

Grade: CEW670-UZ

Technical Data Sheet

Type: Injection molding, PP + Rubber + Talc

Application:

Properties	Test Method	Unit	Values
Physical properties			
Density	ISO 1183	gm/cm ³	1,02
Melt Index (230°C, 2.16kg)	ISO 1133	gm/10min	23
Filler	ISO 3451	%	21
Shrinkage (48h after molding)	ISO 294	%	0.66
Mechanical properties			
Tensile Strength at Yield	ISO 527	Mpa	15
Flexural Modulus	ISO 178	Mpa	17600
Nothched Charpy Impact (23°C)	ISO 180		58
Nothched Charpy Impact (-30°C)	ISO 180		6
Thermal properties			
HDT (1.82 MPa)	ISO 75	°C	56

Processing Guide (Injection Molding)

Processing Parameters		Unit	Values
Drying Temperature		°C	80
Drying Time		hrs	2
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