

PLASTRON® LFT

Long Fiber Reinforced Thermoplastics

General Properties

RA627P

COLOR No. F03L

Long cellulose fiber reinforced PP resin (Cellulose fiber 30%)

Item	Unit	Test method	RA627P
Density	g/cm ³	ISO 1183	1.02
Tensile strength	MPa	ISO 527 -1,2	85
Flexural strength	MPa	ISO 178	114
Flexural modulus	MPa	ISO 178	6,100
Charpy notched impact strength (23°C)	kJ/m ²	ISO 179/1eA	7
Temperature of deflection under load (1.8MPa)	°C	ISO 75 -1,2	157

Standard molding conditions

Preliminary drying	Cylinder temperature (°C)				Screw rotational speed (rpm)	Back pressure (MPa)	Mold temperature (°C)
	Nozzle	Front section	Center section	Rear section			
3-5hrs 120°C	170-200	180-200	180-200	170-200	30-100	1-5	40-80

【Alert Notes】

• Cylinder temperature

The recommended cylinder temperature is up to 200°C. Discoloration may occur when higher temperatures are set.

• Retention in the cylinder

Please avoid retaining PLASTRON® LFT in the cylinder for long periods of time.

It should be retained in the cylinder for no longer than 10 minutes at 200°C. If it has been retained longer than this, the cylinder should be emptied.

• Pellet moisture and predrying

Pellet moisture should be less than 0.1%, or else physical properties and retention stability could deteriorate.

Using a hopper dryer, predry for at least three hours at 120°C.

If you do not have a hopper dryer, please make sure to remove from the dryer as necessary to avoid moisture absorption.

• Cool the purged plastics lumps down in water bath, they may possibly ignite due to their high temperature.

NOTES TO USERS

- All property values shown in this brochure are the typical values obtained under conditions prescribed by applicable standards and test methods.
- This brochure has been prepared based on our own experiences and laboratory test data, and therefore all data shown here are not always applicable to parts used under different conditions. We do not guarantee that these data are directly applicable to the application conditions of users and we ask each user to make his own decision on the application.
- It is the users' responsibility to investigate patent rights, service life and potentiality of applications introduced in this brochure.
Materials we supply are not intended for the implant applications in the medical and dental fields, and therefore are not recommended for such uses.
- For all works done properly, it is advised to refer to appropriate technical catalogs for specific material processing.
- For safe handling of materials we supply, it is advised to refer to the Material Safety Data Sheet "**SDS**" of the proper material.
- This brochure is edited based on reference literature, information and data available to us at the time of creation. The contents of this brochure are subject to change without notice upon achievement of new data.
- Please contact our office for any questions about products we supply, descriptive literatures or any description in this brochure.

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