

TECHNICAL DATA SHEET



PRODUCT CODE:	THERMOFIL PP F610B99 Black
CATEGORY:	ADVANCED ENGINEERING

DESCRIPTION :	30% glass fibre, medium flow, chemically coupled homopolymer polypropylene compound.
APPROVALS :	UL94 HB 1mm
TYPICAL APPLICATIONS:	Automotive and industrial fans

Properties at 23°C	Test Method	Units	Value
Reinforcement Content	ATL Method	%	30
Specific Gravity (SG)	ISO R1183		1.12
Melt Flow Index (MFI)	ISO R1133	g/10 minutes	6
Mould Shrinkage	ATL Method	%	0.2-1.0
Water Absorption	ISO 62	%	-
Flammability Resistance	UL 94/1.0mm	-	HB
Tensile Strength	ISO R527	MPa	90
Elongation at Break	ISO R527	%	2.5
Tensile Modulus	ISO R527	GPa	6.7
Flexural Strength	ISO 178	MPa	135
Flexural Modulus	ISO 178	GPa	6.2
Izod Impact notched 23°C	ISO R180	J/m	115
Charpy Impact notched 23°C	ISO 179/1eA	KJ/m ²	10
Charpy Impact unnotched 23°C	ISO 179/1eU	KJ/m ²	45
Charpy Impact unnotched -30°C	ISO 179/1eU	KJ/m ²	50
Heat Distortion Temperature	ISO 75/0.46 MPa	°C	157
Heat Distortion Temperature	ISO 75/1.81 MPa	°C	150



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Registered in England No 2594313

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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		3-4 Hours at 90°C

PROCESSING GUIDELINES

Processing Parameter	Units	Recommendation
Barrel Temperature Profile (Rear to Nozzle)	°C	200, 220, 230, 250
Injection Speed		Medium
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 WxLxH(mm)	Overall Height (m)	Maximum Stack Height (Pallets)	Weight Per Pallet Net (Kgs)	Suitable for Racking System Supported on 2 Sides	Description	2 Way or 4 Way Entry Pallets
F	1000x1200x120	2.0	2	1000	Yes	Octabin	2
J	1000x1200x120	1.1	3	500	Yes	Gallia Standard Octabin	2
S	1000x1200x120	1.5	2	1000	No	20-25Kg Bags	4

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