TECHNICAL DATA SHEET

PRODUCT CODE:	**THERMOFIL PP F610B99 Black**
CATEGORY:	**ADVANCED ENGINEERING**

DESCRIPTION :	**30% glass fibre, medium flow, chemically coupled homopolymer polypropylene compound.**
APPROVALS :	**UL94 HB 1mm**
TYPICAL APPLICATIONS:	**Automotive and industrial fans**

Properties at 23°C	Test Method	Units	Value
Reinforcement Content	ISO 3451	%	30
Specific Gravity (SG)	ISO 1183		1.12
Melt Flow Index (MFI)	ISO 1133	g/10 minutes	6
Mould Shrinkage	Internal Method	%	0.2-1.0
Flammability Resistance	UL 94/1.0mm	-	HB
Tensile Strength	ISO 527	MPa	90
Elongation at Break	ISO 527	%	3
Tensile Modulus	ISO 527	MPa	6700
Flexural Strength	ISO 178	MPa	135
Flexural Modulus	ISO 178	MPa	6200
Izod Impact notched 23°C	ISO 180	KJ/m^2	11.5
Charpy Impact notched 23°C	ISO 179/1eA	KJ/m^2	10
Charpy Impact unnotched 23°C	ISO 179/1eU	KJ/m^2	45
Charpy Impact unnotched -30°C	ISO 179/1eU	KJ/m^2	50
Heat Distortion Temperature	ISO 75/0.45 MPa	°C	157
Heat Distortion Temperature	ISO 75/1.8 MPa	°C	150

Sumika Polymer Compounds
Sumitomo Chemical Group

Sumika Polymer Compounds (UK) Ltd.
28, New Lane, Havant Hampshire PO9 2NQ UK
Telephone : 00 44 (0) 23 92 48 63 50 Fax 00 44 (0) 23 92 47 23 88

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Registered in England No 2594313

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PRE-DRYING REQUIREMENTS

	Units	Values
Pre-Dried Ready For Use	–	Yes
Storage Life (unopened) @ 23°C/50%R.H	Months	6
Open Storage Time Before Pre-Drying Required	Hours	6
Pre-Drying Recommendation		3-4 Hours at 90°C

PROCESSING GUIDELINES

Processing Parameter	Units	Recommendation
Barrel Temperature Profile (Rear to Nozzle)	°C	200, 220, 230, 250
Injection Speed		Medium
Use of Back Pressure		Low
Tool Temperature Requirement	°C	30-60
Regrind Addition (Maximum)	% by Weight	10

SPECIALIST PROCESSING ADVICE IS AVAILABLE FROM THERMOFIL TECHNICAL DEPARTMENT

HEALTH & SAFETY DATA

	Units	Recommendation
Maximum Barrel Residence Time	Minutes	15
Maximum Barrel Temperature	°C	280
Spontaneous Ignition Temperature	°C	320
Disposal of Purgings and Melts		Cooled in Water to avoid fire

A separate Material Safety Data Sheet is also available

HANDLING RECOMMENDATIONS AND DETAILS

Packaging Code (Digit 8)	Pallet Size WxLxH(mm)	Overall Height (m)	Weight Per Pallet Net (Kg)	Description	2 Way or 4 Way Entry Pallets
F	1000x1200x120	2.0	1000	Octabin	2
J	1000x1200x120	1.1	500	Gallia Standard Octabin	2
S	1000x1200x120	1.5	1000	20-25Kg Bags	4

Issue No:	04
Date Issued:	3.06.19