



# Kimia Baspar Golpa

PPM3T14

HIPP+ RUBBER+MF

## General Information

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

● **Application:** Exterior parts-Side Protector, Waist line molding

## Physical Property

Property	Test method	Test condition	Unit	Nominal Values
<b>Mechanical Property</b>				
Notched Izod impact	ASTM D256	23°C	KJ/m2	55
		-20 °c	KJ/m2	15
Hardness	ASTM D2240-05	23°C, 15sec	Shore D	65
**Scratch Resistance	ISO7724Method A	10N	ΔL	<0.5
Tensile stress at yield	ASTM D638	23°C , 50 mm/min	Mpa	24.5
Tensile strength at break			Mpa	21
Tensile modulus			Mpa	2000
Elongation at Yield			%	5
Elongation at break			%	200
Flexural modulus			ASTM D790	23°C
Flexural strength	Mpa	35		
<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	68
		unannealed0.455MPa	°C	120
<b>Polymer property</b>				
Melt flow index	ASTM D1238	230°C , 2.16kg	g/10min	1.5
Density	ASTMD792	23°C	g/cm3	1.02
Filler content	ASTM D5630-94	800°C	%	12
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	0.9~1.1

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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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	200~220	
Cylinder Temperature	Reare	°C	200~220
	Middle	°C	200~220
	Front	°C	210~230
Nozzel 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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