PRODUCT INFORMATION

NILENE P25 K25BE

Polypropylene homopolymer 25% barium sulphate filled, high flow.

ISO short ISO 1043: PP-MD25
Form Pellets

Key Features

- Designed for injection moulding applications
- High flow
- Mineral filled
- High density
- Good surface aspect

Availability

- YT: laser printable
- S2: high heat stabilized
- S: heat stabilized
- AT: antistatic
- L: UV stabilized
- D: detergent stabilized
- All colours

Process

- INJECTION MOULDING

Application

- Household
- General purpose applications

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	600		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,13		
Filler content	ISO 3451	%	25	600°C - 1h	
Granule Humidity	Internal method	%	0,05		
Mould Shrinkage (Parallel)	Internal method	%	0,9 - 1,1		
Mould Shrinkage (Normal)	Internal method	%	0,9 - 1,1		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	25	230°C - 2,16 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	2100	Speed 1 mm/min	

PRODUCT INFORMATION

NILENE P25 K25BE

Tensile Yield Strength	ISO 527-1,2	MPa	30	Speed 50 mm/min
Elongation at Break	ISO 527-1,2	%	40	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	2000	Speed 1 mm/min
IZOD Notched Impact (+23°C)	ASTM D256	J/m	30	
THERMAL				
Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	155	
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	90	
FLAMMABILITY				
Flame Behaviour (3,2 mm)	UL94	Class	HB	
Oxigen index	ASTM D2863	%	21	

INJECTION MOULDING	Value
Drying Temperature (Circulating Air Oven)	70 - 90°C
Drying Temperature (Desiccant Dryer)	70 - 90°C
Drying Time (Circulating Air Oven)	3 - 5 hours
Drying Time (Desiccant Dryer)	0,5 - 2,5 hours
Suggested Max Moisture	0,2%
Suggested Max Regrind	< 10%
Melt Temperature	190 - 230°C
Feed Temperature	50°C
Rear Temperature	170°C
Middle Temperature	190°C
Front Temperature	200°C
Nozzle Temperature	220°C
Mould Temperature	40 - 60°C
Injection Rate	50 - 150 mm/sec
Back Pressure	0,3 - 0,5 Mpa
Screw Revolving Speed	50 - 100 rpm
Cushion	3 - 6 mm
Vent Depth	0,05 mm

PRODUCT INFORMATION

NILENE P25 K25BE

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.