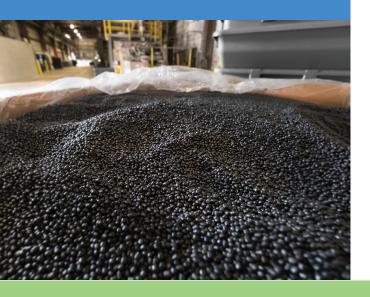
# X-Pro® PP 4620



## **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	4.5-7.5	Ft lbs/in	ASTM 256 / ISO 180/A
Tensile @ Yield	Report	psi	ASTM D638 / ISO 527-1/2
Flexural Modulus 0.05 in/min	120,000 min	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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