

Grade: CE472CB-UZ

Technical Data Sheet

Type: Injection molding, 10% Talc Filled PP + RUBBER

Application: interior or exterior trim components.

Properties	Test Method	Unit	Values
Physical properties			
Density	EDS-T-7406	gm/cm ³	0.98
Melt Index (230°C, 2.16kg)	EDS-T-7516	gm/10min	24
Filler	EDS-T-7301	%	10
Mechanical properties			
Tensile strength	EDS-T-7511	kg/cm ²	224
Flexural strength	EDS-T-7518	kg/cm ²	318
Impact strength, IZOD (23°C)	EDS-T-7514	kg cm/cm	17.8
Impact strength, IZOD (-30°C)	EDS-T-7514	kg cm/cm	3.37
Thermal properties			
HDT (4.6 kg/cm ²)	EDS-T-7520	°C	124

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

