



Kalpena Industries Limited

Technical Data Sheet

KI-24-PPCT

Kalpena's filler master batches are produced from ultra-fine dispersible talc and virgin POLYPROPYLENE resins. Additives like antioxidant, lubricant, processing aid and desiccant are added to improve long term thermal & mechanical properties and process ability. The compounds are used directly or diluted with desired grades of POLYPROPYLENE show good dispersibility and excellent balance of properties in the ultimate product. **It helps exceptional process ability with low Cycle Time, high Gloss & Processing Stability.**

Kalpena's Filler Master batches offers the following benefits.

- Better dimensional stability –less shrinkage and warpage .
- Mould release and surface finish .
- Faster cooling rate and hence shorter cycle time.
- Cost reduction .
- Decrease creep, mould shrinkage and coefficient of thermal expansion .

| properties | Test methods | unit | value |
|--------------------------|--------------|-------------------|-------|
| Density | ASTM-D-792 | G/cm ³ | 1.2 |
| MFI | ASTM-D-1238 | G/10 min | 12-13 |
| Tensile strength @ break | ASTM-D-638 | MPa | 22 |
| Flexural modulus | ASTM-D-790 | MPa | 1400 |
| Elongation at break | ASTM-D-638 | % | 6 |
| Filler content | TGA | | 38 |
| Moisture content | ASTM-C-25 | % | <0.05 |
| IZOD IMPACT STRENGTH | ASTMD-256 | Kgcm/cm | 4 |

(The information given in the document is believed to be reliable and is given in good faith but without warranty. The user should test the product to assertion the suitability for intended use. The product specification or the whole document is subject to change without any prior notice.)

Processing parameters:

| | | | | | | |
|--------------------|-----------------------------|-----------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| <i>Zones</i> | <i>1</i> | <i>2</i> | <i>3</i> | <i>4</i> | <i>5</i> | <i>6</i> |
| <i>Temperature</i> | <i>175-180⁰C</i> | <i>185-190⁰C</i> | <i>200⁰C</i> | <i>220⁰C</i> | <i>225⁰C</i> | <i>230⁰C</i> |

APPLICATION :

House ware application and spoon compound.

Storage:

The material shall be kept in a cool dry place and protected from direct sunlight.

Package: 25 kg pp woven sacks.

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Technical Data Sheet

KI-22-40 T

Kalpena's filler master batches are produced from ultra-fine dispersible talc and virgin POLYPROPYLENE resins. Additives like antioxidant, lubricant, processing aid and desiccant are added to improve long term thermal & mechanical properties and process ability. The compounds are used directly or diluted with desired grades of POLYPROPYLENE show good dispersibility and excellent balance of properties in the ultimate product. **It helps exceptional processability with low Cycle Time, high Gloss & Processing Stability.**

Kalpena's Filler Master batches offers the following benefits.

- Better dimensional stability –less shrinkage and warpage .
- Mould release and surface finish .
- Faster cooling rate and hence shorter cycle time.
- Cost reduction .
- Decrease creep, mould shrinkage and coefficient of thermal expansion .

| properties | Test methods | unit | value |
|--------------------------|--------------|-------------------|-------|
| Density | ASTM-D-792 | G/cm ³ | 1.14 |
| MFI | ASTM-D-1238 | G/10 min | 12-13 |
| Tensile strength @ break | ASTM-D-638 | MPa | 20 |
| Flexural modulus | ASTM-D-790 | MPa | 1300 |
| Elongation at break | ASTM-D-638 | % | 5 |
| Filler content | TGA | | 40 |
| Moisture content | ASTM-C-25 | % | <0.05 |
| IZOD IMPACT STRENGTH | ASTMD-256 | Kgcm/cm | 3 |

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Processing parameters:

| | | | | | | |
|--------------------|-----------------------------|-----------------------------|-------------------------|-------------------------|-------------------------|-------------------------|
| <i>Zones</i> | <i>1</i> | <i>2</i> | <i>3</i> | <i>4</i> | <i>5</i> | <i>6</i> |
| <i>Temperature</i> | <i>185-195⁰C</i> | <i>200-210⁰C</i> | <i>220⁰C</i> | <i>230⁰C</i> | <i>235⁰C</i> | <i>240⁰C</i> |

APPLICATION :

House ware application , Industrial mouldings and furniture .

Storage:

The material shall be kept in a cool dry place and protected from direct sunlight.

Package: 25 kg HDPE woven sacks.

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