

Technical Data Sheet

# Gapex RPP25DZ04BL

Polypropylene  
LyondellBasell Industries  
Engineering Plastics

| General                                   |                                     |                    |             |
|-------------------------------------------|-------------------------------------|--------------------|-------------|
| Filler / Reinforcement                    | • Glass Fiber, 25% Filler by Weight |                    |             |
| Appearance                                | • Blue                              |                    |             |
| Forms                                     | • Pellets                           |                    |             |
| Processing Method                         | • Injection Molding                 |                    |             |
| Physical                                  | Nominal Value (English)             | Nominal Value (SI) | Test Method |
| Density / Specific Gravity                | 1.08                                | 1.08 g/cm³         | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 Kg) | 7.0 g/10 min                        | 7.0 g/10 min       | ASTM D1238  |
| Mechanical                                | Nominal Value (English)             | Nominal Value (SI) | Test Method |
| Tensile Strength (Yield)                  | 5750 psi                            | 39.6 MPa           | ASTM D638   |
| Tensile Elongation (Break)                | 4.0 %                               | 4.0 %              | ASTM D638   |
| Flexural Modulus                          | 400000 psi                          | 2760 MPa           | ASTM D790   |
| Flexural Strength (Yield)                 | 9000 psi                            | 62.1 MPa           | ASTM D790   |
| Impact                                    | Nominal Value (English)             | Nominal Value (SI) | Test Method |
| Notched Izod Impact (73°F (23°C))         | 0.45 ft·lb/in                       | 24 J/m             | ASTM D256   |
| Unnotched Izod Impact (73°F (23°C))       | 4.0 ft·lb/in                        | 210 J/m            | ASTM D4812  |
| Thermal                                   | Nominal Value (English)             | Nominal Value (SI) | Test Method |
| Deflection Temperature Under Load         |                                     |                    | ASTM D648   |
| 66 Psi (0.45 Mpa), Unannealed             | 310 °F                              | 154 °C             |             |
| 264 Psi (1.8 Mpa), Unannealed             | 275 °F                              | 135 °C             |             |

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| Injection              | Nominal Value (English) | Nominal Value (SI) |
|------------------------|-------------------------|--------------------|
| Drying Temperature     | 160 to 180 °F           | 71 to 82 °C        |
| Drying Time            | 2.0 to 4.0 hr           | 2.0 to 4.0 hr      |
| Rear Temperature       | 430 to 460 °F           | 221 to 238 °C      |
| Middle Temperature     | 440 to 470 °F           | 227 to 243 °C      |
| Front Temperature      | 450 to 500 °F           | 232 to 260 °C      |
| Nozzle Temperature     | 450 to 500 °F           | 232 to 260 °C      |
| Processing (Melt) Temp | 430 to 460 °F           | 221 to 238 °C      |
| Mold Temperature       | 100 to 150 °F           | 38 to 66 °C        |
| Injection Rate         | Slow-Moderate           | Slow-Moderate      |
| Back Pressure          | 20.0 to 50.0 psi        | 0.138 to 0.345 MPa |
| Cushion                | 0.200 to 0.500 in       | 5.08 to 12.7 mm    |

### Notes

These are typical property values not to be construed as specification limits.