



Product Data Sheet

100% Post-Consumer Polypropylene 615N, 615L, 615D



PHYSICAL PROPERTIES

	ASTM Method	Properties (Mean)	Properties (Range)
Specific Gravity: $W_1 / (W_1 - W_2)$	D792	0.925 g / cm ³	0.90 – 0.935 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	D5630	1%	.55% - 2.8%

MECHANICAL PROPERTIES

		English	English
Tensile Strength: @ Yield	D638	3,800 psi	3.4 -4.2 psi
Elongation: @ Yield	D638	10%	8% - 12%
Flexural Modulus: 1% Secant	D790	160,000 psi	130 – 190 psi
Izod Impact Strength: @ Break	D256	1.5 ft-lbs/in	1.3 – 2.0 ft-lbs/in

PROPERTY NOTES

Values are for guideline purposes only - actual stated values are based upon ASTM testing standards. Performance may vary depending upon injection-molding conditions or product design. Significant loss of physical properties may occur if material is run above degradation temperature.

St. Joseph Plastics makes no warranties or specific use recommendations. 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.

SUGGESTED MOLDING PARAMETERS

Melt Temperature:	Feed Zone:	350° F / 135° C
	Barrel:	375° - 450° F / 191 - 232° C
	Mold:	100° - 150° F / 38 - 66° C



GRINDING

4515 Easton Rd.
St. Joseph, MO 64503



WASHING

1500 Sedalia Rd.
Sedalia, MO 65301



COMPOUNDING

1102 5th Ave.
St. Joseph, MO 64505