

PPC5GF2-Black

PP-GX20

Washington Penn Plastic Co., Inc.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	12	g/10min	ISO 1133
ASTM Data			
Melt Flow Index, MFI	12	g/10min	ASTM D 1238
Mechanical properties			
ISO Data			
Yield stress	72	MPa	ISO 527
Stress at break	64	MPa	ISO 527
Flexural modulus, 23°C	4100	MPa	ISO 178
Flexural strength	97	MPa	ISO 178
Charpy notched impact strength, +23°C	7	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	8	kJ/m ²	ISO 180/1A
Izod notched impact strength	6	kJ/m ²	ISO 180/1A
Temperature	-40	°C	-
ASTM Data			
Tensile Strength at Yield	71	MPa	ASTM D 638
Flexural Modulus	4100	MPa	ASTM D 790
Izod Impact notched, 1/8 in	81	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	148	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	160	°C	ISO 75-1/-2
ASTM Data			
DTUL @ 264 psi	150	°C	ASTM D 648
Other properties			
Density	1030	kg/m ³	ISO 1183
Density	1030	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	70 - 90	°C	-
Pre-drying - Time	1 - 2	h	-
Melt temperature	215 - 230	°C	-
Mold temperature	15 - 60	°C	-
Zone 1	205 - 220	°C	-
Zone 2	205 - 220	°C	-
Zone 3	210 - 220	°C	-
Zone 4	215 - 225	°C	-
Nozzle temperature	215 - 230	°C	-
Injection speed	19 - 64	mm/s	-
Injection pressure	4.1 - 9.7	MPa	-
Back pressure	0.52 - 0.85	MPa	-
Holding pressure	1 - 6.2	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Automotive

Delivery form

Black

Regional Availability

North America

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat