

## ParsaFill 30204HI

Compounded Polyolefin

### Description

ParsaFill 30204HI is a mineral filled co-polypropylene which provides good stiffness as well as high impact strength even at low temperatures. Its superior properties and ease of processing make it a suitable choice for injection molded automotive parts.

### Characteristics

**Material Status:** Commercial: Active

**Filler/Reinforcement:** Mineral Filler , 20% by weight

**Appearance:** Black

**Form:** Pellets

**Processing Method:** Injection molding

### Applications

Automotive applications

### Properties

Physical	Value	Unit	Test Method
Density	1.04	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage		%	ASTM D955
Across Flow	1.0 - 1.3		
Flow	1.0 - 1.3		
Melt Flow Rate (MFR) (230°C/2.16 kg)	7 - 10	g/10min	ASTM D1238
Flammability	HB	-	UL 94
Mechanical	Value	Unit	Test Method
Tensile Modulus (50 mm/min)	1700	MPa	ASTM D638
Tensile Stress (50 mm/min)		MPa	ASTM D638
Yield	20		
Break	15		

Tensile Strain (50 mm/min)		%	ASTM D638
Yield	5		
Break	75		
Flexural Modulus	1800	MPa	ASTM D790
Flexural Stress @ Yield	20	MPa	ASTM D790
Flexural Strain @ Yield	NA	%	ASTM D790
Charpy Notched Impact Strength		kJ/m <sup>2</sup>	ASTM D6110
@ 23 °C	15		
@ 0 °C	5		
@ -20 °C	NA		
Charpy Unnotched Impact Strength		kJ/m <sup>2</sup>	ASTM D6110
@ 23 °C	No Break		
Izod Notched Impact Strength		kJ/m <sup>2</sup>	ASTM D256
@ 23 °C	14		
@ 0 °C	NA		
@ -20 °C	NA		
Scratch Resistance (2N)	NA	MPa	ASTM G171-03
Hardness (Shore D)	67		ASTM D2240
<b>Thermal</b>	<b>Value</b>	<b>Unit</b>	<b>Test Method</b>
Heat Deflection Temperature		°C	ASTM D648
1.82 MPa, Unannealed	56		
0.455 MPa, Unannealed	NA		
Vicat Softening Temperature	NA	°C	ASTM D1525
<b>Processing Conditions</b>			
Drying Temperature	80 °C		
Drying Time	2h		
Barrel Temperature	190 - 230 °C		
Melt Temperature	210 - 240 °C		
Mould Temperature	30 - 50 °C		
Injection Speed	Low to medium		
Hold Pressure	30 - 60 MPa		

**Notes:**

*Typical properties: these are not to be construed as specifications.*