

Polypropylene compound Glass 30 Mineral 10 | Colour: Black

Property	Method	Measurement condition	Unit	Values
Melt Flow Rate	ISO 1133	230 °C; 2,1 kg	g /10 min	5
Ash content	ISO 3451	800 °C, 30 min	%	40 ± 2
Izod Impact Strength at 23°C	ISO 180	notched	kJ/m <sup>2</sup>	8
Flexural Modulus	ISO 178	2 mm/min	MPa	8200
Flexural Yield Strength	ISO 178	2 mm/min	MPa	138
Tensile strength	ISO 527-1	5 mm/min	MPa	90
Elongation at break	ISO 527-1	5 mm/min	%	4
Heat Deflection Temperature	ISO 75A	A	°C	151
Vicat Temperature	ISO 306	50N; 50 °C/h	°C	161
Density	ISO 1183-1	method A	g/cm <sup>3</sup>	1,21
Burning Behavior	UL - 94	1,6	mm	HB
Moldschrinkage	Inhouse method		%	0,3-0,7

## Application data

Description	Black PP compound with 30% glasfiber and 10% Talcum
Application	Injection Moulding
Drying conditions	80 oC , 4-6 hours moisture content < 0,02%
Moulding temperature - Nozzle	240 - 260 °C
Moulding temperature - Barrel	210 - 255 °C
Mould Temperature	40 - 80 °C
Compression ratio	2:1 - 2,5:1
Injection Pressure	Low
Injection Speed	Fast ram speed
Hold Pressure	Low
Screw speed	0,1 - 0,2 m/s
Cushion	4 - 6 mm
Back Pressure	0 - 1,0 MPa

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