

Grade: CE472T3

Technical Data Sheet

Material indication : > PP+EPDM-TD20 <

Type: Injection molding.

Application: interior or exterior trim components.

Properties	Test Method	Unit	Values
Physical properties			
Density	EDS-T-7406	gm/cm ³	1.06
Melt Index (230°C, 2.16kg)	EDS-T-7516	gm/10min	14
Filler	EDS-T-7301	%	20
Mechanical properties			
Tensile strength	EDS-T-7511	kg/cm ²	250
Flexural strength	EDS-T-7518	kg/cm ²	435
Impact strength, IZOD (23°C)	EDS-T-7514	kg cm/cm	12
Impact strength, IZOD (-30°C)	EDS-T-7514	kg cm/cm	3.22
Thermal properties			
HDT (4.6 kg/cm ²)	EDS-T-7520	°C	137

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

