



A~Star Plastics Pte Ltd

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Company & GST Registration #: 201504765Z

Product Data Sheet

Material Type: POLYPROPYLENE COMPOSITE WITH 30% LONG GLASS FIBRES

Grade: PP-CP00IJ-LGF30

Colour: NATURAL

Application: For General Purpose Injection Molding

<u>Physical</u>	<u>Value</u>	<u>Unit</u>	<u>Test Method</u>
Density	1.10 - 1.13	g/cm ³	ASTM D792
Mold Shrinkage	0.2 - 0.4	%	ASTM D955
<u>Mechanical</u>	<u>Value</u>	<u>Unit</u>	<u>Test Method</u>
Tensile stress at yield, 5mm/min	113 - 118	MPa	ASTM D638
Tensile strain (elongation) at break, 5mm/min	> 1.5	%	ASTM D638
Izod impact notched, 23°C	33 - 38	kgf.cm/cm	ASTM D256
Izod impact un-notched	70 - 75	kgf.cm/cm	ASTM D4812
Flexural strength	148 - 153	MPa	ASTM D790
<u>Thermal</u>	<u>Value</u>	<u>Unit</u>	<u>Test Method</u>
Heat Deflection Temperature at 0.45 Mpa	158 - 160	°C	ASTM D648
Heat Deflection Temperature at 1.82 Mpa	155 - 157	°C	ASTM D648

Processing Condition

<u>Temperature</u>	<u>Value</u>	<u>Unit</u>
Drying Temperature	80	°C
Drying Time	2	Hour
Melt Temperature	220 - 250	°C
Rear Barrel Temperature	230 - 250	°C
Middle Barrel Temperature	230 - 250	°C
Front Barrel Temperature	220 - 240	°C
Nozzle Temperature	220 - 240	°C
Mould Temperature	50 - 60	°C

The information should only be used as a reference guide.

A~Star Plastics Pte Ltd makes no warranties of the product for any particular use or purpose.

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