

Kingfa APO-2212

Polypropylene

Kingfa

Message:

PP-T20

General Information			
Filler / Reinforcement	Talc filler, 20% filler by weight		
Additive	Rubber		
	UV stabilizer		
Features	Good UV resistance		
	Workability, good		
	Good coloring		
Uses	Automotive exterior parts		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.03 - 1.07	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	6.0 - 14	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.011 - 0.012	%	Internal method
Ash Content ¹ (750°C)	17 - 23	%	ISO 3451
Weather Resistance ²	4.00 - 5.00		SAE J1960
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	32.0	MPa	ISO 527-2/50
Flexural Modulus ³	2650	MPa	ISO 178
Flexural Stress ⁴	45.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	3.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	68.0	°C	ISO 75-2/A
Flammability	Nominal Value	Unit	Test Method
Burning Rate ⁵	45	mm/min	ISO 3795
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	0.0 - 2.0	hr	
Rear Temperature	190 - 210	°C	
Middle Temperature	205 - 230	°C	
Front Temperature	215 - 240	°C	

Processing (Melt) Temp	220 - 245	°C
Mold Temperature	30.0 - 60.0	°C
Injection Rate	Slow-Moderate	
Back Pressure	0.350	MPa

Injection instructions

Processing Temp. Limit: 250°C

NOTE

1.	30 min
2.	250 kJ/m ²
3.	2.0 mm/min
4.	2.0 mm/min
5.	360×100×3

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