



Kimia Baspar Golpa

PPHR 1085

HIPP+Rubber+MF

General Information

● **Characteristic:** Medium impact strength, low temperature toughness, Excellent Formability, easy coating, dimensional stability, good process ability, Weather Resistance

● **Application:** Exterior parts Bumper assembly, Bumper Fascia

Physical Property

Property	Test method	Test condition	Unit	Nominal Value
Mechanical Property				
Notched Izod impact	ASTM D256	23°C	KJ/m2	52
		-20 °c	KJ/m2	13
Hardness	ASTM D2240-05	23°C,15sec	Shore D	58
Tensile stress at yield	ASTM D638	23°c , 50 mm/min	Mpa	17/5
Tensile strength at break			Mpa	15
Tensile modulus			Mpa	750
Elongation at Yield			%	7
Elongation at break			%	320
Flexural modulus	ASTM D790	23°c	Mpa	850
Flammability				
Flammability	UL94	⅜ inch (3.2 mm)	HB (<76mm/min)	HB
Thermal Property				
HDT(Heat Deflection Temperature)	ASTM D648	unannealed1.82MPa	°C	56
		unannealed0.455MPa	°C	100
Polymer property				
Melt flow index	ASTM D1238	230°c , 2.16kg	g/10min	10
Density	ASTMD792	23°c	g/cm3	0/935
Filler content	ASTM D5630-94	800°C	%	6
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	1.3~1.5

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

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

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

**Scratch test on the ungrained and Black color surface with 3.2mm thickness.

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Processing guid (Injection molding condition)

Processing parameters		unit	value
Drying Temprature		°C	50~60
Drying Time		hrs	2~3
Moisture content		%	<0.1
Melt Temprature		°C	200~220
Cylinder Tempratre	Reare	°C	200~210
	Middle	°C	200~220
	Front	°C	210~230
Nozzel Temprature		°C	210~230
Mold Temprature		°C	25~50
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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