




## Material Datasheet 7

<b>Trade Name : PP BK 1515</b>	
<b>Material : PP Copolymer</b>	
<b>Color No. : Black</b>	
<b>RoHS Compliance</b>	

Properties	Test Method	Test Condition	Unit	Typical Value
<b>Physical</b>				
Specific Gravity	ASTM D792		g/cm <sup>3</sup>	0.95 - 0.99
Shrinkage			%	1.30 - 1.60
Water Absorption	ASTM D570	23°C	%	0.015 - 0.025
<b>Rheological</b>				
Melt Flow Index	ASTM D1238	200°C - 5kg	g/10min	14 - 16
<b>Mechanical</b>				
Tensile Strength	ASTM D638		kg/cm <sup>2</sup>	260 - 280
Elongation at Yield	ASTM D638		%	8 - 10
Flexural Modulus	ASTM D790B		kg/cm <sup>2</sup>	11000 - 13000
Izod Impact	ASTM D256	V-notched, 1/8"	kg.cm/cm	14 - 16
<b>Thermal</b>				
Heat Distortion Temp.	ASTM D648	Unannealed	°C	76 - 84
<b>Flammability</b>				
Flammability	UL 94	2.0mm (All Colors)		HB

### Recommended Injection Molding Parameters

Barrel Temperature	Value	Mold Temperature	Value
Zone 1	160 - 230°C	Fixed Half	30 - 50°C
Zone 2	160 - 230°C	Moving Half	10 - 40°C
Zone 3	160 - 230°C	Injection Pressure	200 - 400 Bars
Zone 4	140 - 200°C	Hold on Pressure	20 - 80 Bars
Nozzle	160 - 230°C	Screw Back Pressure	10 - 50 Bars
		Screw Speed	50 - 200 RPM
		Drying Hour	2 (If necessary)
		Drying Temperature	70 - 80°C

The data are intended as a general guide only and do not necessarily represent results that may be obtained elsewhere. For further information, please contact or fax to Zinco Colours Technical Services Department.



## Raw Materials



## Finished Product

**YAMAHA - Motorcycle Parts**

