-2/A
8.0 MPa, not annealed	122	°C	ISO 75-2/C
Injection	**Nominal Value**	**Unit**	
Drying Temperature	90.0 - 100	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	220 - 240	°C	
Middle Temperature	240 - 250	°C	
Front Temperature	250 - 260	°C	
Nozzle Temperature	240 - 270	°C	
Processing (Melt) Temp	230 - 270	°C	
Mold Temperature	30.0 - 70.0	°C	
Injection Pressure	60.0 - 120	MPa	
Injection Rate	Slow		
Holding Pressure	40.0 - 80.0	MPa	
Back Pressure	0.00 - 3.00	MPa	

Injection instructions

Manifold Temperature: 230 to 270°CZone 4 Temperature: 260 to 270°CFeed Temperature: 20 to 50°C

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China


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