

# XPRO® PP 4920



## OVERVIEW:

- ♦ Polypropylene Copolymer, recycled, medium flow
- ♦ Processing—Injection Molding
- ♦ Application— General Purpose, Industrial, Housewares, Construction
- ♦ Color—General Purpose Black
- ♦ Low cost alternative to virgin resin with comparable quality and process ability.
- ♦ Quality: ISO 9001:2015 registered, IEC 17025: 2005 accredited laboratories, COA on every lot.

PROPERTY	VALUE	UNITS	TEST METHOD
Melt Flow	17-25	g/10 min	ASTM D1238 / ISO 1133
Izod Impact Notched @ 23° C	>8.5 NB	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	120,000 min	psi	ASTM D790 / ISO178

## 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 – 420°F		
Melt Temperature: 400°F – 440°F		
Mold Temperature: 80°F – 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 @ 180°F		

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