Ticona
Performance Driven Solutions™

CELSTRAN® PP-GF30-0553 Black | PP | Glass Reinforced

Description

Material code according to ISO 1043-1: PP

Polypropylene copolymer reinforced with 30weight percent long glass fibers. Low emission. The fibers are chemically coupled to the polypropylene matrix. The pellets are cylindrical and normally as well as the embedded fibers 10 mm long.

Parts molded of CELSTRAN have outstanding mechanical properties such as high strength and stiffness combined with high heat deflection. The notched impact strength is increased at elevated and low temperatures due to the fiber skeleton built in the parts. The long fiber reinforcement reduces creep significantly.

The very isotropic shrinkage in the molded parts minimizes the warpage.

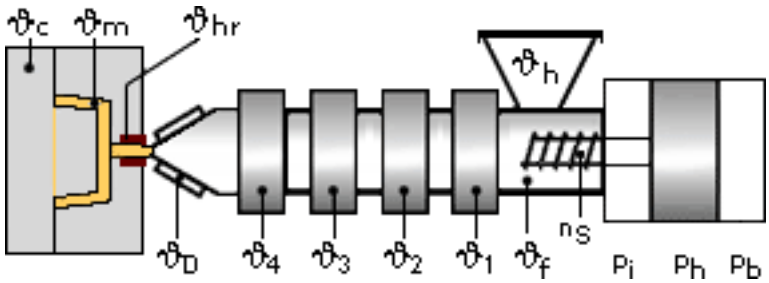
Complex parts can be manufactured with high reproducibility by injection molding.

Application field: Functionial/structural parts for automotive

Physical properties	Value	Unit	Test Standard
Density	**1120**	kg/m³	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	**6200**	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	**107**	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	**2.6**	%	ISO 527-2/1A
Flexural modulus (23°C)	**6050**	MPa	ISO 178
Flexural strength (23°C)	**164**	MPa	ISO 178
Notched impact strength (Izod) @ 23°C	**38.0**	kJ/m²	ISO 180/1A

Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.2%

It is normally not necessary to dry CELSTRAN PP. However, should there be surface moisture (condensate) on the molding compound as a result of incorrect storage, drying is required.

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The product can then be stored in standard conditions until processed.

Drying time: 4 h

Drying temperature: 90 - 100 °C

Temperature:

	ϑ Manifold	ϑ Mold	ϑ Melt	ϑ Nozzle	ϑ Zone4	ϑ Zone3	ϑ Zone2	ϑ Zone1	ϑ Feed
min (°C)	230	30	230	240	250	240	230	220	20
max (°C)	270	70	270	250	250	250	240	230	50

Pressure:

	Inj press	Hold press	Back pressure
min (bar)	600	400	0
max (bar)	1200	800	30

Speed:

Injection speed: slow

Screw speed

Screw diameter (mm)	16	25	40	55	75
Screw speed (RPM)	-	-	50	35	25