Kkalpana Industries (India) Limited

Technical Data Sheet

PPCT-35 (E .B)

Kalpena's filler master batches are produced from ultra-fine dispersible calcium and virgin polypropylene resins. Additives like antioxidant, lubricant, processing aid and desiccant are added to improve long term thermal & mechanical properties and process ability.

Kalpena's Filler Master batches offers the following benefits.

- Improve stiffness.
- Improve strength and improve product stability.
- Smooth and glossy surface finish
- Cost reduction

Physico-Mechanical Properties:

SL NO	PROPERTIES	TEST METHOD	UNIT	VALUE
1.	Sp. Gravity	ASTM D 792	-	1.18-1.20
2.	Moisture content	ASTM D 6980	%	<0.05
3.	Tensile strength	ASTM D 638	Kg/cm2	>175
4.	Elongation at break	ASTM D 638	%	>10
5.	Flexural Strength	ASTM D 790	Kg/cm2	300-400
6.	Flexural modulus	ASTM D 790	Kg/cm2	>25000
7.	Izod impact (notched	ASTM D 256	Kg-cm/cm	>3.0
8.	HDT@ 4.6Kg/cm2	ASTMD 648	°C	>125
9.	MFI(230°C/2.16 Kg)	ASTMD 1238	gm/10 min	14-17

Pre Drying:. We recommended the pre dry of material at 80 ˚C for minimum 02 Hrs.

Process Condition :-

Hopper	Rare Barrel	Middle Barrel	Front Barrel	Nozzle	Mould
160 ˚C	180-185 ˚C	190-205 ˚C	210-230 ˚C	230 ˚C	30-66 ˚C

Injection Pressure:
Generally, we are recommended 69 to 120 MPa. Higher injection pressure will improve the weld line with low shrinkage.

Storage: The material shall be kept in a cool and dry place.

Main application: INJECTION MOULDINGE (electrical Application , Household Application)

Delivery: Granule form .

Package: 25 kg HDPE woven sacks.