

CB 3648 MO

Technical Data Sheet
Polypropylene, Impact Heterophasic Copolymer



Product Description

CB 3648 MO is a nucleated heterophasic copolymer with antistatic agent used for injection moulding applications. CB 3648 MO exhibits an excellent stiffness / impact balance combined with a high fluidity. CB 3648 MO is applied in toys, furniture and thin wall injection moulding items.

CB 3648 MO is non-phthalate grade.
This grade is suitable for food contact.

Product Characteristics

Application	Furniture. Housewares. Opaque Containers. Sports. Leisure & Toys
Processing Method	Injection Molding. TWIM
Market	Consumer Products. Rigid Packaging
Features	High Flow. Medium Impact Resistance. Medium Stiffness. Nucleated. Antistatic. Phthalate-free

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate (230°C/2.16kg)	36	g/10 min	ISO 1133
Mechanical			
Flexural modulus (2 mm/min)	1400	MPa	ISO 178
Tensile modulus (1 mm/min)	1300	MPa	ISO 527
Tensile Strength at Yield (50 mm/min)	24	MPa	ISO 527
Elongation at Yield (50 mm/min)	4	%	ISO 527
Impact			
Izod Impact Strength (Notched, 23°C)	7.0	kJ/m ²	ISO 179
Thermal			
Vicat Softening Temperature (10N)	150	°C	ISO 306
Heat Deflection Temperature (0.45 MPa)	90	°C	ISO 75B

Typical temperature profile for Injection Molding:

Feed (Rear zone): 205°C / Transfer (Center zone): 220°C / Metering (Front zone): 220°C / Nozzle: 235°C / Mold: 15-30°C

Higher temperature settings may be necessary for parts or cycles requiring more plasticizing capacity.

Mold temperature may be raised to improve flow and surface finish or lowered for faster cycles, lower shrink and better ejection.

Notes

These are typical property values not to be construed as specification limits

REACH

Polypropylene are exempted from registration under REACH. However, the corresponding monomers (used as raw materials for polymer production) and relevant additives have been registered. Please see related Declaration of Compliance for Plastic Food Contact Materials (DoC for PFCM).

Packaging

Polypropylene pellets is typically packed in polyethylene bags with net weight of 25kg each. 50 bags are stacked on a flat wooden pallet (dimensions: 1100mm x 1300mm x 150mm) with net weight of 1250kg per pallet that is stretch-hood film wrapped. Upon agreement with a customer PP pellet can be packed into big bag sized for 1000kg on wooden pallet (dimensions: 1140mm x 1140mm x 150mm) without stretch-hood film wrapping.

Storage

Polypropylene product packed in 25kg bags or 1000kg big bags stacked on wooden pallet shall be stored in enclosed dry place preventing from direct sunlight at least 1 meter far from heaters, at temperature min. -15°C / max. 35°C, relative humidity max. 80%. Prior to processing PP product bags shall be kept in production area for at least 12 hours.

PP shelf life is 36 months from the date of manufacture.

POLYPROPYLENE HETEROPHASIC COPOLYMER