

**Grade: CT452H-UZ**

## Technical Data Sheet

**Material indication : > PP-TD20 <**

**Type: Injection molding.**

**Application: Typical applications include the following: air inlet panel.**

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	31
Filler	ISO 3451	%	21
Shrinkage (48h after molding, plaque size 100 mm x 150 mm x 2 mm)	ISO 294	%	1.1 to 1.2
<b>Mechanical properties</b>			
Tensile Strength at Yield	ISO 527	Mpa	28
Tensile Modulus	ISO 527-1	Mpa	2500
Nothched Charpy Impact (23°C)	ISO 180	kJ/m <sup>2</sup>	5
Nothched Charpy Impact (-30°C)	ISO 180	kJ/m <sup>2</sup>	3
<b>Thermal properties</b>			
HDT (1.82 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 <sup>2</sup>	300 ~ 600	
Screw Speed	rpm	30 ~ 60	

