

Technical Data Sheet

PCR PP Regranulate Natural Color

Product Code: 000615



Description

PCR PP 000615 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 000615 is made from 100% PCR products, including food take-away boxes, PP protection films. The product is manufactured through high quality recycling process, consist of hot washing, melt filtration, pelletization and degassing etc., comply with GRS (Global Recycled Standard).

Applications	
Housewares Containers	Packaging Components
Lids	Other injection parts

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

Compliance	
RoHS Directive (EU) 2011/65	REACH (224 SVHC)
FDA compliant	California Prop. 65
TPCH	

Physical Properties	Value	Units	Test Method
Density	0,91	g/cm ³	ISO 1183
MFR (230°C/ 2,16kg)	10	g/10 min	ISO 1133
Tensile Stress (50mm/min)	32	MPa	ISO 527-2
Elongation at break	43	%	ISO 527-2
Flexural Modulus	1150	MPa	ISO 178
Flexural Strength	35	MPa	ISO 178

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Ash Content	0,5	%	ISO 3451-1
Melt Point	160	°C	ISO 11357
Molding Shrinkage	1,6	%	Internal
Charpy Impact Strength, notched (23°C)	6,5	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 000615 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.

Storage

PCR PP 000615 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.

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.

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