



UzAuto Cepla



Grade: GMW15548 T6B

Technical Data Sheet

Type: Injection molding, PP

Application: interior trim components.

Properties	Test Method	Unit	Values
Physical properties			
Density	ISO 1183	gm/cm ³	1.01
Melt Index (230°C, 2.16kg)	ISO 1133	gm/10min	23
Filler	ISO 3451	%	17
Shrinkage (48h after molding)	ISO 294	%	0.9 to 1.2
Mechanical properties			
Tensile Stress at Yield	ISO 527	Mpa	28
Tensile Modulus	ISO 527-1	Mpa	2500
Nothched Charpy Impact (23°C)	ISO 180	KJ/m ²	5
Nothched Charpy Impact (-30°C)	ISO 180	KJ/m ²	3
Thermal properties			
HDT (1.8 MPa)	ISO 75	°C	57

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	210
Nozzle Temperature	°C	220	
Mold Temperature	°C	40 ~ 70	
Back Pressure	kg/cm ²	300 ~ 600	
Screw Speed	rpm	30 ~ 60	

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