Technical Data Sheet

PCR PP Homo Regranulate natural colored ex. cups

Product Code: 000604

Description

PCR PP Homo Regranulate natural colored ex. Cups - 000604 is a 100% PCR (post-consumer recycled) polypropylene material with a good melt flow rate and good tensile and flexural strength, designed for injection molding process.
PCR PP Homo Regranulate natural colored ex. Cups - 000604 is made from 100% PCR products, water cups, these products are manufactured through high quality recycling process, consist of hot washing, melt filtration, pelletization and degassing etc., comply with GRS (Global Recycled Standard) and food contact materials (FCM) regulations.

Applications	
Food Containers	Packaging components
Lids	Water cups
Children toys	Houseware containers

Special Features	
Lower impurity content control	Stable MFR suitable for injection molding

Compliance	
BPA Free	FDA compliant
REACH (224 SVHC)	RoHS Directive (EU) 2011/65
California Prop. 65	TPCH
EU Regulations EC No 1935/2004 & EU No 10/2011	

Physical Properties	**Value**	**Units**	**Test Method**
Density	0,9	g/cm^3	ISO 1183
MFI (230°C/ 2,16kg)	9	g/10 min	ISO 1133
Tensile Stress	30	MPa	ISO 527-2

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(50mm/min)			
Flexural Modulus	1300	MPa	ISO 178
Flexural Strength	35	MPa	ISO 178
Ash Content	0,8	%	ISO 3451-1
Melt Point	160	°C	ISO 11357
Molding Shrinkage	1,6	%	Internal
Charpy Impact Strength, unnotched (23°C)	97	KJ/m^2	ISO 180
Charpy Impact Strength, notched (23°C)	3,5	KJ/m^2	ISO 180
Heat Deflection Temperature (0,45MPa)	91	°C	ISO 75-2
Heavy Metals (Rohs)	Cd, Hg, Pb, Cr	-	

Processing Conditions

PCR PP 000604 is easy to process with standard injection moulding machines.

Following parameters should be used as guidelines:

Melt temperature: **180 -210 °C**

Holding pressure: **200 – 500 bar**

Mould pressure: **60-100 MPa**

Mould temperature: **30-50 °C**

Molding time: **30-60 s**

Shrinkage 1 - 2%, depending on wall thickness and moulding parameters.

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Storage
PCR PP 000604 should be stored in dry conditions at temperatures below 50°C and protected from UV-light. Improper storage can initiate degradation, which results in odor generation and color changes and can have negative effects on the physical properties of this product. More information on storage can be found in Material Safety Data Sheet (MSDS) for this product.
Recycling
The product is suitable for recycling using modern methods of shredding and cleaning. In-house production waste should be kept clean to facilitate direct recycling.
Disclaimer
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