



# Kimia Baspar Golpa

**PPHIG20**

**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, Light Housing

## Physical Property

Property	Test method	Test condition	Unit	Nominal Values
<b>Mechanical Property</b>				
Notched Izod impact	ASTM D256	23°C	KJ/m <sup>2</sup>	12
		-20 °C	KJ/m <sup>2</sup>	...
Tensile stress at yield	ASTM D638	23°C , 50 mm/min	Mpa	63
Tensile modulus			Mpa	3500
Elongation at Yield			%	...
Elongation at break			%	4
Flexural modulus	ASTM D790	23°C	Mpa	3300
Flexural strength			Mpa	80
<b>Flammability</b>				
Flammability	UL94	½ inch (3.2 mm)	HB (<76mm/min)	HB
<b>Thermal Property</b>				
HDT(Heat Deflection Temperature)	ASTM D648	unannealed 1.82MPa	°C	100
		unannealed 0.455MPa	°C	150
<b>Polymer property</b>				
Melt flow index	ASTM D1238	230°C , 2.16kg	g/10min	....
Density	ASTM D792	23°C	g/cm <sup>3</sup>	1.04
Filler content	ASTM D5630-94	800°C	%	20
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	0.4~0.6

1-The above data are typical values. they are only for material selection purpose, and variation within normal tolerances are for various colors.

typical values are not our specification and not be used for part or tool design.

2-all properties, 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 Temprature	°C	60~70
Drying Time	hrs	2~3
Moisture content	%	<0.1
Melt Temprature	°C	200~230
Cylinder Tempratre	Reare	200~210
	Middle	200~230
	Front	210~230
Nozzel Temprature	°C	210~230
Mold Temprature	°C	40~60
Back Pressure	kg/cm2	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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