Technical Data Sheet

GAPEX®
HP RPP30EV04HB

Polypropylene
Engineering Plastics

General	
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Features	• Chemically Coupled
Appearance	• Red
Forms	• Pellets

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.13	1.13 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	4.5 g/10 min	4.5 g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow	3.0E-3 in/in	0.30 %	
Across Flow	0.010 in/in	1.0 %	
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield, 73°F (23°C))	9400 psi	64.8 MPa	ASTM D638
Tensile Elongation (Break, 73°F (23°C))	5.0 %	5.0 %	ASTM D638
Flexural Modulus			ASTM D790
1% Secant : 73°F (23°C)	703000 psi	4850 MPa	
Tangent : 73°F (23°C)	742000 psi	5120 MPa	
Flexural Strength (Yield, 73°F (23°C))	15400 psi	106 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact (73°F (23°C))	2.0 ft·lb/in	110 J/m	ASTM D256
Unnotched Izod Impact (73°F (23°C))	11 ft·lb/in	600 J/m	ASTM D256
Gardner Impact	7.00 in·lb	0.791 J	ASTM D5420
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 psi (0.45 MPa), Unannealed	315 °F	157 °C	
264 psi (1.8 MPa), Unannealed	290 °F	143 °C	

Additional Information

Filler Content, ASTM D2584: 30%

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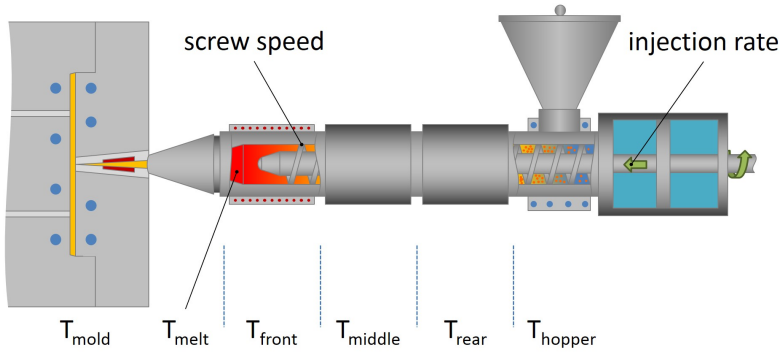

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	160 to 180 °F	71 to 82 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Rear Temperature	430 to 460 °F	221 to 238 °C
Middle Temperature	440 to 470 °F	227 to 243 °C
Front Temperature	450 to 500 °F	232 to 260 °C
Nozzle Temperature	450 to 500 °F	232 to 260 °C
Processing (Melt) Temp	430 to 460 °F	221 to 238 °C
Mold Temperature	100 to 150 °F	38 to 66 °C
Injection Rate	Slow-Moderate	Slow-Moderate
Back Pressure	20.0 to 50.0 psi	0.138 to 0.345 MPa
Cushion	0.200 to 0.500 in	5.08 to 12.7 mm

Notes

These are typical property values not to be construed as specification limits.