

Grade: CE462GF-UZ

Technical Data Sheet

Material indication: >PP-GF20<

Type: Injection molding, 20% Glass fiber reinforced polypropylene

Application: interior or exterior parts of a vehicle.

Properties	Test Method	Unit	Values
Physical properties			
Density	EDS-T-7406	gm/cm ³	1.1
Melt Index (230°C, 2.16kg)	EDS-T-7516	gm/10min	7.5
Glass fiber	EDS-T-7301	%	20
Mechanical properties			
Tensile strength	EDS-T-7511	kg/cm ²	714
Flexural strength	EDS-T-7518	kg/cm ²	917
Impact strength, IZOD (23°C)	EDS-T-7514	kg cm/cm	8.2
Impact strength, IZOD (-30°C)	EDS-T-7514	kg cm/cm	6.08
Thermal properties			
HDT (4.6 kg/cm ²)	EDS-T-7520	°C	158.5

Processing Guide (Injection Molding)

Processing Parameters		Unit	Values
Drying Temperature		°C	90
Drying Time		hrs	4
Minimum Moisture Content		%	0.02
Melt Temperature		°C	230 ~ 240
Cylinder Temperature	Rear	°C	180 ~ 210
	Middle	°C	200 ~ 225
	Front	°C	220
Nozzle Temperature		°C	230
Mold Temperature		°C	50 ~ 80
Back Pressure		kg/cm ²	300 ~ 600
Screw Speed		rpm	40 ~ 70

