



Product Data Sheet & General Processing Conditions

RTP 199 X 155673 B Polypropylene (PP) Cellulose Fiber 30% Renewable Resource Content* Post-Consumer Recycled Content Preliminary Datasheet

*Based on % of total compound weight

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.05	1.05	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0020 - 0.0080 in/in	0.20 - 0.80 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.8 ft-lbs/in	43 J/m	D 256
unnotched 1/8 in (3.2 mm) section	6.0 ft-lbs/in	320 J/m	D 4812
Tensile Strength	5000 psi	34 MPa	D 638
Tensile Elongation	3.0 %	3.0 %	D 638
Tensile Modulus	0.50 x 10 ⁶ psi	3448 MPa	D 638
Flexural Strength	9000 psi	62 MPa	D 790
Flexural Modulus	0.50 x 10 ⁶ psi	3448 MPa	D 790

THERMAL

Deflection Temperature @ 66 psi (455 kPa)	280 °F	138 °C	D 648
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PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	340 - 400 °F	171 - 204 °C
Mold Temperature	90 - 150 °F	32 - 66 °C
Drying	4 hrs @ 175 °F	4 hrs @ 79 °C

PROCESSING NOTES

Process at lowest temperature possible to prevent fiber degradation. Do not exceed 400 degrees Fahrenheit

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This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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