PRODUCT INFORMATION

NILFLEX 14 K15TE

Polypropylene copolymer high flow 15% mineral filled, high impact, good surface appearance.

ISO short ISO 1043: PP-MD15
Form Pellets

Key Features

- Designed for injection moulding applications
- Mineral filled
- Good surface aspect

Availability

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

Process

- INJECTION MOULDING

Application

- Furniture
- Automotive

Property	Method	Unit	Value	Condition	State
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,01		
Filler content	ISO 3451	%	15	600°C - 1h	
Water Absorption (24h / +23°C)	ISO 62	%	0,02		
Mould Shrinkage (Parallel)	Internal method	%	1,0 - 1,4		
Mould Shrinkage (Normal)	Internal method	%	1,0 - 1,4		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	14	230°C - 2,16 kg	
MECHANICAL					
Tensile Yield Strength	ISO 527-1,2	MPa	30	Speed 50 mm/min	
Elongation at Break	ISO 527-1,2	%	35	Speed 50 mm/min	
Flexural Modulus	ISO 178	MPa	1750	Speed 1 mm/min	
IZOD Notched Impact (+23°C)	ASTM D256	J/m	180		

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THERMAL				
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	55	50°C/h

FLAMMABILITY			
Flame Behaviour (1,6 mm)	UL94	Class	HB

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.