



UzAuto Cepla



Grade: CT454-UZ

Lot №

Technical Data Sheet

Type: Injection molding, PP-TD40

Application:

Properties	Test Method	Unit	Values
Physical properties			
Density	ASTM D792	gm/cm ³	1,23
Melt Index (230°C, 2.16kg)	ASTM D1238	gm/10min	12
Filler content	EDS-T - 7301	%	40
Mechanical properties			
Tensile Strength at Yield	ASTM D638	(kg/cm ²)	260
Elongation	ASTM D638	(%)	6
Flexural strength		(kg/cm ²)	440
Flexural Modulus	ASTM D790		37 000
Nothched Izod Impact (23°C)	ASTM D256	(kg cm/cm)	5
Nothched Izod Impact (-30°C)	ASTM D256	(kg cm/cm)	3
Thermal properties			
HDT (1.82 MPa)	ASTM D648	°C	142

Processing Guide (Injection Molding)

Processing Parameters

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 ²	300 ~ 600
Screw Speed		rpm	30 ~ 60