

FOROLEN® PP(2050MN)

MATERIAL NAME: PP COLOR: NATURAL CODE: 2050MN

MATERIAL DESCRIPTION: Forolen® PP 2050MN is a 20% mineral filled, prime, natural homo Polypropylene for injection molding.

| No. | PROPERTIES | | METHOD | UNIT | VALUE |
|-------------------------------------|------------------------------------|------------------|-----------------------|---------------------|-------------|
| PHYSICAL PROPERTIES | | | | | |
| 1 | ASH CONTENT | | ISO 3451 | % | 20 |
| 2 | RELATIVE DENSITY | | ISO 1183 | g/cm ³ | 1.06 |
| 3 | VISCOSITY NUMBER | | ISO 307 | Cm ³ /gr | - |
| 4 | MOISTURE CONTENT | | ISO 62 | % | 0.23 |
| MECHANICAL PROPERTIES | | | | | |
| 5 | TENSIL STRENGTH AT BREAK (5mm/min) | | ASTM/D638 | MPa | 26 |
| 6 | ELONGATION AT BREAK (5mm/min) | | ASTM/D638 | % | 60 |
| 7 | TENSIL MODULUS (5mm/min) | | ASTM/D638 | MPa | 2100 |
| 8 | NOTCHED IMPACT STRENGTH-IZOD | | ISO 180 | Kj/m ² | 5.5 |
| 9 | UN NOTCHED IMPACT STRENGTH-IZOD | | ISO 180 | Kj/m ² | 49 |
| THERMAL PROPERTIES | | | | | |
| 10 | HARDNESS | | ISO 868 | Shore D | 65 |
| 11 | MFI | | ASTM/D1238 | g/10min | - |
| 12 | VICAT(50° C/h) | 10N | ASTM/D1238 | ° C | - |
| | | 50N | | | - |
| FLAMMABILITY | | | | | |
| 13 | HDT (120° C/h) | 264psi | ASTM/D648 | ° C | - |
| | | 66psi | | | - |
| 14 | Flammability | Class | UL94 | - | - |
| INJECTION PROCESS PARAMETERS | | | | | |
| <i>Loading</i> | | <i>Injection</i> | | <i>Degassing</i> | |
| <i>Speed</i> | <i>Pressure (Bar)</i> | <i>Speed</i> | <i>Pressure (Bar)</i> | <i>Temperature</i> | <i>Time</i> |
| 60 | 80 | 60 | 80 | 50 °C | 0.5h |
| <i>Mold Releasing</i> | | <i>Zone</i> | | | |
| <i>Good</i> | | 5 | 4 | 3 | 2 |
| | | - °C | 165°C | 170°C | 175°C |