



Kimia Baspar Golpa

PPFR702

HIPP+Flame Retardant(Halogen FR)

General Information

●**Characteristic:**Flame retardant feinforced,Electrical and Electronic part&requiring flam retardant property

●**Application:**Automotive Exterior part, Electrical and Electronic part&etc

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
Mechanical Property				
Notched Izod impact	ASTM D256	23°C	KJ/m2	8
Tensile stress at yield	ASTM D638	23°C , 50 mm/min	Mpa	26
Tensile modulus			Mpa	2050
Elongation at Yield			%	5
Elongation at break			%	50
Flexural modulus	ASTM D790	23°C	Mpa	2300
Flexural strength			Mpa	34
Flammability				
Flammability	UL94	½ inch (3.2 mm)	V-2(0.75mm)	V-2(0.75mm)
Thermal Property				
HDT(Heat Deflection Temperature)	ASTM D648	unannealed1.82MPa	°C	72
		unannealed0.455MPa	°C	110
Polymer property				
Melt flow index	ASTM D1238	230°C , 2.16kg	g/10min	6
Density	ASTMD792	23°C	g/cm3	0.96
Filler content	ASTM D5630-94	800°C	%	15
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	1.6~1.8

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	1~2	
Moisture content	%	<0.1	
Melt Temperature	°C	180~200	
Cylinder Temperature	Reare	°C	190~210
	Middle	°C	190~210
	Front	°C	190~210
Nozzel Temperature	°C	200~220	
Mold Temperature	°C	25~50	
Back Pressure	kg/cm ²	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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