

RheTech Products F22-01 20% Glass Fiber/Mineral Co-Reinforced Polypropylene, Black

Category : Polymer , Thermoplastic , Polypropylene (PP) , Polypropylene, Glass/Mineral Reinforced

Material Notes:

Applications: Support ductsHousingsBattery traysInjection molding conditions reported in table.Information provided by RheTech Products.

Order this product through the following link:

http://www.lookpolymers.com/polymer_RheTech-Products-F22-01-20-Glass-FiberMineral-Co-Reinforced-Polypropylene-Black.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.06 g/cc	1.06 g/cc	23/23°C; ASTM D792
Filler Content	20 %	20 %	ASTM D5630
Linear Mold Shrinkage	0.0060 cm/cm	0.0060 in/in	ASTM D955
Melt Flow	18 g/10 min @Load 2.16 kg, Temperature 230 °C	18 g/10 min @Load 4.76 lb, Temperature 446 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	74	74	ASTM D2240
Tensile Strength at Break	37.2 MPa	5400 psi	2 in/min; ASTM D638
Flexural Modulus	3.10 GPa	450 ksi	Tangent; ASTM D790
Izod Impact, Notched	0.267 J/cm @Temperature 23.0 °C	0.500 ft-lb/in @Temperature 73.4 °F	ASTM D256
Gardner Impact	0.339 J	0.250 ft-lb	ASTM D5420

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	143 °C	290 °F	ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	96.1 °C	205 °F	ASTM D648

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	199 - 227 °C	390 - 440 °F	
Middle Barrel Temperature	204 - 232 °C	400 - 450 °F	
Front Barrel Temperature	210 - 238 °C	410 - 460 °F	

Processing Properties	Metric	English	Comments
Nozzle Temperature	216 - 227 °C	423 - 440 °F	
Mold Temperature	26.7 - 48.9 °C	80.0 - 120 °F	
Drying Temperature	65.6 - 82.2 °C	150 - 180 °F	
Dry Time	1 - 2 hour	1 - 2 hour	
Moisture Content	<= 0.050 %	<= 0.050 %	Recommended
Injection Pressure	2.76 - 10.3 MPa	400 - 1500 psi	
Hold Pressure	2.07 - 8.27 MPa	300 - 1200 psi	
Back Pressure	0.345 - 1.03 MPa	50.0 - 150 psi	

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