

Thermylene® P7-30FG-0684

Asahi Kasei Plastics North America Inc. - Polypropylene

General Information

General

Filler / Reinforcement	• Glass Fiber Reinforcement, 30% Filler by Weight
Additive	• Heat Stabilizer • UV Stabilizer
Features	• Heat Stabilized
Forms	• Pellets

ASTM and ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	0.0030	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	14000	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	790000	psi	ASTM D790
Flexural Strength	19000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.80	ft-lb/in	ASTM D256
Unnotched Izod Impact (73°F)	12.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	309	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating - UL (0.0625 in)	HB		UL 94

Additional Information

The value listed as Unnotched Izod Impact ASTM D256 was tested in accordance with ASTM D4812.

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	160	°F
Drying Time	2.0	hr
Suggested Max Moisture	0.15	%
Rear Temperature	380 to 400	°F
Middle Temperature	400 to 420	°F
Front Temperature	420 to 450	°F
Nozzle Temperature	430 to 460	°F
Mold Temperature	80.0 to 150	°F
Injection Pressure	12000 to 16000	psi
Injection Rate	Moderate-Fast	
Holding Pressure	10000 to 15000	psi
Back Pressure	50.0	psi

Injection Notes

Screw Rpm: Normal
Cooling Time: Short



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Screw Type: General

Slightly longer cycle times may be required to mold wall thicknesses over 1/4 inch.

Slightly higher injection pressures and mold temperatures may be required to mold wall thicknesses below 0.100 inches (2.54 mm).

Notes

¹ Typical properties: these are not to be construed as specifications.

