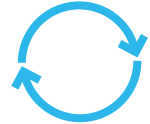


TPRR 450

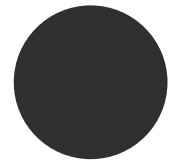
Specifications

- Adapted for Injection Moulding
- Good replacement for polyolefin materials
- Pellets with Black Colour

In short



Recycled
Thermoplastic
Polyolefins



Black Colour
Pellets

	Hardness	Tensile Strength	Tensile Modulus	Elongation at Yield	Charpy Impact Strength	Melt Flow Rate 230 °C 2.16 kg
	ISO 868 Shore D	ISO 527 MPa	ISO 527 MPa	ISO 527 %	ISO 179/1eA kJ/m ²	ISO 1133 g/10min
TPRR 450	48	11	340	23	21	7

Injection moulding guide

For TPRR 450

Pre-drying is recommended for 2-4 h at 80 °C.

Melt Temperature: Injection moulding is recommended with 200-240 °C melt temperature.

Mould Temperature: 40-80 °C recommended.

Screw Speed: Peripheral screw speeds of 0.6-0.75 m/s is recommended. Measure the melt temperature to ensure that the desired value is obtained and adjust if needed.

Clamping Force: A clamping force of 3.5 kN/cm² projected area of the moulded part is generally sufficient.

Cooling Time: Adapt the cooling time according to the thickest section of the moulded part. A general recommendation up to 3 mm thickness is to use the following assumption:

Cooling time = 2.5 * (max part thickness)²

Legal disclaimer

Legal disclaimer and notice to users

This document or publication was printed based on Ecorub's present state of knowledge, and Ecorub undertakes no obligation to update it. Because conditions of product use are outside Ecorub's control, Ecorub makes no warranties, expressed or implied, and assumes no liability in connection with any use of this information. Nothing herein is intended as a license to operate under or a recommendation to infringe any patents.

The values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values. Properties of moulded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their product use.

To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication. Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards. We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use and entrust the handling of such material to adequately trained personnel only. The products mentioned herein are not intended for use in medical or dental implants.

Ecorub®, registered design and trademarks identified herein with ®, TM, SM, unless otherwise noted, are trademarks of Ecorub AB.

© 2024 Ecorub AB. All rights reserved. Published January 2024.