

Grade: CPI 20EDA T1U

Technical Data Sheet

Type: Injection molding, PP+EPDM M20

Application: Instrumental panel

Properties	Test Method	Unit	Values
Physical properties			
Density	ISO 1183	gm/cm ³	1.03 ±0.02
Melt Flow Rate (230°C, 2.16kg)	ISO 1133	gm/10min	19 to 23
Filler content	ISO 3451	%	20 ± 2
Mold Shrinkage	ISO 294	%	0.6 to 0.75
Mechanical properties			
Tensile Stress at yield	ISO 527	Mpa	≥17
Tensile Modulus	ISO 527-1	Mpa	1600 to 2260
Nothched Charpy Impact (23°C)	ISO 179-1	kJ/m ²	≥40
Nothched Charpy Impact (-30°C)	ISO 179-1	kJ/m ²	≥4
Thermal properties			
HDT (0.45 MPa)	ISO 75	°C	≥102

Processing Guide (Injection Molding)

Processing Parameters		Unit	Values
Drying Temperature		°C	80
Drying Time		hrs	4
Minimum Moisture Content		%	0.01
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

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