

DAICEL PP

PP compound

Technical Information

TI-05209

Properties

PT4N1

Talc-reinforced PP compound (Talc20%)

Properties	Test methods	Test conditions	Units	
Melt mass-flow rate	ISO 1133	230 deg C/2.16kg	g/10min	12
Mold shrinkage	Our standard	-	%	1.0-1.3
Tensile strength	ISO 527	-	MPa	25
Flexural strength	ISO 178	-	MPa	40
Flexural modulus	ISO 178	-	MPa	2400
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	6
Rockwell hardness	ISO 2039	-	-	R87
Deflection temperature under load	ISO 75	0.45MPa	deg C	117
Density	ISO 1183	-	g/cm3	1.05

Note

- Test methods such as ISO standards are fully or almost compliant with the standards.
- Values are typical, not quality assured.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
3-5hrs 80-120deg C	180-230	180-230	160-210	140-190	70-90	5-20	40-60

*Preliminary drying under the conditions above is required, although PP resin hardly absorbs moisture.