

# X-Pro<sup>®</sup> SP200

## P 3085



### OVERVIEW

- Automotive certification: General Motors, GM-GMP.PP.123
- 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: 2017 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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