

RheTech Polypropylene T20P104-334

Polypropylene

RheTech, Inc.

Message:

20% Talc Reinforced Polypropyle, Black

General Information			
Filler / Reinforcement	Talc filler, 20% filler by weight		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	17	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	74		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	31.0	MPa	ASTM D638
Flexural Modulus	2410	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	27	J/m	ASTM D256
Dart Drop Impact	1.13	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	119	°C	ASTM D648
1.8 MPa, not annealed	68.3	°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	199 - 227	°C	
Middle Temperature	204 - 232	°C	
Front Temperature	216 - 238	°C	
Nozzle Temperature	26.7 - 48.9	°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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