Optipro TPO2068-20M

The Materials Group - *Compounded Polypropylene*

General Information

General			
Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Mineral, 20% Filler by Weight		
Features	• Excellent Processability	• High Flow	
Appearance	• Black	• Colors Available	• Natural Color
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.03 to 1.07		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	> 10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	9.0E-3 to 0.011	in/in	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	> 2760	psi	ASTM D638
Tensile Elongation (Break)	> 18	%	ASTM D638
Flexural Modulus	> 218000	psi	ASTM D790
Flexural Strength	> 4790	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact	2.8	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	> 248	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176 to 212	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	338 to 374	°F
Middle Temperature	374 to 410	°F
Front Temperature	374 to 410	°F
Processing (Melt) Temp	356 to 428	°F
Mold Temperature	104 to 158	°F

Notes

[1] Typical properties: these are not to be construed as specifications.