Technical Data Sheet

Accuguard HP1363V2CSL

Polypropylene Homopolymer
LyondellBasell Industries
Engineering Plastics

General	
Filler / Reinforcement	• Copper
Additive	• Heat Stabilizer
Features	• Flame Retardant
UL File Number	• E158835
Forms	• Pellets

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	0.935	0.933 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°c/2.16 Kg)	13 g/10 min	13 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	174000 psi	1200 MPa	ASTM D638
Tensile Strength (Yield)	4750 psi	32.8 MPa	ASTM D638
Flexural Modulus	210000 psi	1450 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact	0.80 ft·lb/in	43 J/m	ASTM D256
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	190 °F	87.8 °C	
264 Psi (1.8 Mpa), Unannealed	125 °F	51.7 °C	
RTI Elec	230 °F	110 °C	UL 746B
RTI Imp	230 °F	110 °C	UL 746B
RTI Str	230 °F	110 °C	UL 746B
Flammability	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Flame Rating (0.06 In (1.6 Mm))	V-2	V-2	UL 94

Additional Information

? Flame retardant materials require purging with non-FR polypropylene or a commercial purging compound if extended downtimes are encountered.
? Contact your toolmaker for specific recommendations regarding metallurgy, venting, gating and runner layouts, etc. Runnerless molds must be well-designed for FR resins.
? Vents and adjacent areas should be inspected and cleaned if necessary at least once per shift.
? All residue should be removed from the tool and a commercial protectant applied before storage.

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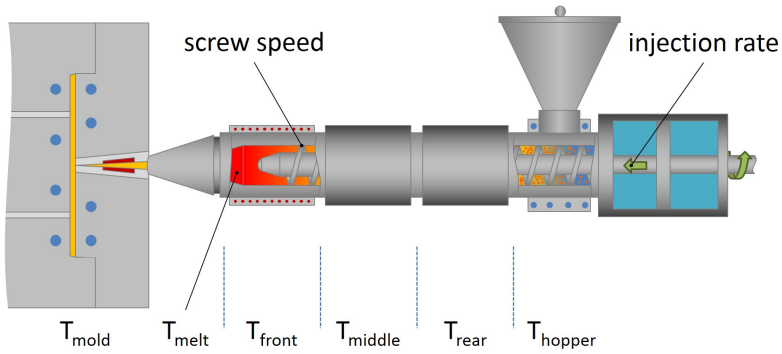

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	180 °F	82 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Rear Temperature	350 to 400 °F	177 to 204 °C
Middle Temperature	350 to 400 °F	177 to 204 °C
Front Temperature	350 to 425 °F	177 to 218 °C
Nozzle Temperature	350 to 425 °F	177 to 218 °C
Processing (Melt) Temp	350 to 425 °F	177 to 218 °C
Mold Temperature	90 to 150 °F	32 to 66 °C
Injection Rate	Slow-Moderate	Slow-Moderate
Back Pressure	< 100 psi	< 0.689 MPa
Screw Speed	20 to 60 rpm	20 to 60 rpm
Cushion	0.250 to 0.500 in	6.35 to 12.7 mm

Notes

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