POLYfill
PPH T8020

polykemi
BRINGS OUT THE BEST IN PLASTICS

Fillers: Mineral Talc

Feature	Value	Unit	Testmethod
PHYSICAL PROPERTIES			
Density	1,04	g/cm³	ISO 1183
MFI at 230°C/2,16kg	8	g/10min	ISO 1133
MECHANICAL PROPERTIES			
Flexural modulus at +23°C	2800	MPa	ISO 178
Maximum flexural strength	50	MPa	ISO 178
Maximum tensile strength	32	MPa	ISO 527-2
Elongation at break	--	%	ISO 527-2
Elongation at yield	6	%	ISO 527-2
IMPACT PROPERTIES			
Impact strength	--	--	--
Notched Charpy at +23°C	4	kJ/m²	ISO 179
Notched Charpy at -20°C	2,5	kJ/m²	ISO 179
Unnotched Charpy at +23°C	--	kJ/m²	ISO 179
Unnotched Charpy at -20°C	--	kJ/m²	ISO 179
THERMAL PROPERTIES			
Heat Distortion Temperature	--	--	--
HDT 120°C/h at 455kPa (B)	118	°C	ISO 75/1
HDT 120°C/h at 1820kPa (A)	68	°C	ISO 75/1
Softening temperature	--	--	--
Vicat 50°C/h at 9,81N (A)	148	°C	ISO 306
Vicat 50°C/h at 49,05N (B)	86	°C	ISO 306
FLAMMABILITY PROPERTIES			
Flammability	--	--	--
GWFI at 2 mm	750	°C	IEC 60695-2-12
UL94 at 1.6 mm	HB*	--	UL94
ADDITIONAL INFORMATION			
Filler content	20	±2%	ISO 3451
Mould shrinkage (with flow)	1,0-1,2	%	Polykemi
Mould shrinkage (across flow)	1,0-1,2	%	Polykemi
PROCESS INSTRUCTIONS			
Drying time	2-4	h	--
Drying temperature	70-80	°C	--
Melt temperature	205-260	°C	--
Mould temperature	40-80	°C	--
Peripherical screw speed	600-750	mm/s	--
Back pressure	60-100	bar	--

*UL file no. E122538

Further material information is available upon request

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