



Kimia Baspar Golpa

FRPC/ABS 180

Flame Retardant PC/ABS

General Information

● **Characteristic:** General purpose > Injection grade > Flame Retardant

● **Application:**

Automotive: Front Ends, Cluster pad main panel (instrument panel), Console Box, Glove Box Center, Wheel Cover.

Electrical: Monitor HSG, Fax HSG, Note book pc HSG, Cellular phone case, copy machine Frame, connector, Switch

Industrial/Mechanical: Helmet Terminal Box, Electrical Tool HSG, Industrial Bobbin, Distributing Board Box, Gear and cams

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
Mechanical Property				
Notched Izod impact	ASTM D256	23°C	KJ/m2	50
Rock well hardness	ASTM D-785	R-Scal	Shore D	120
Tensile stress at yield	ASTM D638	23°c , 50 mm/min	Mpa	56
Tensile modulus			Mpa	2750
Elongation at Yield			%	4
Elongation at break			%	35
Flexural modulus	ASTM D790	23°c	Mpa	2600
Flexural strength			Mpa	77
Flammability				
Flammability	UL94	⅜ inch (3.2 mm)	V-0(1.6MM)	V-0(1.6MM)
Thermal Property				
HDT(Heat Deflection	ASTM D648	unannealed1.82MPa	°C	100
Polymer property				
Melt flow index	ASTM D1238	260°C , 5kg	g/10min	30
Density	ASTMD792	23°c	g/cm3	1/13
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	0.5~0.7

1-The above data are typical values. they are only for material selection purpose, and variation within normal tolerances are for various colors.

typical values are not our specification and not be used for part or tool design.

2-all properties, except Melt Flow Index are measured on injection molded specimens and after 48 hour storage at 23°C and in RH of 50%..

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Processing guid (Injection molding condition)

Processing parameters	unit	value
Drying Temperature	°C	70~100
Drying Time	hrs	2~3
Moisture content	%	<0.1
Melt Temperature	°C	220~230
Cylinder Temperature	Reare	°C 220~230
	Middle	°C 220~230
	Front	°C 230~240
Nozzel Temperature	°C	220~240
Mold Temperature	°C	60~80
Back Pressure	kg/cm2	150~500
Screw Speed	rpm	30~60

Note): Some modifications may be required depending on the specific molding equipment and part configuration.

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