



Phone: (517) 295-4196 Fax: (517) 295-4918

Technical Data Sheet

LCA® PP20T15 Black

Polypropylene Talc Reinforced, Heat Stabilized, Lubricated

| Typical Compound Properties | Value / Measure | Test Methods |
|------------------------------|------------------------|--------------|
| Physical Properties | | |
| | English Units | |
| Density | 1.04 g/cm ³ | ASTM D-792 |
| Ash Content | 20 % | ASTM D-2584 |
| Melt Flow | 15 g/10 min. | ASTM D-1238 |
| Mechanical Properties | | |
| Izod Impact | 1.50 ft-lb/in | ISO 179 |
| Tensile Strength (Break) | 5,300 psi | ISO 527 |
| Flexural Modulus | 380,000 psi | ISO 178 |
| Thermal Properties | | |
| HDT 1.8 Mpa Unannealed | 162 °F | ISO 75 |
| Melt Temperature | 324 °F | ISO 11357 |

All tests are performed on dry as molded ASTM (ISO) test bars.

General Product Type Information

The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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| Typical Processing Conditions | | | |
|-------------------------------|-------------|---------------|----------|
| Process Variable | Description | Values | |
| Temperatures | | F | C |
| Barrel | Rear | 420 - 440 | |
| | Center | 430 - 450 | |
| | Front | 440 - 460 | |
| | Nozzle | 450 - 470 | |
| | Mold | 80-150 | |
| <hr/> | | | |
| Drying | | | |
| Type | | Dehumidifier | |
| Temperature | | 160°F - 170°F | |
| Time | | 2 Hours | |
| Max. % Moisture | | 0.20% | |
| <hr/> | | | |
| Special Requirements | | | |
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Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.