

PRODUCT CODE	M04000626
PRODUCT DESCRIPTION	ECOSTAR PPH, %30 GLASS FIBER REINFORCED, BLACK

PHYSICAL				
PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
ASH CONTENT	750 °C±50 °C	ISO 3451	%	30 - 32
DENSITY	+23°C	ISO 1183	g/cm³	1,13 - 1,16
MELT FLOW INDEX	230 °C 2,16kg	ISO 1133	gr/10'	5 - 7
MOLDING SHRINKAGE	PARALLEL	ISO 294-4	%	0,20 - 0,40

MECHANICAL				
PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
YIELD STRENGTH	+23°C	ISO 527-2	MPa	80 - 90
TENSILE STRESS AT BREAK	+23°C	ISO 527-2	Mpa	80 - 90
TENSILE STRAIN AT BREAK	+23°C	ISO 527-2	%	2,50 - 3
TENSILE MODULUS	+23°C	ISO 527-2	MPa	6.300 - 6.700
FLEXURAL MODULUS	+23°C	ISO 178	MPa	6.300 6.700
IZOD IMPACT STRENGTH, NOTCHED	+23°C	ISO 180/1A	Kj/m²	8 - 12
CHARPY IMPACT STRENGTH, NOTCHED	+23°C	ISO 179/1eA	Kj/m²	8 12

THERMAL				
PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
HEAT DEFLECTION TEMPERATURE	0,45 MPa	ISO 75-2/B	°C	153 - 157
HEAT DEFLECTION TEMPERATURE	1,80 MPa	ISO 75-2/A	°C	138 - 142

INJECTION PROCESS		
PROPERTIES	UNITS	VALUE
PREDRYING TEMPERATURE	°C	80
PREDRYING TIME	Hour	1-2

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MELTING TEMPERATURE	°C	210-230
NOZZLE TEMPERATURE	°C	230
PRE-3 REGION TEMPERATURE	°C	200-240
MID-2 REGION TEMPERATURE	°C	200-240
AFT-1 REGION TEMPERATURE	°C	150-180
MOLD TEMPERATURE	°C	40-70
HOLD PRESSURE	MPa	50-100

Data are based on dry conditions.

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These values alone do not represent a sufficient basis for any part design. Colorants or other additives may cause significant variations in data values. Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure.

Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Call Customer Services for the appropriate Material Safety Data Sheets (MSDS) before attempting to process our products.