

RheTech Polypropylene T40P109-01

Polypropylene

RheTech, Inc.

Message:

40% Talc Reinforced, Polypropylene, Black.

General Information			
Filler / Reinforcement	Talc filler, 40% filler by weight		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.26	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	15	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	73		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	29.6	MPa	ASTM D638
Flexural Modulus	3620	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	27	J/m	ASTM D256
Dart Drop Impact	0.904	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	131	°C	ASTM D648
1.8 MPa, not annealed	80.6	°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	210 - 238	°C	
Middle Temperature	216 - 243	°C	
Front Temperature	221 - 249	°C	
Nozzle Temperature	227 - 238	°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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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

