

Generic PP, Unspecified - Mica

Polypropylene

Generic

Message:

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This information is provided for comparative purposes only.

General Information			
Filler / Reinforcement	Mica filler		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.998 - 1.25	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	1.0 - 18	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C)	0.70 - 1.4	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (23°C)	73 - 75		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 23°C	22.1 - 47.6	MPa	ASTM D638
23°C	20.0 - 33.2	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	3.0 - 26	%	ASTM D638
Flexural Modulus (23°C)	1640 - 4990	MPa	ASTM D790
Flexural Strength (23°C)	31.0 - 49.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	26 - 81	J/m	ASTM D256
Unnotched Izod Impact (23°C)	39 - 670	J/m	ASTM D256
Dart Drop Impact (23°C)	0.339 - 0.613	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	119 - 151	°C	ASTM D648
1.8 MPa, not annealed	55.5 - 88.4	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	73.9 - 79.7	°C	
Drying Time	1.5 - 2.5	hr	
Suggested Max Moisture	0.050 - 0.054	%	
Rear Temperature	195 - 224	°C	
Middle Temperature	195 - 229	°C	
Front Temperature	195 - 235	°C	
Nozzle Temperature	214 - 232	°C	
Processing (Melt) Temp	200 - 212	°C	
Mold Temperature	37.8 - 48.9	°C	

Injection Pressure	6.55 - 86.2	MPa
Holding Pressure	5.17 - 6.42	MPa
Back Pressure	0.676 - 0.689	MPa

Injection instructions

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