

# RheTech Polypropylene HP521-372

Polypropylene Copolymer

RheTech, Inc.

Message:

15% Talc Reinforced, High Performance, UV Stabilized, Polypropylene Copolymer, 110D Medium Dark Pewter.

| General Information                       |                                   |                   |             |
|-------------------------------------------|-----------------------------------|-------------------|-------------|
| Filler / Reinforcement                    | Talc filler, 15% filler by weight |                   |             |
| Additive                                  | UV stabilizer                     |                   |             |
| Features                                  | Copolymer                         |                   |             |
|                                           | Good UV resistance                |                   |             |
| Appearance                                | Dark gray                         |                   |             |
| Processing Method                         | Injection molding                 |                   |             |
| Physical                                  | Nominal Value                     | Unit              | Test Method |
| Specific Gravity                          | 0.998                             | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 16                                | g/10 min          | ASTM D1238  |
| Hardness                                  | Nominal Value                     | Unit              | Test Method |
| Durometer Hardness (Shore D)              | 67                                |                   | ASTM D2240  |
| Mechanical                                | Nominal Value                     | Unit              | Test Method |
| Tensile Strength                          | 20.7                              | MPa               | ASTM D638   |
| Flexural Modulus                          | 1380                              | MPa               | ASTM D790   |
| Impact                                    | Nominal Value                     | Unit              | Test Method |
| Notched Izod Impact                       | 91                                | J/m               | ASTM D256   |
| Dart Drop Impact                          | 22.6                              | J                 | ASTM D5420  |
| Thermal                                   | Nominal Value                     | Unit              | Test Method |
| Deflection Temperature Under Load         |                                   |                   | ASTM D648   |
| 0.45 MPa, not annealed                    | 101                               | °C                | ASTM D648   |
| 1.8 MPa, not annealed                     | 57.2                              | °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                          | 193 - 221                         | °C                |             |
| Middle Temperature                        | 199 - 227                         | °C                |             |
| Front Temperature                         | 204 - 232                         | °C                |             |
| Nozzle Temperature                        | 210 - 221                         | °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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