ISOGLASS® - PP (glass fiber reinforced)

Structure	Semicristalline
Density	0.97 – 1.26 g/cm3 (10-40% filled)
General properties	Hard, good resilience. High stiffness. Low hygroscopicity and good thermal stability.
Barrel temperature	(decrease 15°C for flame retardant grades)
Feed zone:	30 – 50 °C
Zone 1:	160 – 240 °C
Zone 2:	210 – 250 °C
Zone 3:	230 – 250 °C
Zone 4:	230 – 250 °C
Zone 5:	230 – 250 °C
Nozzle:	230 – 250 °C
Melt temperature	230 – 250 °C
Mould temperature	20 – 70 °C
Injection temperature	800 – 1400 bar
Post-pressure	Between 30 and 60% of injection pressure, high post-pressure time
Counterpressure	50 – 200 bar
Injection speed	Medium
Screw speed	Equal to peripheric speed of 1.3 m/s
Metering	0.5 –4.0 diameters
Cushion	2 – 8 mm, depends on metering and screw diameter
Drying	Not necessary. 1 hour at 70°C if stored in humid place.
Recycle	100% of regrinded material. This percentage decreases for technical and aesthetic parts.
Shrinkage	0.3 – 0.7 %, complete after 40 hours.
Barrel equipment	Standard screw, non-return valve, free-flow nozzle
Quenching	Not necessary to purge with other materials. Purge with natural product suggested after flame retardant processing.

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