

# 4PROP® 25C1622.5

Polypropylene Copolymer  
4Plas

Message:

4PROP 25C1622.5 is a MFI 6 2.5% Carbon Black Copolymer Polypropylene

| General Information                                |                   |                   |                |
|----------------------------------------------------|-------------------|-------------------|----------------|
| Additive                                           | Carbon black (3%) |                   |                |
| Features                                           | Copolymer         |                   |                |
| Processing Method                                  | Injection molding |                   |                |
| Physical                                           | Nominal Value     | Unit              | Test Method    |
| Density                                            | 0.905             | g/cm <sup>3</sup> | ISO 1183       |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)          | 6.5               | g/10 min          | ISO 1133       |
| Hardness                                           | Nominal Value     | Unit              | Test Method    |
| Hardness - Shore D                                 | 55.0              |                   |                |
| Mechanical                                         | Nominal Value     | Unit              | Test Method    |
| Tensile Modulus (23°C)                             | 1000              | MPa               | ISO 527-2/5    |
| Tensile Stress                                     |                   |                   | ISO 527-2/5    |
| Yield, 23°C                                        | 25.0              | MPa               | ISO 527-2/5    |
| Fracture, 23°C                                     | 20.0              | MPa               | ISO 527-2/5    |
| Tensile Strain                                     |                   |                   | ISO 527-2/5    |
| Yield, 23°C                                        | 50                | %                 | ISO 527-2/5    |
| Fracture, 23°C                                     | 45                | %                 | ISO 527-2/5    |
| Flexural Modulus <sup>1</sup> (23°C)               | 1050              | MPa               | ISO 178        |
| Impact                                             | Nominal Value     | Unit              | Test Method    |
| Notched Izod Impact                                |                   |                   | ISO 180/1A     |
| -30°C                                              | 5.0               | kJ/m <sup>2</sup> | ISO 180/1A     |
| 23°C                                               | 12                | kJ/m <sup>2</sup> | ISO 180/1A     |
| Thermal                                            | Nominal Value     | Unit              | Test Method    |
| Heat Deflection Temperature (0.45 MPa, Unannealed) | 50.0              | °C                | ISO 75-2/B     |
| Vicat Softening Temperature                        | 67.0              | °C                | ISO 306/B      |
| Melting Temperature <sup>2</sup>                   | 165               | °C                | ISO 11357      |
| Flammability                                       | Nominal Value     | Unit              | Test Method    |
| Flame Rating (1.60 mm)                             | HB                |                   | UL 94          |
| Glow Wire Ignition Temperature (2.00 mm)           | 650               | °C                | IEC 60695-2-13 |
| Injection                                          | Nominal Value     | Unit              |                |
| Processing (Melt) Temp                             | 200 - 240         | °C                |                |
| Mold Temperature                                   | 20.0 - 50.0       | °C                |                |
| Injection Rate                                     | Moderate          |                   |                |

|                                                        |             |     |
|--------------------------------------------------------|-------------|-----|
| Holding Pressure                                       | 40.0 - 80.0 | MPa |
| Screw Speed                                            | 200         | rpm |
| Injection instructions                                 |             |     |
| Feed Throat Temperature: 20 - 60 °C Back Pressure: Low |             |     |
| NOTE                                                   |             |     |
| 1.                                                     | 2.0 mm/min  |     |
| 2.                                                     | 10 K/min    |     |

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