

Properties

PG4N1

Glass fiber-reinforced PP compound (GF20%, UL94 HB)

Properties	Test methods	Test conditions	Units	
Melt mass-flow rate	ISO 1133	230 deg C/2.16kg	g/10min	6
Mold shrinkage	ASTM D955	-	%	0.5-0.8
Tensile strength	ISO 527	-	MPa	70
Flexural strength	ISO 178	-	MPa	100
Flexural modulus	ISO 178	-	MPa	4200
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	10
Rockwell hardness	ISO 2039	-	-	R110
Deflection temperature under load	ISO 75	0.45MPa	deg C	160
Flammability	UL94	-	-	HB
Density	ISO 1183	-	g/cm3	1.04

Note

- Values are typical, not quality assured.
- UL recognition File No. of Daicel Polymer is E47773.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
3-5hrs 80-120deg C	180-230	180-230	160-210	140-190	70-90	5-20	40-60

[Alert Notes]

*Preliminary drying under the conditions above is required, although PP resin hardly absorbs moisture.