



CoolPoly® D1202 Thermally Conductive Polypropylene (PP)

CoolPoly D1202 is a thermally conductive injection molding resin based on a Polypropylene matrix. CoolPoly D1202 is electrically insulative. Thermally conductive polymers like CoolPoly D1202 cool faster than standard injection molding grade resins.

Typical Injection Molding Conditions

Temperature Settings	SI /Metric	English
Rear Zone	190 - 220 °C	380 - 430 °F
Center Zone	210 - 230 °C	410 - 450 °F
Front Zone	215 - 245 °C	420 - 475 °F
Melt	215 - 245 °C	420 - 475 °F
Mold	20 - 65 °C	70 - 150 °F

Pressure Settings

Injection	35 - 105 MPa	5000 - 15000 psi
Hold	20 - 55 MPa	3000 - 8000 psi
Back	0 - 0.35 MPa	0 - 50 psi

Injection Settings

Fill	moderate - fast	moderate - fast
Screw	20 - 60 rpm	20 - 60 rpm

Drying Conditions

Time & Temperature	1-2hrs@ 80 °C	1-2hrs@ 180 °F
Dew Point	-20 °C	0 °F

Additional Information

A low compression screw (less than 2:1) is recommended

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