

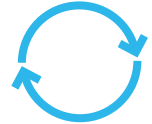
# TPRR 550

## Specifications

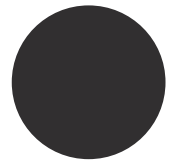
Impact Modified Polypropylene Copolymer

- Adapted for Injection Moulding
- Post Industrial Recycled Material
- 88 % Recycled Content
- Pellets with Black Colour

In short



Recycled Thermoplastic Polypropylene



Black Colour Pellets

**88%**

Amount of recycled content

	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 <sup>2</sup>	ISO 1133 g/10min
<b>TPRR 550</b>	59	17	650	13	6	12

# Injection moulding guide

## For TPRR 550

**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/cm<sup>2</sup> 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) <sup>2</sup>

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