



Kimia Baspar Golpa

PPHR10820

HIPP+ RUBBER+Mineral Filler

General Information

● **Characteristic:** Hi impact strength, low temperature toughness, Excellent Formability, easy coating, dimensional stability, good process ability, Weather Resistance

● **Application:** Exterior parts Bumper assembly, Bumper Fascia

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
Mechanical Property				
Notched Izod impact	ASTM D256	23°C	KJ/m2	30
		-20 °c	KJ/m2	7
Hardness	ASTM D2240-05	23°c,15sec	Shore D	65
Tensile stress at yield	ASTM D638	23°c , 50 mm/min	Mpa	20
Tensile strength at break			Mpa	17
Tensile modulus			Mpa	950
Elongation at Yield			%	6
Elongation at break			%	100
Flexural modulus	ASTM D790	23°c	Mpa	1120
Flexural strength			Mpa	32
Flammability				
Flammability	UL94	¾ inch (3.2 mm)	HB (<76mm/min)	HB
Thermal Property				
HDT(Heat Deflection Temperature)	ASTM D648	unannealed1.82MPa	°C	58
		unannealed0.455MPa	°C	104
Polymer property				
Melt flow index	ASTM D1238	230°c , 2.16kg	g/10min	9
Density	ASTMD792	23°c	g/cm3	1/02
Filler content	ASTM D5630-94	800°C	%	20
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	0.9~1.2

1-The above data are typical values and they are not quality guaranteed values.this data sheet is based on our current knowledge and experience.

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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%..



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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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