

XPRO® PP 4220



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	1.8-2.8	Ft lbs/in	ASTM 256 / ISO 180/A
Tensile @ Yield	Report	psi	ASTM D638 / ISO 527-1/2
Flexural Modulus 0.05 in/min	Report	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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