

# DAICEL PP

PP compound

Technical Information

TI-05211

## Properties

### PT6N1

Talc-reinforced PP compound (Talc30%)

| Properties                        | Test methods | Test conditions  | Units   |         |
|-----------------------------------|--------------|------------------|---------|---------|
| Melt mass-flow rate               | ISO 1133     | 230 deg C/2.16kg | g/10min | 12      |
| Mold shrinkage                    | Our standard | -                | %       | 0.9-1.2 |
| Tensile strength                  | ISO 527      | -                | MPa     | 25      |
| Flexural strength                 | ISO 178      | -                | MPa     | 40      |
| Flexural modulus                  | ISO 178      | -                | MPa     | 3000    |
| Notched Charpy impact strength    | ISO 179/1eA  | 23 deg C         | kJ/m2   | 5       |
| Rockwell hardness                 | ISO 2039     | -                | -       | R88     |
| Deflection temperature under load | ISO 75       | 0.45MPa          | deg C   | 125     |
| Density                           | ISO 1183     | -                | g/cm3   | 1.11    |

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<br>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.

**Novacel Co., Ltd.**

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