

Local grade: CT-452-HA
Standard name: GMW 16528 PP
TD20

Technical Data Sheet

Type: Injection molding, PP+TD20

Application: Brackets.

Properties	Test Method	Unit	Values
Physical properties			
Density	ISO 1183	gm/cm ³	1.02 to 1.06
Melt Flow Rate (230°C, 2.16kg)	ISO 1133	gm/10min	5 to 18
Filler content	ISO3451	%	18 to 22
Shrinkage(longitudinal)	ISO294	%	0.7 to 1.2
Mechanical properties			
Tensile Stress at yield	ISO 527	Mpa	≥26
Tensile Modulus	ISO 527-1	Mpa	≥2300
Nothched Charpy Impact (23°C)	ISO 179-1	kJ/m ²	≥30
Nothched Charpy Impact (-40°C)	ISO 179-1	kJ/m ²	≥2
Thermal properties			
HDT (1.8 MPa)	ISO 75	°C	≥70

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