

Advanced Composites ATX646M

Polypropylene
Advanced Composites, Inc.

Message:

Advanced Composites ATX646M is a polypropylene product. It is available in North America. Typical application areas are: automotive industry.
Features include:
high liquidity
Impact resistance

General Information			
Features	High liquidity		
	Low temperature impact resistance		
Uses	Application in Automobile Field		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Density	0.957	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)	24	g/10 min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	64		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	25.4	MPa	ISO 527-2
Flexural Modulus	1620	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180
-40°C	4.0	kJ/m ²	ISO 180
23°C	37	kJ/m ²	ISO 180
Instrumented Dart Impact			ASTM D3763
0°C	36.0	J	ASTM D3763
23°C	35.0	J	ASTM D3763
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	62.0	°C	ISO 75-2/A
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	> 2.0	hr	
Rear Temperature	193	°C	
Middle Temperature	210 - 216	°C	
Front Temperature	216	°C	
Nozzle Temperature	210	°C	

Processing (Melt) Temp	193 - 238	°C
Mold Temperature	37.8 - 48.9	°C
Injection Rate	Slow-Moderate	
Cushion	6.35 - 12.7	mm

Injection instructions

Injection Pressure: 50 to 60% of machine capacityScrew RPM: 1 to 2 secs before mold open

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