

## Properties

### PT4N1

Talc-reinforced PP compound (Talc20%)

| Properties                        | Test methods | Test conditions  | Units   |         |
|-----------------------------------|--------------|------------------|---------|---------|
| Melt mass-flow rate               | ISO 1133     | 230 deg C/2.16kg | g/10min | 12      |
| Mold shrinkage                    | ASTM D955    | -                | %       | 1.0-1.3 |
| Tensile strength                  | ISO 527      | -                | MPa     | 25      |
| Flexural strength                 | ISO 178      | -                | MPa     | 40      |
| Flexural modulus                  | ISO 178      | -                | MPa     | 2400    |
| Notched Charpy impact strength    | ISO 179/1eA  | 23 deg C         | kJ/m2   | 6       |
| Rockwell hardness                 | ISO 2039     | -                | -       | R87     |
| Deflection temperature under load | ISO 75       | 0.45MPa          | deg C   | 117     |
| Density                           | ISO 1183     | -                | g/cm3   | 1.05    |

Note

•Values are typical, not quality assured.

### Typical settings for processing

| Preliminary drying    | Barrel temperature(deg C) |         |         |         | Screw rotation<br>(rpm) | Back pressure<br>(MPa) | Mold temperature<br>(deg C) |
|-----------------------|---------------------------|---------|---------|---------|-------------------------|------------------------|-----------------------------|
|                       | Nozzle                    | Front   | Middle  | Back    |                         |                        |                             |
| 3-5hrs<br>80-120deg C | 180-230                   | 180-230 | 160-210 | 140-190 | 70-90                   | 5-20                   | 40-60                       |

[Alert Notes]

\*Preliminary drying under the conditions above is required, although PP resin hardly absorbs moisture.