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Product Data Sheet & General Processing Conditions

RTP 199 X 118048 Polypropylene (PP) Long Glass Fiber Concentrate

RTP 199 X 118048 is a 60% Long Glass Fiber, Heat Stabilized concentrate designed for blending with natural polypropylene to make long glass fiber compounds with fiber content from 10% to 50%

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE		STANDARD
Primary Additive	60 %	
Density	1.47 g/cm ³	ISO 1183

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

GENERAL PROCESSING FOR INJECTION MOLDING

Injection Pressure	70 - 105 MPa
Injection Pressure	680 - 1030 bar
Melt Temperature	220 - 260 °C
Mold Temperature	35 - 65 °C
Drying	2 hrs @ 80 °C

PROCESSING NOTES

Use a reverse barrel profile. To maximize fiber length, the following injection barrel, screw, and tip designs should be followed. L/D ratio 16/1 - 22/1, Compression ratio 2:1, Flight depth 5 mm minimum, in feed section, Screw diameter 16.5 - 20 mm minimum, Compression section length 12 - 13 diameters, Check ring valve assembly - free flow type no restrictions, Nozzle orifice 6 mm diameter. Feed throat from hopper to machine must have sufficient opening to prevent bridging of long pellet composition.