



PRODUCT INFORMATION

NILFLEX 14 K10T

Polypropylene copolymer high flow 10% mineral filled, high impact, good surface appearance.

ISO short Form ISO 1043: PP-MD10 Pellets

Key Features

- Improved impact resistance
- Designed for injection moulding applications
- Mineral filled
- Good surface aspect

Availability

- YT: laser printable
- S: heat stabilized
- L: UV stabilized
- All colours

Process

- INJECTION MOULDING

Application

- Furniture
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
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ELECTRICAL

Tracking Resistance (CTI - Method A)	IEC 60112	Volt	600		
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PHYSICAL

Density (+23°C)	ISO 1183	g/cm ³	0,99		
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Water Absorption (24h / +23°C)	ISO 62	%	0,05		
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Mould Shrinkage (Parallel)	Internal method	%	1,1-1,3		
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Mould Shrinkage (Normal)	Internal method	%	1,1-1,3		
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Melt Flow Rate (MFR)	ISO 1133	g/10 min	14	230°C - 2,16 kg	
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MECHANICAL

Tensile Yield Strength	ISO 527-1,2	MPa	25	Speed 50 mm/min	
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Elongation at Break	ISO 527-1,2	%	>100	Speed 50 mm/min	
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Flexural Modulus	ISO 178	MPa	1350	Speed 1 mm/min	
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IZOD Notched Impact	ASTM D256	J/m	400	+23°C
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THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	152
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	60
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	52
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K ⁻¹	6X10exp(-5)

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	HB
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INJECTION MOULDING

Value

Drying Time (Desiccant Dryer)	2 hours
Melt Temperature	190 - 230°C
Feed Temperature	150°C
Rear Temperature	180°C
Middle Temperature	190°C
Front Temperature	200°C
Nozzle Temperature	210°C
Mould Temperature	40 - 60°C
Injection Rate	Medium

Notes

It is normally not necessary to dry NILFLEX compounds, however should there be surface moisture (condensate) on the moulding compound as a result of incorrect storage, drying process is required. NILFLEX must be stored indoors at a temperature below 40°C avoiding humidity and direct sunlight as well. NILFLEX 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 NILFLEX material the machine may be shut down.