

**Grade: CP 470-UZ**

## Technical Data Sheet

**Type: Injection molding, PP**

**Application: interior or exterior trim components.**

Properties	Test Method	Unit	Values
<b>Physical properties</b>			
Density	EDS-T-7406	gm/cm <sup>3</sup>	0.914
Melt Index (230°C, 2.16kg)	EDS-T-7516	gm/10min	21.4
Filler	EDS-T-7301	%	0
<b>Mechanical properties</b>			
Tensile strength	EDS-T-7511	kg/cm <sup>2</sup>	278
Flexural strength	EDS-T-7518	kg/cm <sup>2</sup>	392
Impact strength, IZOD (23°C)	EDS-T-7514	kg cm/cm	8.1
Impact strength, IZOD (-30°C)	EDS-T-7514	kg cm/cm	3.2
<b>Thermal properties</b>			
HDT (4.6 kg/cm <sup>2</sup> )	EDS-T-7520	°C	97

## *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
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	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

