

Phillips Sumika Marlex® CHP-370 Thermoplastic Polyolefin (discontinued **)

Category : Polymer , Thermoplastic , Polyolefin

Material Notes:

Thermoplastic Polyolefin, Good Stiffness and Impact PerformanceApplications: Automotive Pillar TrimConditioning after Molding: 48 hr at 23°CNominal Shrinkage: 0.8-1.0%Drying conditionsTemperature: 80-100°CTime: 2 hours minimum, 4 hours maximumDevice: Desiccant DryerMoisture content: 0.1 wt% max.Molding TemperaturesRear Temperature: 145-200°CMiddle Temperature: 210-235°CFront and Nozzle Temps: 210-235°CTock Temperature: 191-246°CMold Temperature: 23-50°CProcessing conditionsSuggested shot size: 50-70%First stage injection pressure: MaximizeScrew Speed: 30-60%Packing pressure: MinimizeBack Pressure: 50-150 psiOther molding considerations: Melt temperature above 260°C may cause resin degradation and changes to resin properties. To improve dispersion of color concentrates use a screw with a mixing zone or mixing nozzle.Phillips Sumika Polypropylene Company has been shut down, as announced in 2011. This product had been discontinued prior to the shutdown announcement.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Phillips-Sumika-Marlex-CHP-370-Thermoplastic-Polyolefin-nbspdiscontinued-.php

Physical Properties	Metric	English	Comments
Density	1.00 g/cc	0.0361 lb/in ³	ASTM D1505
	1.00 g/cc	0.0361 lb/in ³	ISO 1183
Linear Mold Shrinkage	0.0080 - 0.010 cm/cm	0.0080 - 0.010 in/in	
Melt Flow	30 g/10 min	30 g/10 min	ASTM D1238
	@Temperature 230 °C	@Temperature 446 °F	
	30 g/10 min	30 g/10 min	ISO 1133
	@Temperature 230 °C	@Temperature 446 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	61	61	ASTM D785
	61	61	ISO 2039
Hardness, Shore D	58	58	ASTM D2240
	58	58	ISO 868
Tensile Strength, Yield	20.7 MPa	3000 psi	50 mm/min; ISO 527
	20.9 MPa	3030 psi	50 mm/min; ASTM D638
Flexural Modulus	1.60 GPa	232 ksi	Secant, 1.3 mm/min; ASTM D790
	1.63 GPa	236 ksi	2.0 mm/min; ISO 178
Izod Impact, Notched	NB	NB	ASTM D256

Mechanical Properties	Metric	English	Comments
	0.310 J/cm	0.005 ft-lb/in	ASTM D256
	@Temperature -30.0 °C	@Temperature -22.0 °F	
Izod Impact, Notched (ISO)	31.0 kJ/m ²	14.8 ft-lb/in ²	ISO 180
	3.00 kJ/m ²	1.43 ft-lb/in ²	ISO 180
	@Temperature -40.0 °C	@Temperature -40.0 °F	

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	102 °C	216 °F	ISO 75
	104 °C	219 °F	ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	53.0 °C	127 °F	ASTM D648
	54.0 °C	129 °F	ISO 75

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