

X-Pro® PP 4220



OVERVIEW

- Polypropylene Copolymer, recycled, medium flow
- Low cost alternative to virgin resin with comparable quality and process ability

Processing

Injection Molding

Application

General Purpose, Industrial, Housewares, Construction

Color

General Purpose Black

Quality

- ISO 9001: 2015 registered
- IEC 17025: 2017 accredited laboratories
- COA on every lot

PROPERTY	VALUE	UNITS	TEST METHOD
Melt Flow	17-25	g/10 min	ASTM D1238 / ISO 1133
Izod Impact Notched @ 23° C	1.8-2.8	Ft lbs/in	ASTM 256 / ISO 180/A
Tensile @ Yield	Report	psi	ASTM D638 / ISO 527-1/2
Flexural Modulus 0.05 in/min	Report	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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