

# RheTech Polypropylene P254-00

Polypropylene Copolymer

RheTech, Inc.

Message:

Polypropylene Copolymer, Natural.

| General Information                       |                   |                   |             |
|-------------------------------------------|-------------------|-------------------|-------------|
| Features                                  | Copolymer         |                   |             |
| Appearance                                | Natural color     |                   |             |
| Processing Method                         | Injection molding |                   |             |
| Physical                                  | Nominal Value     | Unit              | Test Method |
| Specific Gravity                          | 0.898             | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 20                | g/10 min          | ASTM D1238  |
| Hardness                                  | Nominal Value     | Unit              | Test Method |
| Durometer Hardness (Shore D)              | 64                |                   | ASTM D2240  |
| Mechanical                                | Nominal Value     | Unit              | Test Method |
| Tensile Strength                          | 24.1              | MPa               | ASTM D638   |
| Flexural Modulus                          | 1070              | MPa               | ASTM D790   |
| Impact                                    | Nominal Value     | Unit              | Test Method |
| Notched Izod Impact                       | 120               | J/m               | ASTM D256   |
| Dart Drop Impact                          | 21.5              | J                 | ASTM D5420  |
| Thermal                                   | Nominal Value     | Unit              | Test Method |
| Deflection Temperature Under Load         |                   |                   | ASTM D648   |
| 0.45 MPa, not annealed                    | 91.1              | °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                          | 188 - 216         | °C                |             |
| Middle Temperature                        | 193 - 221         | °C                |             |
| Front Temperature                         | 199 - 227         | °C                |             |
| Nozzle Temperature                        | 204 - 216         | °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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