

Advanced Composites ATX889

Compounded Polypropylene

Advanced Composites, Inc.

Message:

Advanced Composites ATX889 is a composite polypropylene product, which contains talc filler. It is available in North America. Typical application areas are: automotive industry.

Features include:

Impact modification

high liquidity

scratch resistance

General Information			
Filler / Reinforcement	Talc filler		
Additive	Impact modifier		
Features	Impact modification		
	High liquidity		
	Scratch resistance		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	30	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.80 - 1.0	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	66		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	23.0	MPa	ASTM D638
Flexural Modulus	1720	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-29°C	56	J/m	ASTM D256
23°C	160	J/m	ASTM D256
Instrumented Dart Impact ¹ (-18°C, Total Energy)	36.2	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	132	°C	ASTM D648
1.8 MPa, not annealed	69.0	°C	ASTM D648
Injection	Nominal Value	Unit	Test Method
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

1. 6.60 m/sec

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