

# REPRO PP RG4

Polypropylene  
Rondo Plast AB

Message:  
PP 20% glassfibre reinforced

| General Information                       |                                  |                   |                |
|-------------------------------------------|----------------------------------|-------------------|----------------|
| Filler / Reinforcement                    | Glass Fiber,20% Filler by Weight |                   |                |
| Recycled Content                          | Yes                              |                   |                |
| Physical                                  | Nominal Value                    | Unit              | Test Method    |
| Density                                   | 1.05                             | g/cm <sup>3</sup> | ISO 1183       |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 7.0                              | g/10 min          | ISO 1133       |
| Mechanical                                | Nominal Value                    | Unit              | Test Method    |
| Tensile Stress                            | 30.0                             | MPa               | ISO 527-2      |
| Flexural Modulus (23°C)                   | 2900                             | MPa               | ISO 178        |
| Flexural Stress                           | 45.0                             | MPa               | ISO 178        |
| Impact                                    | Nominal Value                    | Unit              | Test Method    |
| Charpy Notched Impact Strength (23°C)     | 7.0                              | kJ/m <sup>2</sup> | ISO 179        |
| Thermal                                   | Nominal Value                    | Unit              | Test Method    |
| Heat Deflection Temperature <sup>1</sup>  |                                  |                   |                |
| 0.45 MPa, Unannealed                      | 125                              | °C                | ISO 75-2/B     |
| 1.8 MPa, Unannealed                       | 95.0                             | °C                | ISO 75-2/A     |
| Flammability                              | Nominal Value                    | Unit              | Test Method    |
| Flame Rating (1.60 mm)                    | HB                               |                   | UL 94          |
| Glow Wire Ignition Temperature (2.00 mm)  | 750                              | °C                | IEC 60695-2-13 |
| Injection                                 | Nominal Value                    | Unit              |                |
| Drying Temperature                        | 80.0                             | °C                |                |
| Drying Time                               | 2.0 to 4.0                       | hr                |                |
| Processing (Melt) Temp                    | 205 to 260                       | °C                |                |
| Mold Temperature                          | 40.0 to 80.0                     | °C                |                |
| Injection Pressure                        | 40.0 to 110                      | MPa               |                |
| Injection Rate                            | Fast                             |                   |                |
| Back Pressure                             | 1.00 to 2.00                     | MPa               |                |
| NOTE                                      |                                  |                   |                |
| 1.                                        | 120°C/hr                         |                   |                |

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