CELSTRAN® PP-GF30-0403 P10/10

CELSTRAN® Long Fibre

Material code according to ISO 1043-1: PP Polypropylene reinforced with 30weight percent long glass fibers. Black. The fibers are chemically coupled to the polypropylene matrix. The pellets are cylindrical and normally as well as the embedded fibers 11 mm long. Parts molded of CELSTRAN have outstanding mechanical properties such as high strength and stiffness combined with high heat deflection. The notched impact strength is increased at elevated and low temperatures due to the fiber skeleton built in the parts. The long fiber reinforcement reduces creep significantly. The very isotropic shrinkage in the molded parts minimizes the warpage. Complex parts can be manufactured with high reproducibility by injection molding. Application field: Functional/structural parts for automotive

Product information

Resin Identification	PP-LGF30		ISO 1043
Part Marking Code	>PP-LGF30<		ISO 11469

Rheological properties

Viscosity number	3290	in^3/lb	ISO 307, 1628

Typical mechanical properties

Tensile modulus	1.02E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	16000	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.2	%	ISO 527-1/-2
Flexural modulus	1.02E6	psi	ISO 178
Flexural strength	25400	psi	ISO 178
Charpy impact strength, 23°C	26.2	$ftlb/in^2$	ISO 179/1eU
Charpy impact strength, -30°C	21.4	$ftlb/in^2$	ISO 179/1eU
Charpy notched impact strength, 23°C	11.4	$ftlb/in^2$	ISO 179/1eA
Charpy notched impact strength, -30°C	10.5	$ftlb/in^2$	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	331	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	316	°F	ISO 75-1/-2
Temperature of deflection under load, 8 MPa	252	°F	ISO 75-1/-2

Flammability

Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.0787	in	IEC 60695-11-10

Physical/Other properties

Density	0.0401	lb/in^3	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	194	°F
Drying Time, Dehumidified Dryer	2 - 3	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	482	°F
Min. melt temperature	446	°F
Max. melt temperature	518	°F

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Max. screw tangential speed	≤0.1	m/s
Mold Temperature Optimum	122	°F
Min. mold temperature	86	°F
Max. mold temperature	158	°F
Back pressure	435	psi
Ejection temperature	234	°F

Characteristics

Processing	Injection Molding

Additional information

Processing Notes

Pre-Drying

It is normally not necessary to dry CELSTRAN PP. However, should there be surface moisture (condensate) on the molding compound as a result of incorrect storage, drying is required.

