Auszug aus dem „TECHNICAL DATA SHEET" des Rohmaterialherstellers

Description

This PP type "… is a specially modified highly transparent random copolymer with medium melt flow. It is specially formulated for high speed injection moulding and contains antistatic and nucleating additives, allowing high demoulding temperature as well as reduced cooling time.

Products moulded from this PP-type are characterised by excellent transparency, good gloss, good impact strength in ambient temperature, relatively high stiffness, and good demoulding and antistatic properties.

Applications

This PP-type is designed for injection moulded houseware and closures needing very good transparency and good impact strength. It is also suitable for injection stretch blow moulding (ISBM).

Example of products successfully injection moulded with this PP-type are:

- Houseware containers
- Closures
- Appliances requiring good transparency
- Lids and pails

Physical Properties**

		Typical Value*	Unit	Test Method
Density		905	kg/m^3	IS01183
Melt Flow Rate	(230°C/2.16kg)	8	g/10 min	ISO 1133
Tensile Stress at Yield	(50 mm/min)	31	MPa	ISO 527-2
Tensile Strain at Yield	(50 mm/min)	11	%	ISO 527-2
Tensile Modulus	(1 mm/min)	1250	MPa	ISO 527-2
Hardness, Rockwell		90	R-scale	ISO 2039-2
Heat Deflection Temperature	(0.45 N/mm^2)	82	°C	ISO 75-2

* Data should not be used for specification work
** Values determined an injection moulded specimens acc. to ISO 1873-2 (97), based an 7 days conditioning time

Processing Guidelines

The grade can be processed an standard injection moulding machines. Following moulding parameters should be used as guidelines.

Melt temperature	210 - 260°C
Injection speed	High to medium high
Holding pressure	Minimum required to avoid sink marks (typical values are 200 - 500 bars) Mould
temperature	30 - 40°C
Shrinkage	1 - 2%, depending an wall thickness and moulding parameters.

Storage and Handling

The product should be stored in dry conditions at temperatures below 50°C and protected from UV-light. Improper storage can initiate degradation, which results in odour generation and colour changes and can have negative effects an the physical properties of the product.

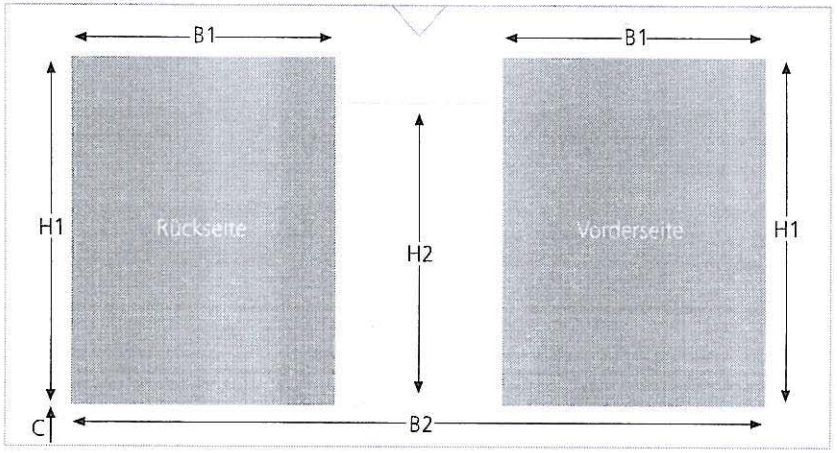
Safety

This PP-type is not classified as dangerous preparation.

Dust and fines from the product carry a risk of dust explosion. All equipment should be properly earthed.
Inhalation of dust should be avoided as it may cause irritation of the respiratory system.
Small amounts of fumes are generated during processing of the product. Proper ventilation is therefore required.

