



St. Joseph PLASTICS

PRODUCT DATA SHEET

615 Polypropylene 100% Post-Consumer

PHYSICAL PROPERTIES

	ASTM METHOD	PROPERTIES	PROPERTIES (RANGE)
SPECIFIC GRAVITY: $W_1 / (W_1 - W_2)$	D 792	0.920 g/cm ³	0.896 - 0.932 g/cm ³
MELT FLOW: @230° C /2.16kg	D1238	10 g/10 min	8 - 12 g/10 min
ASH CONTENT: @800° C 15 min	D 5630	<1%	.55% - 2.8%

MECHANICAL PROPERTIES

TENSILE STRENGTH: @ YIELD	D 638	3,800 psi	3,400 - 4,200 psi
TENSILE ELONGATION: @ BREAK	D 638	10%	8% - 12%
FLEXURAL MODULUS: 1% SECANT	D 790	160,000 psi	130,000 - 190,000 psi
IZOD IMPACT STRENGTH: @ BREAK	D 256	1.5 ft-lbs/in	1.3 - 2.0 ft-lbs/in

PROPERTY NOTES

Stated values are based upon reliable testing methods according to ASTM standards. Values are for guideline purposes only. Actual performance of this material may vary depending upon injection molding conditions or product design. Material should not be run above degradation temperature as a significant loss of physical properties may occur.

St. Joseph Plastics makes no warranties or specific use recommendation. This data sheet does not guarantee product performance, license to operate, suitability, conditions for safe handling, or specific fitness of product. For specific safety recommendations consult the SDS information.

Product standard color is black. Other colors may be available upon request.

SUGGESTED MOLDING PARAMETERS

Melt Temperature:	Feed Zone:	275° F / 135° C
	Barrel:	375° - 450° F / 191° - 232° C
	Mold:	100° - 150° F / 38° - 66° C
Injection Pressure:		8,000 - 15,000 psi

CONTACT INFORMATION

For product inquiries please contact:

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