

Optipro CP3510GM

The Materials Group - Polypropylene Copolymer

General Information

General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber
Features	<ul style="list-style-type: none"> High Stiffness
Uses	<ul style="list-style-type: none"> Automotive Applications
Appearance	<ul style="list-style-type: none"> Black Natural Color
Forms	<ul style="list-style-type: none"> Pellets
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	10	g/10 min	ISO 1133
Molding Shrinkage	0.30 to 0.50	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	7630	psi	ISO 527-2
Tensile Strain (Break)	4.6	%	ISO 527-2
Flexural Modulus	901000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	6.1	ft-lb/in ²	ISO 179

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	160 to 180	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Max Moisture	0.040	%
Suggested Shot Size	30 to 80	%
Rear Temperature	430 to 460	°F
Middle Temperature	440 to 470	°F
Front Temperature	450 to 480	°F
Nozzle Temperature	460 to 490	°F
Processing (Melt) Temp	430 to 460	°F
Mold Temperature	100 to 150	°F
Back Pressure	50.0 to 100	psi
Cushion	0.200 to 0.500	in

Injection Notes

Screw Speed: Slow to Moderate

Notes

¹ Typical properties: these are not to be construed as specifications.

