

X-Pro® SP200 P 5000



OVERVIEW

- Automotive certification: Chrysler, MSDB 500 CPN 4492
- Polypropylene Copolymer, recycled, medium flow
- Low cost alternative to virgin resin with comparable quality and process ability

Processing

Injection Molding

Application

Automotive General Purpose, Automotive Wheel Housings

Color

General Purpose Black

Quality

- ISO 9001: 2015 registered
- IEC 17025: 2005 accredited laboratories
- COA on every lot

| PROPERTY | VALUE | UNITS | TEST METHOD |
|------------------------------|---------|-----------|-------------------------|
| Melt Flow | 17-22 | g/10 min | ASTM D1238 / ISO 1133 |
| Izod Impact Notched @ 23° C | 3.2 | Ft lbs/in | ASTM 256 / ISO 180/A |
| Tensile @ Yield | 2,500 | psi | ASTM D638 / ISO 527-1/2 |
| Flexural Modulus 0.05 in/min | 110,000 | psi | ASTM D790 / ISO 178 |

GENERAL INJECTION MOLDING GUIDE

Barrel Temperature

Rear: 360°F to 420°F
Middle: 380°F to 440°F
Front: 400°F to 420°F

Nozzle Temperature

400°F to 420°F

Melt Temperature

400°F to 440°F

Mold Temperature

80°F to 140°F

Molding Pressure

Boost: 500 to 1,500 psi
Hold: 50 to 75% of Boost
Back: 50 to 150 psi

Screw Speed

Medium to Fast

Clamp Force

2 to 2.5 tons per square inch part projected area

Drying

2 to 4 hours at 180°F



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