



PRODUCT INFORMATION

**NILENE P6 K25VA**

Polypropylene homopolymer 25% glass fibres reinforced chemically coupled, medium flow, good mechanical properties.

**ISO short Form** ISO 1043: PP-GF25 Pellets

**Key Features**

- Designed for injection moulding applications
- Glass fibres reinforced
- Good flowability

**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>					
Dielectric Strength	IEC 60243-1	kV/mm	25		
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	>600		
<b>PHYSICAL</b>					
Density (+23°C)	ISO 1183	g/cm <sup>3</sup>	1,08		
Filler content	ISO 3451	%	25	600°C - 1h	
Water Absorption (24h / +23°C)	ISO 62	%	0,2		
Mould Shrinkage (Parallel)	Internal method	%	0,25-0,45		
Mould Shrinkage (Normal)	Internal method	%	0,75-0,95		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	6	230°C - 2,16 kg	
<b>MECHANICAL</b>					
Tensile Modulus	ISO 527-1,2	MPa	5000	Speed 1 mm/min	
Elongation at Break	ISO 527-1,2	%	4,2	Speed 50 mm/min	



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Tensile Break Strength	ISO 527-1,2	MPa	80	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	4800	Speed 1 mm/min
Flexural Break Strength	ISO 178	MPa	100	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	90	+23°C
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m <sup>2</sup>	6,5	

**THERMAL**

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	145	
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	128	
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	125	

**FLAMMABILITY**

Flame Behaviour (1,6 mm)	UL94	Class	HB	
Burning Rate (US-FMVSS 302)	ISO 3795	mm/min	<100	Thickness 2 mm
Oxygen index	ASTM D2863	%	20	

**INJECTION MOULDING**

	Value
Drying Temperature (Circulating Air Oven)	80 - 100°C
Drying Temperature (Desiccant Dryer)	80 - 100°C
Drying Time (Circulating Air Oven)	3 - 6 hours
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	0,2%
Suggested Max Re grind	< 10%
Melt Temperature	220 - 250°C
Feed Temperature	50°C
Rear Temperature	200°C
Middle Temperature	220°C
Front Temperature	230°C
Nozzle Temperature	240°C
Mould Temperature	40 - 60°C
Injection Rate	50 - 150 mm/sec
Injection Pressure	60 - 120 Mpa
Packing Pressure	30 - 80 Mpa



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Back Pressure	As low as possible (<0,5 MPa)
Screw Revolving Speed	30 - 80 rpm
Cushion	5 - 8 mm
Vent Depth	0,05 mm

**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.