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POLYPROPYLENE

OCTOBER 2014 REV. 1 (61056)

ET280

POLYPROPYLENE COMPOUND 20 % MINERAL FILLED

DESCRIPTION

ET280 *is a natural 20 % mineral filled polypropylene compound intended for injection moulding.*

ET280 *has been developed especially for automotive interior parts that require excellent balance between the impact strength and stiffness.*

The product is available in natural (**ET280**) *and black* (**ET280 - 8229**) *but other colours can be provided on request.*

APPLICATIONS

- *Consoles*
- *Door panels and pockets*
- *Handles*

PHYSICAL PROPERTIES[1)]

	Typical Value*	Unit	Test Method
Density	1050	Kg/m^3	ISO 1183
Melt Flow Rate (230°C/2.16 Kg)	13	g/10 min.	ISO 1133
Tensile stress at yield (50 mm/min)	29	MPa	ISO 527-2
Tensile Strain at yield (50 mm/min)	6	%	ISO 527-2
Flexural modulus (2 mm/min)	2400	MPa	ISO 178
Charpy Impact strength (notched, +23°C)	7	KJ/m^2	ISO 179/1eA
Charpy Impact strength (notched, -20°C)	3	KJ/m^2	ISO 179/1eA
Charpy Impact strength (unnotched, +23°C)	55	KJ/m^2	ISO 179/1eU
Charpy Impact strength (unnotched, -20°C)	26	KJ/m^2	ISO 179/1eU
Heat Deflection Temp HDT (0.45 N/mm^2)	116	°C	ISO 75-2
Heat Deflection Temp HDT (1.80 N/mm^2)	69	°C	ISO 75-2
Vicat softening temperature (A 10 N)	154	°C	ISO 306
Vicat softening temperature (B 50 N)	75	°C	ISO 306
Mould shrinkage	0,9 - 1,3	%	-
Flammability	HB	-	UL 94

1): Vales determined on standard injection moulded specimens conditioned at 23°C and 50% relative humidity.

*** : Data should not be used for specification work.**

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PROCESSING

ET280 *is easy to process with standard injection moulding machines. Following moulding parameters should be used as guidelines:*

Melt temperature:	210 - 260°C
Injection speed:	medium
Hold-on pressure:	50 – 70 of injection pressure
Mould temperature:	30 - 50°C
Pre-dry (recommended):	3 hours at 80°C

STORAGE AND HANDLING

ET280 *should be stored in dry conditions at temperatures below 50°C and protected from UV-light.*

Improper storage can initiate degradation with resulting odour generation and colour changes.

SAFETY

ET280 *is not classified as a dangerous product.*

Dust and fines from the product carry a risk for dust explosion. All equipment should be properly earthed.

Inhalation of dust may irritate the respiratory system and should be avoided.

During processing of the product small amounts of fumes are generated, which require proper ventilation.

RECYCLING

The product is suitable for recycling using modern methods of shredding and cleaning. In-house production waste should be kept clean to facilitate direct recycling.

A Safety Data Sheet is available on request. Please contact your AD majoris representative for more details on various aspects of safety, recovery and disposal of the product.

The recommendations and data given are based on our experience to date, but no liability can be assumed in connection with their usage.