



# Kimia Baspar Golpa

PPHIM10

HIPP+MF

## General Information

● **Characteristic:** Medium Flow, Medium Impact, Excellent Formability, dimensional stability, good processability, Weather Resistance

● **Application:** Interior parts – MA packet-Speaker grill

## Physical Property

Property	Test method	Test condition	Unit	Nominal Values
<b>Mechanical Property</b>				
Notched Izod impact	ASTM D256	23°C	KJ/m2	8
		-20 °c	KJ/m2	3
Hardness	ASTM D2240-05	23°C, 15sec	Shore D	62
**Scratch Resistance	ISO7724Method A	10N	ΔL	<0.5
Tensile stress at yield	ASTM D638	23°C , 50 mm/min	Mpa	20
Tensile strength at break			Mpa	17
Tensile modulus			Mpa	1300
Elongation at Yield			%	5
Elongation at break			%	50
Flexural modulus			ASTM D790	23°C
Flexural strength	Mpa	33		
<b>Flammability</b>				
Flammability	UL94	½ inch (3.2 mm)	HB (<76mm/min)	HB
<b>Thermal Property</b>				
HDT(Heat Deflection Temperature)	ASTM D648	unannealed1.82MPa	°C	65
		unannealed0.455MPa	°C	115
<b>Polymer property</b>				
Melt flow index	ASTM D1238	230°C , 2.16kg	g/10min	10
Density	ASTMD792	23°C	g/cm3	0.96
Filler content	ASTM D5630-94	800°C	%	10
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	1.1~1.5

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 Temperature	°C	50~60	
Drying Time	hrs	2~3	
Moisture content	%	<0.1	
Melt Temperature	°C	200~230	
Cylinder Temperature	Rear	°C	200~210
	Middle	°C	200~230
	Front	°C	210~230
Nozzle Temperature	°C	210~230	
Mold Temperature	°C	25~50	
Back Pressure	kg/cm <sup>2</sup>	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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