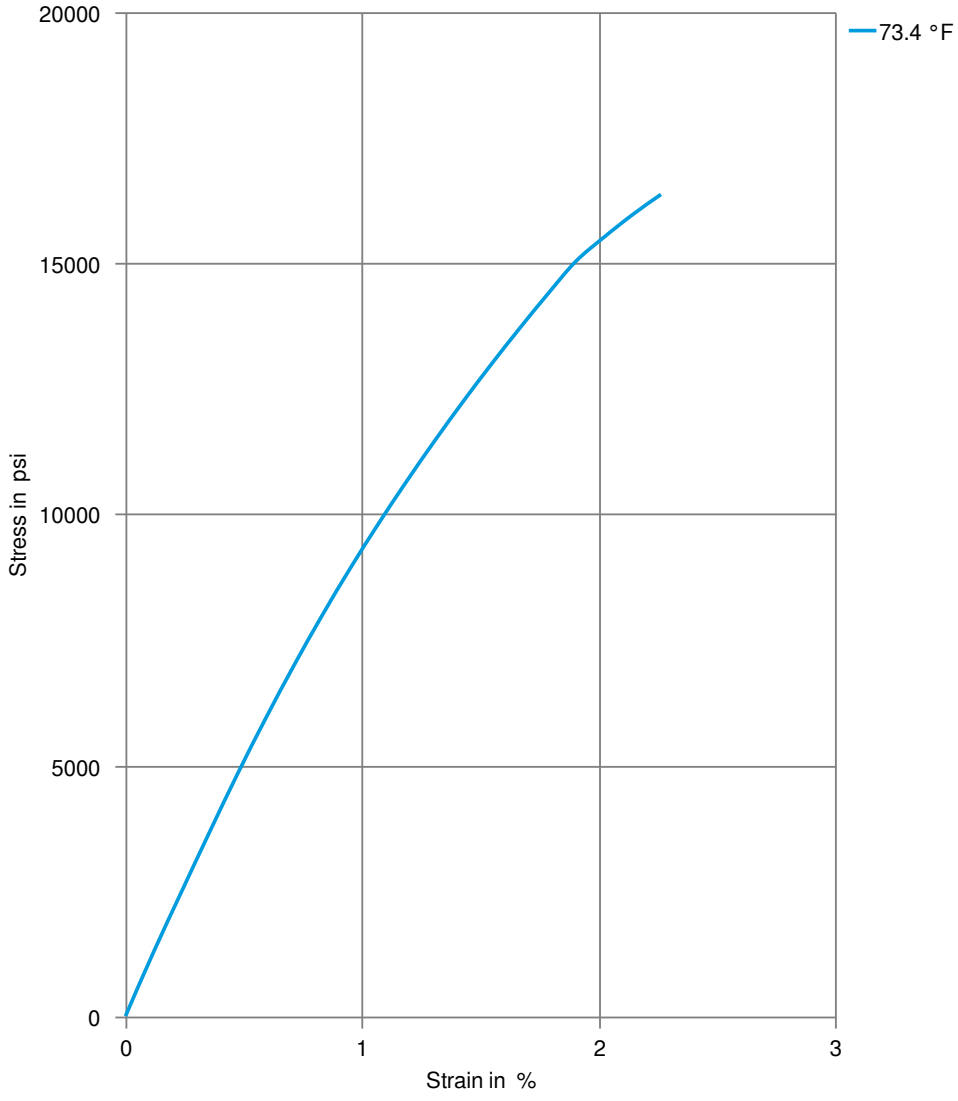
Storage

The product can then be stored in standard conditions until processed.

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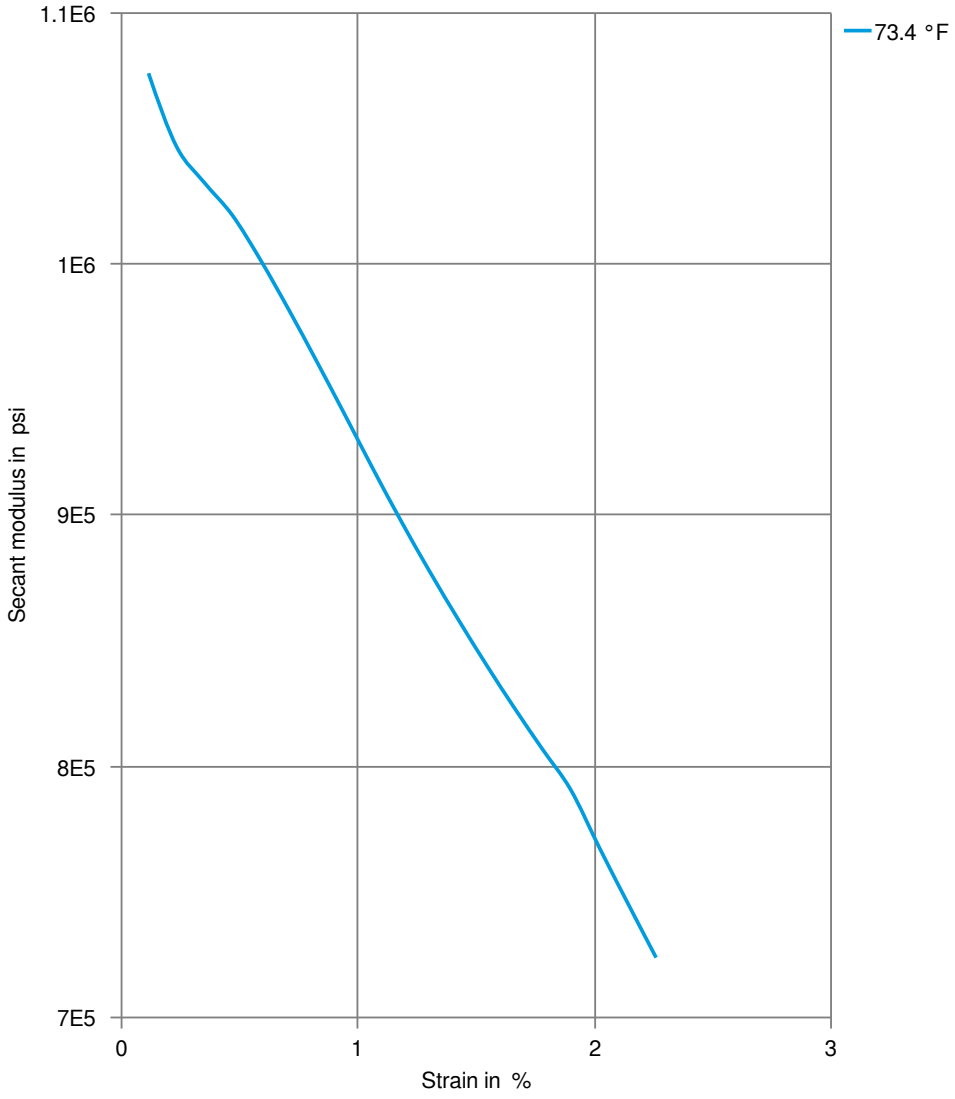
Stress-strain



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Secant modulus-strain



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