



Polypropylene HJ325MO

Polypropylene Homopolymer for Injection Moulding

Description

HJ325MO is a very high melt flow polypropylene homopolymer specially designed for products with long flow length. **HJ325MO** is formulated for high speed injection moulding and contains antistatic and nucleating additives allowing fast cycle and high demoulding temperature. The additives are optimised to give reduced tendency for mould plate out. **HJ325MO** is a CR grade with narrow molecular weight distribution giving low warpage.

Components moulded from **HJ325MO** have very good demoulding properties, and combines good stiffness and ambient temperature impact properties with good antistatic performance, good transparency and gloss..

Applications

HJ325MO is designed for very fast production of thin wall articles without warpage or distortion problems.

Examples of products successfully injection moulded from **HJ325MO** are:

- Thin wall containers, products with long flow length
- Square containers
- Rectangular and flat products like lids and trays
- Caps and closures
- Houseware

Physical Properties**

		Typical Value*	Unit	Test Method
Density		910	kg/m ³	ISO 1183
Melt Flow Rate	(230°C/2.16kg)	50	g/10 min	ISO 1133
Tensile Stress at Yield	(50 mm/min)	35	MPa	ISO 527-2
Tensile Strain at Yield	(50 mm/min)	9	%	ISO 527-2
Tensile Modulus	(1 mm/min)	1650	MPa	ISO 527-2
Charpy Impact Strength, notched	(+23°C)	2.0	kJ/m ²	ISO 179/1eA
Hardness, Rockwell		101	R-scale	ISO 2039-2
Heat Deflection Temperature	(0.45 N/mm ²)	103	°C	ISO 75-2

* Data should not be used for specification work

** Values determined on injection moulded specimens acc. to ISO 1873-2 (97), based on 7 days conditioning time.

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Processing Guidelines

The grade can be processed on standard injection moulding machines. Following moulding parameters should be used as guidelines.

Melt temperature	210 – 250°C
Injection speed	Very high
Holding pressure	Minimum required to avoid sink marks (typical values are 200 - 500 bars)
Mould temperature	10 – 30°C
Shrinkage	1 - 2%, depending on wall thickness and moulding parameters.

Storage and Handling

The product should be stored in dry conditions at temperatures below 50°C and protected from UV-light.

Improper storage can initiate degradation, which results in odour generation and colour changes and can have negative effects on the physical properties of the product.

Safety

HJ325MO is not classified as dangerous preparation.

Dust and fines from the product carry a risk of dust explosion. All equipment should be properly earthed. Inhalation of dust should be avoided as it may cause irritation of the respiratory system. Small amounts of fumes are generated during processing of the product. Proper ventilation is therefore required.

Recycling

The product is suitable for recycling using modern methods of shredding and cleaning. In-house production waste should be kept clean to facilitate direct recycling.

A Safety Data Sheet is available on request. Please contact your Borealis representative for more details on various aspects of safety, recovery and disposal of the product.



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Related Documents

The following related documents are available on request, and represent various aspects on the usability, safety, recovery and disposal of the product:

Recovery and disposal of Polyolefins
Information on Emissions from Processing and Fires
Safety Data Sheet, SDS
Environmental Fact Sheet

Liability statements on:

- Compliance to Food Contact Regulations

Disclaimer

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