

PRODUCT DATA SHEET

LEXPRENE RP-150

Description

Lexprene RP-150 is Co-PP using r-PP compound with high flow & high stiffness stability.

The product is available in black color pellet form which have good melt flow rate for easy injection molding , specifically design to provide an excellent balance of stiffness and impact for automobile parts.

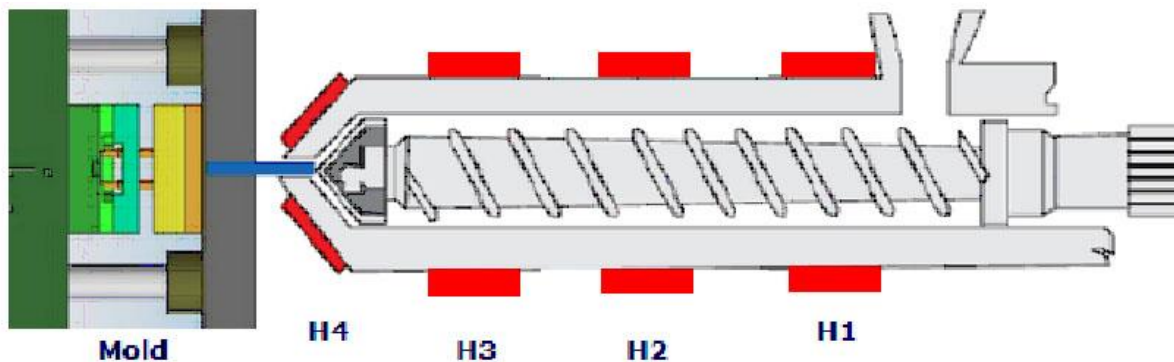
This compounded PP can be supplied in black or pre-colored.

Suggested molding conditions: melt temperature 210-230°C, mold temperature 40-80°C.

Application : Vehicle part, Engine under cover etc..

General properties	H Company Spec.	Unit	Test method	RP-150 value
Density	0.90 ~ 0.93	g/cm ³	ISO 1183	0.92
Melt flow rate , @230°C, 2.16kgf	10 ↑	g / 10min	ISO 1133	15
Shrink-rate as-molded	-	-/1,000	Polylex method	15~ 16 / 1,000
Mechanical properties				
Izod impact strength, 4mm notched @+23°C	8 ↑	KJ/m ²	ISO 180	9.0
Izod impact strength, 4mm notched @-30°C	2.5 ↑	KJ/m ²	ISO 180	3.0
Tensile stress, @ yield, 50 mm/min	26 ↑	MPa	ISO 527-1.-2	27
Tensile strain, @ yield, 50 mm/min	80 ↑	%	ISO 527-1.-2	100
Flexural strength, @yield, 10mm/min	30 ↑	MPa	ISO 178	31
Flexural modulus, @yield, 10mm/min	1,090↑	MPa	ISO 178	1,200
Thermal properties				
Deflection temperature @ 0.45MPa, 4mm	100 ↑	°C	ISO 75-2	105

PROCESSING GUIDE of RP-150



Parameter Injection Molding		Value	Unit
Drying Temperature		°C	75 ~ 85
Drying Time		Hr	2 ~ 3
Maximum moisture content		%	0.02
Melt Temperature		°C	210 ~ 230
Cylinder Temperature	H4	°C	210 ~ 230
	H3	°C	210 ~ 230
	H2	°C	200 ~ 220
	H1	°C	190 ~ 200
Mold Temperature		°C	40 ~ 80
Back Pressure		MPa	0.3 ~ 0.7
Screw rotating speed		rpm	20 ~ 100