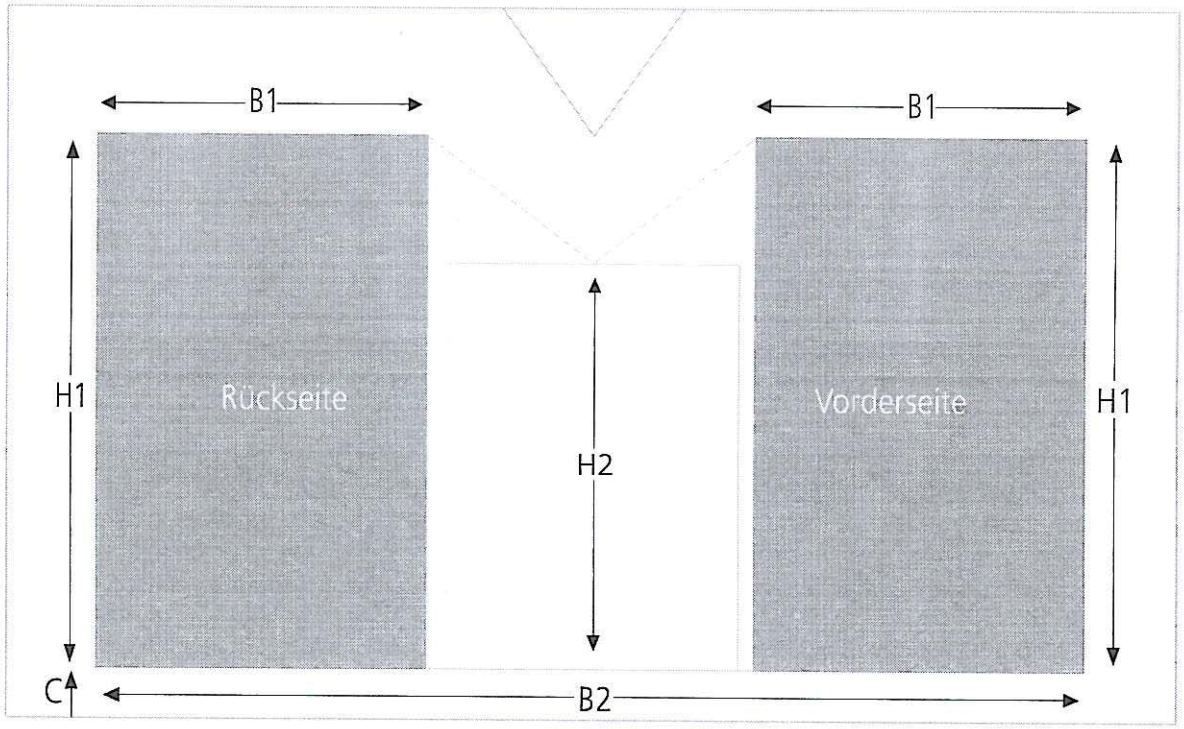
Recycling

The product is suitable for recycling using modern methods of shredding and cleaning. In-house production waste should be kept clean to facilitate direct recycling."

