

X-Pro® PP 4230



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	27-34	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



IMPORTANT: The following supersedes buyer documents. Seller makes NO WARRANTY, REPRESENTATION OR CONDITION OF ANY KIND, EXPRESS OR IMPLIED (INCLUDING NO WARRANTY OF MERCHANTABILITY OR FITNESS OF THE GOODS FOR ANY USE CONTEMPLATED BY BUYER) concerning the Goods and none shall be implied by law. Final determination of the suitability of the Goods for the use contemplated by Buyer is the sole responsibility of Buyer, and Seller shall in no way be responsible for the suitability of the Goods for any particular end use.