

Celstran® PP-GF30-0403 P10/10

Polypropylene

Celanese Corporation

Message:

Material code according to ISO 1043-1: PP

Polypropylene reinforced with 30weight percent long glass fibers. The fibers are chemically coupled to the polypropylene matrix. The pellets are cylindrical and normally as well as the embedded fibers 10 mm long.

Parts molded of CELSTRAN have outstanding mechanical properties such as high strength and stiffness combined with high heat deflection.

The notched impact strength is increased at elevated and low temperatures due to the fiber skeleton built in the parts. The long fiber reinforcement reduces creep significantly.

The very isotropic shrinkage in the molded parts minimizes the warpage.

Complex parts can be manufactured with high reproducibility by injection molding.

Application field: Functional/structural parts for automotive

General Information			
Filler / Reinforcement	Long glass fiber, 30% filler by weight		
Features	Low warpage		
	Rigidity, high		
	High strength		
	Chemical coupling		
	Impact resistance, good		
	Good creep resistance		
	Low temperature impact resistance		
Uses	Application in Automobile Field		
RoHS Compliance	Contact manufacturer		
Forms	Particle		
Processing Method	Injection molding		
Resin ID (ISO 1043)	PP		
Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.35	%	ISO 294-4
Flow direction	0.22	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
--	7000	MPa	ISO 527-2/1A/1
80°C	4700	MPa	ISO 527-2/1A
Tensile Stress			

Fracture	110	MPa	ISO 527-2/1A/5
80°C	70.0	MPa	ISO 527-2/1A
Tensile Strain			
Fracture	2.2	%	ISO 527-2/1A/5
Fracture, 80°C	2.3	%	ISO 527-2/1A
Flexural Modulus			
23°C	7000	MPa	ISO 178
80°C	6600	MPa	ISO 178
Flexural Stress			
23°C	180	MPa	ISO 178
80°C	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	22	kJ/m ²	ISO 179/1eA
23°C	24	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	45	kJ/m ²	ISO 179/1eU
23°C	55	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, not annealed	155	°C	ISO 75-2/A
8.0 MPa, not annealed	122	°C	ISO 75-2/C
Melting Temperature ¹	166	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	90.0 - 100	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	220 - 230	°C	
Middle Temperature	230 - 240	°C	
Front Temperature	240 - 250	°C	
Nozzle Temperature	240 - 250	°C	
Processing (Melt) Temp	230 - 270	°C	
Mold Temperature	30.0 - 70.0	°C	
Injection Pressure	60.0 - 120	MPa	
Injection Rate	Slow		
Holding Pressure	40.0 - 80.0	MPa	
Back Pressure	0.00 - 3.00	MPa	
Injection instructions			
Manifold Temperature: 230 to 270°CZone 4 Temperature: 250 to 250°CFeed Temperature: 20 to 50°C			
NOTE			
1.	10°C/min		

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