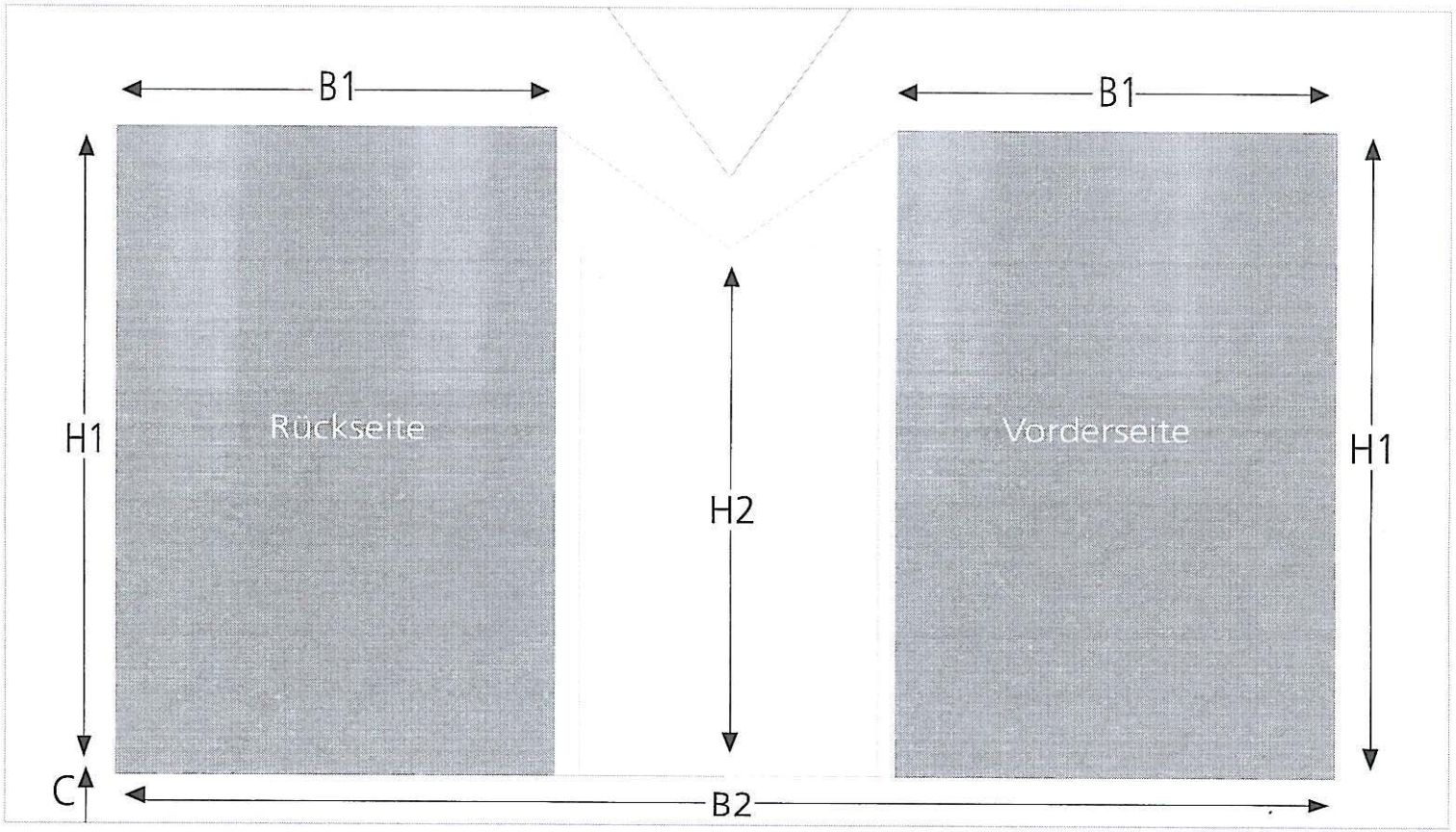


Art. Nr.	480941	481941	482941	483941	484941
Volumen	250 ml	500 ml	1.000 ml	2.000 ml	3.000 ml
Breite B1 (mm)	65	65	90	105	113
Höhe H1 (mm)	105	105	130	165	200
Höhe unter Ausguß H2 (mm)	80	80	105	145	165
Gesamte Breite B2 (mm)	195	195	250	305	335
Abstand Bodenunterkante C (mm)	10	10	12	17	17

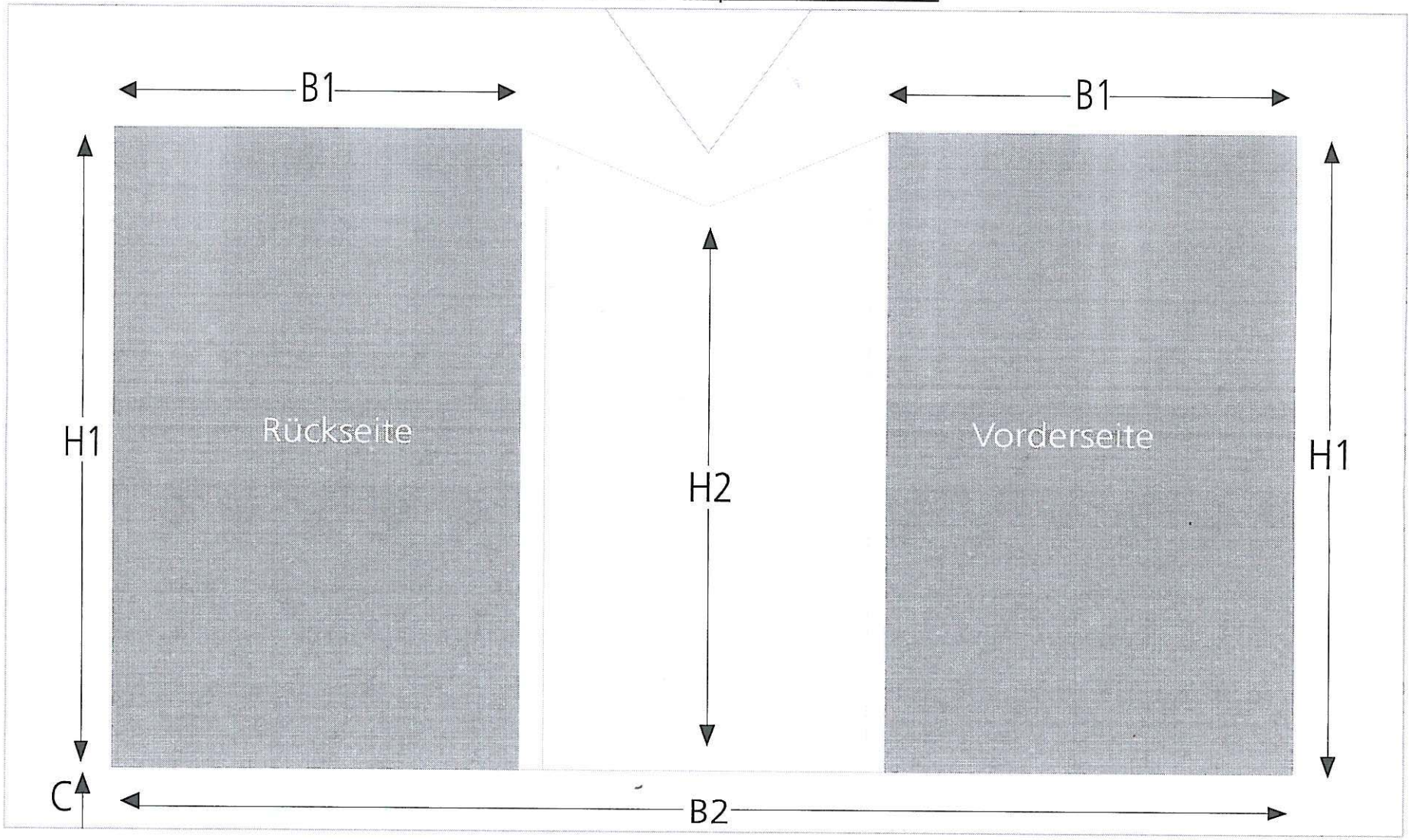
Messbecher, stapelbar, 500 ml



Messbecher, stapelbar, 1000 ml



Messbecher, stapelbar, 2000 ml



Messbecher, stapelbar, 3000 ml