



GLASS REINFORCED POLYPROPYLENE

SINPOLENE GPP 1630

Technical data sheet (Dec'05)

SINPOLENE GPP1630 is a premium glass reinforced polypropylene moulding compound. It has a good balance of mechanical and physical properties together with good resistance to both chemical and creep.

APPLICATIONS

Automotive Components, Appliances' Housings etc.

TYPICAL PROPERTY

PROPERTY	ASTM METHOD	UNITS	TYPICAL VALUES
<u>MECHANICAL</u>			
Tensile Yield strength	D-638	MPa	95
Elongation @ Break	D-638	%	13
Flexural Strength	D-790	MPa	125
Flexural Modulus	D-790	MPa	6000
Notched Izod Impact Strength @ 23°C	D-256	J/m	90
<u>THERMAL</u>			
Heat Distortion Temp (3.2mm) @ 0.45MPa	D-648	°C	160
@1.81 MPa		°C	149
<u>PHYSICAL</u>			
Specific Gravity	D-792	-	1.13
Melt Flow Index	D-1238	g/10min	7.5
<u>PROCESSING</u>			
Mold Shrinkage**	D-955		
Flow Direction		%	0.4
Transverse Direction		%	0.6

** The mould shrinkage values presented here are solely based on laboratory moulded test bars. Users are strongly advised to conduct their own evaluation of tooling values as variable factors such as part thickness & configuration, and moulding conditions could affect the part shrinkage.

MATERIAL HANDLING OF GPP1630

Processing Condition

Pre-drying

For better surface finish, it is recommended to pre-dry before moulding process. Typical drying condition is 2 to 3 hours at 100 - 110°C depending on the degree of exposure to moisture.

Temperature Setting

SINPOLENE GPP1630 can be processed on most types of injection moulding machines with typical setting of:

Rear Cylinder Temperature	: 205 – 210°C
Middle Cylinder Temperature	: 210 – 215°C
Front Cylinder Temperature	: 215 – 220°C
Nozzle Temperature	: 220 – 225°C

Mould Temperature

The optimum mould temperature will depend upon the size and complexity of the moulding. Mould temperatures are usually between 40 - 60°C with higher temperatures producing a better surface finish.

The information presented in this data sheet is believed to be reliable and accurate. Since the conditions under which these materials are used are beyond our control, all suggestions and recommendations are made without guarantee. Values presented are typical and intended to serve as guides only. These values should not be considered as limits to the specifications.

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