

## TECHNICAL DATA SHEET

### ADSTET-GD4GX1208

#### Stone Effect 4

High Performance Recycled PP Compound

Quality assured by AD Compound Material Managing Procedure



| PHYSICAL                                | METHOD        | UNITS        | RANGE VALUE          |
|-----------------------------------------|---------------|--------------|----------------------|
| MFI (A) 230°C/2,16 Kg                   | ISO 1133      | g/10min      | <b>10,0 ÷ 30,0</b>   |
| DENSITY 23°C                            | ISO 1183      | g/cm3        | <b>0,951 ÷ 1,039</b> |
| XRF (RoHS DIRECTIVE)                    | IDO 10 LAB    |              | <b>CONFORM</b>       |
| MECHANICAL                              | METHOD        | UNITS        | RANGE VALUE          |
| TENSILE MODULUS (+23°C 2mm/min)         | ISO 527       | MPa          | <b>&gt;= 1100</b>    |
| IMPACT                                  | METHOD        | UNITS        | RANGE VALUE          |
| CHARPY IMPACT STRENGTH, NOTCHED (+23°C) | ISO 179-1/1eA | kJ/ m²       | <b>&gt;= 3,00</b>    |
| OTHER                                   | METHOD        | UNITS        | RANGE VALUE          |
| DELTA E (COLOR)                         | CIELAB D65    |              | <b>0,00 ÷ 2,00</b>   |
| L* (COLOR) (D65)                        | CIELAB D65    |              | <b>56,32</b>         |
| a* (COLOR) (D65)                        | CIELAB D65    |              | <b>-0,76</b>         |
| b* (COLOR) (D65)                        | CIELAB D65    |              | <b>-2,82</b>         |
| RECYCLE PLASTIC CONTENT                 | INTERNAL      | %            | <b>&gt;=70</b>       |
| CARBON FOOTPRINT REDUCTION²             | INTERNAL      | Kg CO₂ eq/kg | <b>- 68%</b>         |

### RECOMMENDED PROCESSING CONDITIONS

|                                  |                  |
|----------------------------------|------------------|
| DRYING TEMPERATURE (°C)          | <b>90</b>        |
| DRYING TIME (h)                  | <b>2</b>         |
| MELT TEMPERATURE (°C)            | <b>220 - 240</b> |
| INJECTION SPEED                  | <b>Medium</b>    |
| INJECTION PRESSURE               | <b>Medium</b>    |
| SHOT WEIGHT\BARREL CAPACITY (%)¹ | <b>25-50</b>     |

¹ Recommendation suggested before processing.

² Reduction of carbon footprint, based on raw materials formulation only, compared to a virgin matrix PP Compound 12% mineral filled. The calculation has been carried out internally based on data available on literature and considering at least 70% of PIR PP matrix.

- Using less than 25% of the barrel capacity will extend the amount of time in which material sits in the barrel and it could cause the degradation of material.

- Using more than 50% of the barrel capacity may not give material pellets the proper amount of time to melt and cause the material to have a non-uniform plasticization with the potential surface defects on the product.

Residence time on the same **barrels shot capacity** also depends on the cycle time which has to be correlated to the product and mould.

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A.D. Compound S.p.a. Via Meucci, 2 28066 Galliate (NO) Tel. +39 0321 866834 Fax +39 0321 866850 [www.adcompound.com](http://www.adcompound.com)

Sede legale: Via Larga, 6 20122 Milano (Mi) C.F.-P.I. 02253490128 C.S. €4.250.000,00 i.v. Registro imprese: Milano n.02253490128 REA n. 1815199

IDM 8.5.02