



Kimia Baspar Golpa

PPMIT20

HIPP+RUBER+MF

General Information

●**Characteristic:**Medium impact strength, low temperature toughness, Excellent Formability, dimensional stability, High scratch resistance, Heat Resistance, Low Gloss & good surface.

●**Application:**Interior parts –Instrument panel- dashboards

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
Mechanical Property				
Notched Izod impact	ASTM D256	23°C	KJ/m2	10
		-20 °c	KJ/m2	3
Hardness	ASTM D2240-05	23°c,15sec	Shore D	65
**Scratch Resistance	ISO7724Method A	10N	ΔL	<1.5
Tensile stress at yield	ASTM D638	23°c , 50 mm/min	Mpa	23
Tensile strength at break			Mpa	20
Tensile modulus			Mpa	1900
Elongation at Yield			%	5
Elongation at break			%	30
Flexural modulus	ASTM D790	23°c	Mpa	1800
Flexural strength			Mpa	32
Flammability				
Flammability	UL94	⅜ inch (3.2 mm)	HB (<76mm/min)	HB
Thermal Property				
HDT(Heat Deflection Temperature)	ASTM D648	unannealed1.82MPa	°C	60
		unannealed0.455MPa	°C	105
Polymer property				
Melt flow index	ASTM D1238	230°c , 2.16kg	g/10min	15
Density	ASTMD792	23°c	g/cm3	1/05
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	50~60
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 210~230
Nozzel Temperature	°C	210~230
Mold Temperature	°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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