



# UzAuto Cepla



**Grade: CEW670U-UZ**

## Technical Data Sheet

**Type: Injection molding, PP + Rubber + Talc**

**Application:**

Properties	Test Method	Unit	Values
<b>Physical properties</b>			
Density	ISO 1183	gm/cm <sup>3</sup>	1,04
Melt Index (230°C, 2.16kg)	ISO 1133	gm/10min	24,4
Filler	ISO 3451	%	20
Shrinkage (48h after molding)	ISO 294	%	0,58
<b>Mechanical properties</b>			
Tensile Strength at Yield	ISO 527	Mpa	19,2
Flexural Modulus	ISO 178	Mpa	1671
Nothched Charpy Impact (23°C)	ISO 180		55,9
Nothched Charpy Impact (-30°C)	ISO 180		6,5
<b>Thermal properties</b>			
HDT (1.82 MPa)	ISO 75	°C	56

## *Processing Guide (Injection Molding)*

Processing Parameters		Unit	Values
Drying Temperature		°C	80
Drying Time		hrs	2
Minimum Moisture Content		%	0.01
Melt Temperature		°C	210 ~ 240
Cylinder Temperature	Rear	°C	180 ~ 200
	Middle	°C	190 ~ 210
	Front	°C	210
Nozzle Temperature		°C	220
Mold Temperature		°C	40 ~ 70
Back Pressure		kg/cm <sup>2</sup>	300 ~ 600
Screw Speed		rpm	30 ~ 60