



## PRIME 3000TF

PRIME 3000TF is a mineral filled PP Copolymer designed for automotive, leisure and general thermoforming applications where a higher HDT and stiffness is required than that of standard PRIME 3000. The material retains good low temperature impact properties and chemical resistance.

	Property	Unit	ISO	Value
<b>PHYSICAL</b>				
Density		g/cc	1183	1.04
Melt Flow (190°C/5kg)		g/10min	1183	0.3-0.5
<b>MECHANICAL</b>				
Izod Impact, notched		kJ/m <sup>2</sup>	23°C	42
		kJ/m <sup>2</sup>	23°C	5
Strength @ yield	MPa	50mm/min	527/2	27
Flexular Modulus	MPa		178	1700
Shore 'D' Hardness			868	70
<b>THERMAL</b>				
VST @ 10N (VST/A)	°C		306	128
HDT@0.45 MPa (HDT/B)	°C		75	95
<b>FLAMABILITY RATING<sup>3</sup></b>				
Horizontal burn	1.5mm		UL94	HB
	3.0mm		UL94	HB

### Finishing

Aluminium tool construction is recommended with a temperature control function to ensure consistent moulding & finished part dimensional tolerances. A constant tool temperature (Typically 70-80°C for PRIME 3000TF) should be maintained throughout the production run. Cooling using air or water spray will speed up the cooling cycle to provide efficient production output. Once removed from the tool, it is recommended that the component is clamped in a frame for a short period to optimise dimensional stability & reduce the risk of warping.

### Colour, Textures, Capabilities

PRIME 3000TF is available in a full range of colours (subject to minimum order quantities) either colour matched to specific colour references, or to customer sample. A range of more standard colours is available for non-specific requirements. For outdoor use, PRIME 3000TF can be stabilised against UV degradation. PRIME 3000TF is available with a smooth or with a textured finish. Emboss swatches are available on request.

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