

Retpol® 3019 HS

Polypropylene

PolyPacific Pty. Ltd.

Message:

EXTRON 3019 HS is a 30% glass fibre reinforced coupled polypropylene compound. It is a medium flow injection moulding grade developed for components requiring high rigidity and high heat deflection temperatures with excellent creep resistance and good impact strength. It is stabilised to meet heat aging requirements of 21 days at 150°C.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Heat Stabilizer		
Features	Chemically Coupled		
	Good Creep Resistance		
	Good Impact Resistance		
	Heat Stabilized		
	High Rigidity		
	Medium Flow		
Forms	Granules		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.20 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 3.00 mm)	113		ASTM D785
Durometer Hardness			ASTM D2240
Shore D, 3.00 mm	83		
Shore D, 15 sec, 3.00 mm	77		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.00 mm)	96.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.00 mm)	3.0	%	ASTM D638
Flexural Modulus (3.00 mm)	5900	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.00 mm)	110	J/m	ASTM D256
Unnotched Izod Impact (3.00 mm)	680	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.00 mm	159	°C	
1.8 MPa, Unannealed, 3.00 mm	150	°C	

CLTE - Flow (-30 to 30°C, 3.00 mm)	3.0E-5	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Regrind	10	%	
Processing (Melt) Temp	200 to 260	°C	
Mold Temperature	20.0 to 60.0	°C	
Injection Rate	Moderate		
NOTE			
1.	50 mm/min		
2.	50 mm/min		

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