

LABORATORY REPORT FROM QUALITY CONTROL OF A RAW MATERIAL

TECHNICAL-TECHNOLOGICAL
LABORATORY
KONTI HIDROPLAST

MATERIAL: TIPPLEN K 850

Nu. of entrance: 231020

Type of material: PPHM

Date of entrance: 30.11.2023

Lot/batch: 2370626

Quantity (kg): 23,375.00

MELT FLOW RATE (MFR)

Test nu.: 14443

Subject: raw material

Standard: ISO 1133-1;2011 Method A, Equipment 0024

CONDITION

Temperature of
extrusion (°C): 230

Load mass weight
(kg): 2.16

MFR RESULTS

MFR (g/10min)= 0.243

MFR certif. (g/10min)= 0.23

Difference (%): -5.40

CALCULATION

$T_{ref} = 10 \text{ min.} = 600 \text{ sec.}$

Cutt-off time - t (sec): 240

m1(g): 0.096

m2(g): 0.098

m3(g): 0.097

$$MFR = \frac{T_{ref}}{t} \cdot m_{sred}$$

LIMITS AND TOLERANCE

MFR acc. EN12201 EN 1555, method (190°C/5kg): $0.2 < MFR < 1.4$
(g/10min), max allowed difference less than $\pm 20\%$

Status result: Conform

DENSITY

STANDARD EN ISO 1183-1;2012, Equipment 00024

Density by certificate (g/cm³)

Density measured (g/cm³) : 0.9051

Density acc. EN 12201
 ≥ 0.930 (g/cm³)

Status density:

Conform

Test note

Date:
30.11.2023

Quality control | Laboratory
Mech. Eng. Zafir Stardelev

Responsible for quality control
Eng. Gordana Manoleva