



PRODUCT INFORMATION

**NILFLEX 15 K30TC**

Polypropylene copolymer high flow 30% mineral filled, high impact, good surface appearance.

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

**Key Features**

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

**Availability**

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

**Process**

- INJECTION MOULDING

**Application**

- Furniture
- Automotive

Property	Method	Unit	Value	Condition	State
<b>PHYSICAL</b>					
Density (+23°C)	ISO 1183	g/cm <sup>3</sup>	1,12		
Water Absorption (24h / +23°C)	ISO 62	%	0,02		
Mould Shrinkage (Parallel)	Internal method	%	0,8 - 1,3	23°C - 3,2 mm	
Mould Shrinkage (Normal)	Internal method	%	0,8 - 1,3	23°C - 3,2 mm	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	15	230°C - 2,16 kg	
<b>MECHANICAL</b>					
Tensile Yield Strength	ISO 527-1,2	MPa	25	Speed 50 mm/min	
Elongation at Break	ISO 527-1,2	%	50	Speed 50 mm/min	
Flexural Modulus	ISO 178	MPa	1300	Speed 1 mm/min	
IZOD Notched Impact	ASTM D256	J/m	120	+23°C	
IZOD Unnotched Impact	ASTM D256	J/m	70	0°C	
<b>THERMAL</b>					



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Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	65	50°C/h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	60	120°C/h

**FLAMMABILITY**

Flame Behaviour (1,6 mm)	UL94	Class	HB
Flame Behaviour (3,2 mm)	UL94	Class	HB

**INJECTION MOULDING**

	<b>Value</b>
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.