



Kimia Baspar Golpa

PPHIG30

HIPP+GF

General Information

● **Characteristic:** Glass fiber reinforced, High rigidity, High Surface hardness processing, excellent chemical resistance, dimensional stability

● **Application:** Automotive Exterior part, Engine part, Washing machine Tubs

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
Mechanical Property				
Notched Izod impact	ASTM D256	23°C	KJ/m2	18
		-20 °c	KJ/m2	5
Tensile stress at yield	ASTM D638	23°C , 50 mm/min	Mpa	75
Tensile modulus			Mpa	4200
Elongation at Yield			%	2
Elongation at break			%	5
Flexural modulus	ASTM D790	23°C	Mpa	5000
Flexural strength			Mpa	105
Flammability				
Flammability	UL94	½ inch (3.2 mm)	HB (<76mm/min)	HB
Thermal Property				
HDT(Heat Deflection Temperature)	ASTM D648	unannealed1.82MPa	°C	145
		unannealed0.455MPa	°C	158
Polymer property				
Melt flow index	ASTM D1238	230°C , 2.16kg	g/10min	6
Density	ASTMD792	23°C	g/cm3	1.14
Filler content	ASTM D5630-94	800°C	%	30
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	0.3~0.5

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 Temperature	°C	60~70	
Drying Time	hrs	2~3	
Moisture content	%	<0.1	
Melt Temperature	°C	200~230	
Cylinder Temperature	Reare	°C	200~210
	Middle	°C	200~230
	Front	°C	210~230
Nozzel Temperature	°C	210~230	
Mold Temperature	°C	40~60	
Back Pressure	kg/cm ²	300~600	
Screw Speed	rpm	30~60	

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

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