

Generic TPO

Compounded Polypropylene
Generic

Message:

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This information is provided for comparative purposes only.

General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	0.891 - 1.11	g/cm ³	ASTM D792
23°C	0.897 - 1.06	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
230°C/2.16 kg	0.50 - 27	g/10 min	ASTM D1238
230°C/2.16 kg	0.80 - 30	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	12.9 - 21.7	cm ³ /10min	ISO 1133
Molding Shrinkage - Flow (23°C)	0.99 - 1.7	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (23°C)	36 - 94		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	1000 - 2950	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	14.6 - 26.6	MPa	ASTM D638
Yield, 23°C	15.0 - 33.8	MPa	ISO 527-2
Fracture, 23°C	12.9 - 18.4	MPa	ISO 527-2
Tensile Strain			
Yield, 23°C	2.8 - 10	%	ISO 527-2
Fracture, 23°C	47 - 510	%	ASTM D638
Fracture, 23°C	4.0 - 63	%	ISO 527-2
Flexural Modulus			
23°C	172 - 2300	MPa	ASTM D790
23°C	870 - 1900	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	2.4 - 7.5	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	7.0 - 510	J/m	ASTM D256
23°C	3.2 - 54	kJ/m ²	ISO 180
Instrumented Dart Impact (23°C)	15.7 - 20.8	J	ASTM D3763
Dart Drop Impact (23°C)	16.2 - 30.5	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			
0.45 MPa, not annealed	90.4 - 140	°C	ASTM D648
0.45 MPa, not annealed	67.0 - 121	°C	ISO 75-2/B
1.8 MPa, not annealed	46.1 - 65.5	°C	ISO 75-2/A
Vicat Softening Temperature	98.9 - 138	°C	ISO 306
Injection	Nominal Value	Unit	
Drying Temperature	74.3 - 79.7	°C	
Drying Time	1.0 - 3.5	hr	
Rear Temperature	195 - 213	°C	
Middle Temperature	200 - 215	°C	
Front Temperature	204 - 221	°C	
Nozzle Temperature	207 - 220	°C	
Processing (Melt) Temp	213 - 215	°C	
Mold Temperature	29.4 - 54.4	°C	
Back Pressure	0.517 - 44.1	MPa	
Clamp Tonnage	4.1 - 4.5	kN/cm ²	

Injection instructions

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

