

GRADE: APARPRENE 085 AN

Technical Data Sheet

FEATURES			PROCESS	COMPATIBILITY
UV Stabilized	High flow	Color: Natural	Injection/Extrusion	PP
PROPERTIES		UNITS	STANDARDS	AVERAGE VALUES
Hardness Shore A		Nos.	ASTMD 2240	85 ± 5
Density		g/cc	ISO 1183	1.090
Tensile strength at break		N/mm ²	ISO 37	8.8
Elongation at break		%	ISO 37	750
Tear strength		kN/m	ISO 34	45
Modulus at 100% Elongation		N/mm ²	ISO 37	3.5

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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