



## HiPrene<sup>®</sup> MT61DT

Polypropylene Compound

### Product Description

*HiPrene<sup>®</sup> MT61DT is a 16% mineral filled, elastomer modified polypropylene compound suitable for injection moulding. This material combines good impact/stiffness balance, high scratch resistance and good flowability. It gives a good surface quality and is especially designed for esthetical interior parts such as instrument panels, lower and upper dashboard, door panels and trims. This grade is available in natural or color-matched, pellet form.*

### Product Characteristic

<b>Status</b>	Commercial: Active
<b>Test Method Used</b>	ASTM
<b>Availibility</b>	Europe
<b>Features</b>	Scratch Resistance                      High Flow High Stiffness                                Good Processability
<b>Typical Customer Applications</b>	Automotive Interior Parts

### Typical Properties

Physical	Symbol	Test Method	Unit	Value
Melt Mass-Flow Rate	MFR	ASTM D1238	g/10min	<b>27</b>
Specific Gravity	$\rho$	ASTM D792	g/cm <sup>3</sup>	<b>1,02</b>
Mechanical	Symbol	Test Method	Unit	Value
Tensile Stress @ Yield	$\sigma_m$	ASTM D638	MPa	<b>22</b>
Tensile Strain @ Break	$\epsilon_{tB}$	ASTM D638	%	<b>70</b>
Flexural Modulus @ 23°C (2mm/min)	$E_f$	ASTM D790	MPa	<b>2000</b>
Impact	Symbol	Test Method	Unit	Value
IZOD Impact Strength @ 23°C	$a_{IN23^\circ C}$	ASTM D256	kJ/m <sup>2</sup>	<b>15</b>
Hardness	Symbol	Test Method	Unit	Value
Rockwell Hardness (R-Scale)	HR-R	ASTM D785	-	<b>75</b>
Thermal	Symbol	Test Method	Unit	Value
Temperature of Deflection under Load (HDT)	$T_f$	ASTM D648	°C	-
Volatile Matters	-	GS Method	%	<b>0,1</b>
Ash Content @ 600°C	Ash <sub>600°C</sub>	GS Method	%	<b>16</b>

**Notes:** Typical properties; not to be constructed as specification

## Other Properties

Property	Typical Value	Test Method
Scratch Resistance Test <sup>2</sup>	$\Delta L = 0,8$	acc. PV 3952
Mould average Shrinkage-Flow Direction <sup>3</sup>	1,1%	GS Method
Mould average Shrinkage-Cross Flow Direction <sup>3</sup>	1,1%	GS Method
Odour (80°C, 2 h)	2,8	acc. PV 3900
Emission	< 50 $\mu\text{g}$	VDA 277
Fogging (100°C, 16 h)	< 2 mg	DIN 75201
Flammability	85 mm/min	TL 1010

<sup>2</sup> Performed on black plaques with rough structure

<sup>3</sup> Values may only be used as indication and should not be used directly in mould design without prior validation

## Processing Techniques

The actual conditions depends on the type of equipment used.

### Injection Moulding

*HiPrene MT61DT* is easy to process with standard injection moulding machines. To avoid residual humidity from transport or storage, the material should be pre-dried approximately 2h at 80°C. Following moulding parameters should be used as guidelines:

Feeding temperature	40 – 80 °C
Melt temperature	210 – 250 °C
Back pressure	Low to medium
Holding pressure	40 – 65 bar
Mould temperature	30 – 50 °C
Screw speed	Low to medium
Injection speed	100 – 200 m/min

### Storage

This material should be stored in dry conditions, protected from sunlight and at temperatures below 50 °C.

### Contact

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