



Kimia Baspar Golpa

PPMF20

PP+MF

General Information

● **Characteristic:** Medium Flow, low Impact, Excellent Formability, dimensional stability, good processability, Weather Resistance ,High scratch resistance, Heat Resistance

● **Application:** Interior parts – door panels-fan-socket, container

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
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Mechanical Property

Notched Izod impact	ASTM D256	23°C	KJ/m2	4
		-20 °c	KJ/m2	...
Hardness	ASTM D2240-05	23°C,15sec	Shore D	76
**Scratch Resistance	ISO7724Method A	10N	ΔL	
Tensile stress at yield	ASTM D638	23°C , 50 mm/min	Mpa	26
Tensile strength at break			Mpa	20
Tensile modulus			Mpa	2350
Elongation at Yield			%	4
Elongation at break			%	30
Flexural modulus	ASTM D790	23°C	Mpa	2300
Flexural strength			Mpa	37

Flammability

Flammability	UL94	½ inch (3.2 mm)	HB (<76mm/min)	HB
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Thermal Property

HDT(Heat Deflection	ASTM D648	unannealed1.82MPa	°C	72
Temperature)		unannealed0.455MPa	°C	130

Polymer property

Melt flow index	ASTM D1238	230°C , 2.16kg	g/10min	8
Density	ASTMD792	23°C	g/cm3	1/04
Filler content	ASTM D5630-94	800°C	%	20
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	1.1~1.4

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 Temperature		°C	60~70
Drying Time		hrs	2~3
Moisture content		%	<0.1
Melt Temperature		°C	200~220
Cylinder Temperature	Reare	°C	200~210
	Middle	°C	200~220
	Front	°C	200~220
Nozzel Temperature		°C	200~230
Mold Temperature		°C	25~50
Back Pressure		kg/cm2	200~500
Screw Speed		rpm	30~60

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

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