

Properties

PNAK2

Flame-retardant PP compound (UL94 V-0)

Properties	Test methods	Test conditions	Units	
Melt mass-flow rate	ISO 1133	230 deg C/2.16kg	g/10min	11
Mold shrinkage	ASTM D955	-	%	1.5-1.8
Tensile strength	ISO 527	-	MPa	32
Flexural strength	ISO 178	-	MPa	48
Flexural modulus	ISO 178	-	MPa	1900
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	3
Rockwell hardness	ISO 2039	-	-	R97
Deflection temperature under load	ISO 75	0.45MPa	deg C	110
Flammability	UL94	-	-	V-0/0.75mm
Density	ISO 1183	-	g/cm3	1.07

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 80-90deg C	180-220	180-220	160-200	140-180	70-90	5-20	40-60

[Alert Notes]

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