

Advanced Composites ATX832N

Compounded Polypropylene

Advanced Composites, Inc.

Message:

Advanced Composites ATX832N is a composite polypropylene product, which contains talc filler. It is available in North America. Typical application areas are: automotive industry.

Features include:

high liquidity

Impact resistance

scratch resistance

General Information			
Filler / Reinforcement	Talc filler		
Features	Impact resistance, high		
	High liquidity		
	Scratch resistance		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Density	1.03	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)	30	g/10 min	ISO 1133
Molding Shrinkage (3.00 mm)	9.0E-3 - 0.011	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 15 sec)	59		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	25.0	MPa	ISO 527-2
Flexural Modulus	2180	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ISO 180
-40°C	5.0	kJ/m ²	ISO 180
23°C	28	kJ/m ²	ISO 180
Instrumented Dart Impact ¹ (0°C)	36.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	123	°C	ISO 75-2/B
1.8 MPa, not annealed	64.0	°C	ISO 75-2/A
Injection	Nominal Value	Unit	
Drying Temperature	100	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	204	°C	
Middle Temperature	218	°C	
Front Temperature	218	°C	

Nozzle Temperature	216	°C
Processing (Melt) Temp	204 - 232	°C
Mold Temperature	32.2 - 48.9	°C
Cushion	6.35 - 12.7	mm

Injection instructions

Injection Pressure: 10% over max fill pressureHolding Pressure: 50 to 60% of max fill pressureInjection Speed: 1 to 3 inches/secScrew RPM: 1 to 2 secs before mold open

NOTE

- 6.70 m/sec

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