Electrafil® 06004 BL117

Techmer Polymer Modifiers - *Polypropylene*

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Additive	• Antistatic
Features	• Antistatic
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.920		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.010 to 0.015	in/in	ASTM D955
Water Absorption (24 hr)	0.010	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	150000	psi	ASTM D638
Tensile Strength (Yield)	3000	psi	ASTM D638
Tensile Elongation (Break)	75	%	ASTM D638
Flexural Modulus	130000	psi	ASTM D790
Flexural Strength	3100	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (0.125 in)	10	ft·lb/in	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	80		ASTM D785
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+8 to 1.0E+12	ohms	ASTM D257
Volume Resistivity	1.0E+8 to 1.0E+12	ohms·cm	ASTM C611
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	1.0 to 2.0	hr
Rear Temperature	390 to 430	°F
Middle Temperature	390 to 430	°F
Front Temperature	390 to 430	°F
Nozzle Temperature	390 to 430	°F
Processing (Melt) Temp	390 to 430	°F
Mold Temperature	70 to 110	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 100	psi
Screw Speed	Moderate	

Notes

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