

GRADE: APARPRENE 070 AB

Technical Data Sheet

FEATURES			PROCESS	COMPATIBILITY
UV Stabilized	High flow	Color: Black	Injection/Extrusion	PP
PROPERTIES	UNITS	STANDARDS	AVERAGE VALUES	
Hardness Shore A	Nos.	ASTMD 2240	70 ± 5	
Density	g/cc	ISO 1183	1.060	
Tensile strength at break	N/mm ²	ISO 37	7.8	
Elongation at break	%	ISO 37	720	
Tear strength	kN/m	ISO 34	39	
Modulus at 100% Elongation	N/mm ²	ISO 37	2	

GUIDELINES FOR INJECTION MOULDING

Drying		Recommended for drying at 70 to 80 ° C for one hour for better results
Barrel temperature °C	Feed Zone	150 +/- 10
	Transition	170 +/- 10
	Front	185 +/- 10
	Nozzle	195 +/- 10
Melt temperature °C		200 +/- 10
Back Pressure (bar)		10 +/- 5
Injection Speed (mm/s)		70 +/- 10 % max
Holding Pressure (bar)		30 +/- 10 % of Max injection Pressure
Mold Temperature °C		40 +/- 20
Hot runner °C		200 +/- 10

GUIDELINES FOR EXTRUSION

Drying		Recommended for drying at 70 to 80 ° C for one hour for better results
Barrel temperature °C	Feed Zone	150 +/- 10
	Zone 1	170 +/- 10
	Zone 2	180 +/- 10
	Adaptator/Die	190 +/- 10
Melt temperature °C		190 +/- 10

HEALTH AND ENVIRONMENTAL INFORMATION/HANDLING PRECAUTIONS

Please refer to material safety data sheets (MSDS) and contact the sales representative or Distributor of Apar Industries Ltd

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