



PRODUCT INFORMATION

**NILENE P10 K30T**

Polypropylene homopolymer medium flow 30% talcum filled.

**ISO short Form** ISO 1043: PP-MD30 Pellets

**Key Features**

- Designed for injection moulding applications
- Mineral filled

**Availability**

- YT: laser printable
- S: heat stabilized
- AT: antistatic
- L: UV stabilized
- D: detergent stabilized
- All colours

**Process**

- INJECTION MOULDING

**Application**

- General purpose applications

Property	Method	Unit	Value	Condition	State
<b>ELECTRICAL</b>					
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	> 600		
<b>PHYSICAL</b>					
Density (+23°C)	ISO 1183	g/cm <sup>3</sup>	1,14		
Filler content	ISO 3451	%	30	600°C - 1 h	
Granule Humidity	Internal method	%	0,05		
Mould Shrinkage (Parallel)	Internal method	%	1,1		
Mould Shrinkage (Normal)	Internal method	%	1,1		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	10	230°C - 2,16 kg	
<b>MECHANICAL</b>					
Tensile Modulus	ISO 527-1,2	MPa	3150	Speed 1 mm/min	
Tensile Yield Strength	ISO 527-1,2	MPa	35	Speed 50 mm/min	
Elongation at Break	ISO 527-1,2	%	35	Speed 50 mm/min	



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Flexural Modulus	ISO 178	MPa	3000	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	35	+23°C

**THERMAL**

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	155
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	95
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	80
Deflection Temperature 0,45 MPa (HDT B)	ISO 75B	°C	125

**FLAMMABILITY**

Flame Behaviour (1,6 mm)	UL94	Class	HB	UL approved
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	650	
Oxygen index	ASTM D2863	%	21	

**INJECTION MOULDING**

	Value
Drying Temperature (Desiccant Dryer)	70 - 80°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Re grind	< 10%
Melt Temperature	180 - 220°C
Feed Temperature	150°C
Rear Temperature	170°C
Middle Temperature	190°C
Front Temperature	200°C
Nozzle Temperature	210°C
Mould Temperature	30 - 70°C
Injection Rate	Medium to fast
Injection Pressure	50 - 120 Mpa
Packing Pressure	30 - 100 Mpa
Back Pressure	0,5 - 3 Mpa
Screw Revolving Speed	< 300 mm/sec
Cushion	< 5 mm
Vent Depth	0,05 mm



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**Notes** It is normally not necessary to dry NILENE compounds, however should there be surface moisture (condensate) on the moulding compound as a result of incorrect storage, drying process is required. NILENE must be stored indoors at a temperature below 40°C avoiding humidity and direct sunlight as well. NILENE can be processed on a standard injection moulding unit. A general purpose metering screw is recommended with a zone distribution of 40% feed, 40% transition and 20% metering. When the heating cylinder is completely purged of NILENE material the machine may be shut down.

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