

DAICEL PP

PP compound

Technical Information

TI-05212

Properties

PT8F1

Talc-reinforced PP compound (Talc40%)

High flow

| Properties | Test methods | Test conditions | Units | |
|-----------------------------------|--------------|------------------|---------|---------|
| Melt mass-flow rate | ISO 1133 | 230 deg C/2.16kg | g/10min | 13 |
| Mold shrinkage | Our standard | - | % | 0.8-1.1 |
| Tensile strength | ISO 527 | - | MPa | 27 |
| Flexural strength | ISO 178 | - | MPa | 42 |
| Flexural modulus | ISO 178 | - | MPa | 4300 |
| Notched Charpy impact strength | ISO 179/1eA | 23 deg C | kJ/m2 | 3 |
| Rockwell hardness | ISO 2039 | - | - | R86 |
| Deflection temperature under load | ISO 75 | 0.45MPa | deg C | 135 |
| Density | ISO 1183 | - | g/cm3 | 1.23 |

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.