TECHNICAL DATA SHEET

PRODUCT CODE:	**THERMOFIL HP F910X99 Black**
CATEGORY:	**ADVANCED ENGINEERING**

DESCRIPTION :	**50% High Performance Glass Coupled Polypropylene with outstanding Tensile strength, impact strength and stiffness. The grade has improved retention of stiffness and creep properties at elevated temperature.**
APPROVALS :	
TYPICAL APPLICATIONS:	**Automotive and industrial. Long fibre glass PP, Glass polyamide and Glass PBT replacement.**

Properties at 23°C	Test Method	Units	Value
Reinforcement Content	Internal Method	%	50
Specific Gravity (SG)	ISO 1183	-	1.35
Melt Flow Rate (MFR)	ISO 1133	g/10 minutes	3
Mould Shrinkage	Internal Method	%	0.1-1.1
Flammability Resistance	UL 94/3.2mm	-	HB
Tensile Strength	ISO 527	MPa	135
Elongation at Break	ISO 527	%	2.4
Tensile Modulus	ISO 527	GPa	12.6
Flexural Strength	ISO 178	MPa	190
Flexural Modulus	ISO 178	GPa	11.4
Izod Impact notched 23°C	ISO R180	KJ/m²	15
Charpy Impact notched 23°C	ISO 179/1eA	KJ/m²	10
Charpy Impact unnotched 23°C	ISO 179/1eU	KJ/m²	55
Charpy Impact notched -30°C	ISO 179/1eA	KJ/m²	7.5
Charpy Impact unnotched -30°C	ISO 179/1eU	KJ/m²	56
Heat Distortion Temperature	ISO 75/0.45 MPa	°C	163
Heat Distortion Temperature	ISO 75/1.8 MPa	°C	154

Sumika Polymer Compounds
Sumitomo Chemical Group

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PRODUCT CODE :	THERMOFIL PP F910X99

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, if required		3-4 Hours at 90°C

PROCESSING GUIDELINES

Processing Parameter	Units	Recommendation
Barrel Temperature Profile (Rear to Nozzle)	°C	200, 230, 240, 250
Injection Speed		Medium to Fast
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 W x L x H (mm)	Overall Height (m)	Weight Per Pallet Net (Kg)	Description	2 Way or 4 Way Entry Pallets
F	1000x1200x120	2.0	1000	Octabin	4
J	1000x1200x120	1.1	500	Half Octabin	4
S	1000x1200x120	1.5	1000	20-25Kg Bags	4

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