

Grade standard:
UzAuto Cepla name:

GMW16594 T2
CEW 594T2-UZ

Technical Data Sheet

Type: Injection molding

Application: Coolant System surge tanks

Properties	Test Method	Unit	Values
Physical properties			
Density	ISO 1183	gm/cm ³	0.89 to 0.91
Melt Volume Rate (230°C, 2.16kg)	ISO 1133	gm/10min	0.2 to 1.5
Mold Shrinkage	ISO 294	%	Report result
Mechanical properties			
Tensile Strength at yield	ISO 527	Mpa	30 to 40
Tensile Modulus	ISO 527-1	Mpa	≥ 900
Nothched Charpy Impact (23°C)	ISO 179-1	kJ/m ²	≥ 6
Nothched Charpy Impact (-30°C)	ISO 179-1	kJ/m ²	≥ 1
Thermal properties			
HDT (0.45 MPa)	ISO 75	°C	≥ 95

Processing Guide (Injection Molding)

Processing Parameters		Unit	Values
Drying Temperature		°C	80
Drying Time		hrs	4
Minimum Moisture Content		%	0.1
Melt Temperature		°C	210 ~ 240
Cylinder Temperature	Rear	°C	180 ~ 200
	Middle	°C	190 ~ 210
	Front	°C	200 ~ 210
Nozzle Temperature		°C	210 ~ 220
Mold Temperature		°C	40 ~ 70
Back Pressure		kg/cm ²	30 ~ 60

JV "UZAUTO CEPLA" LLC Lab.