



PRODUCT: HEMP PROPYLENE 20%

Description:

CPP20S is a 20% hemp filled polypropylene with a scratch and mar additive. This product is generally used in injection molding, but may be used for other forming methods as developed by individual users. Hemp Propylene is designed to be a drop-in replacement for conventional fossil fuel based polymers.

To accommodate the natural hemp material within the resin, a slightly larger gate size may be required, as noted below. Best suited for thick walled applications. Natural color is medium brown.

Property:	Typical Value:	Units:	Test Method:
Specific Gravity	0.95	g/cc	ASTM D 792
Tensile Strength @ Break	2,600	psi	ASTM D 638
Tensile Elongation @ Break	13.1	%	ASTM D 638
Flexural Modulus (2% secant)	140,800	psi	ASTM D 790
Melt Flow Index, 230C/2.16Kg	41	g/10 min	ASTM D 1238
Izod Impact	0.74	ft. lbs/in	ASTM D 256
Gardner Impact	12	ft*lbs	ASTM D 5420

General Recommendations:

Temperatures (F)		Pressures		Other
Back	270 – 330	Injection	Moderate	Injection Rate: Moderate
Middle	300 – 340	Hold	Moderate – High	Screw Speed: Moderate-Fast
Front	300 – 340	Back	Moderate	Gate size: >0.06 in
Nozzle	310 – 370			
Mold	080 - 100			Pre-drying is recommended before molding to avoid potential for splay

Data are obtained from tests performed under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

This information serves only as a guideline for processors, users and manufacturers. Due to the complex nature of design and processing, observation on a “trial and error” basis may be required to achieve desired results.

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