

Daplen™ KSX65T20

Polypropylene

Borealis AG

Message:

Daplen KSX65T20 is a 15% mineral filled polypropylene compound intended for injection moulding. This material has excellent balanced mechanical properties and is easy to process.

General Information			
Filler / Reinforcement	Mineral filler, 15% filler by weight		
Features	Workability, good		
Uses	Application in Automobile Field		
	Car interior parts		
	Car interior equipment		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.01	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			ISO 1133
230°C/2.16 kg	6.0	g/10 min	ISO 1133
230°C/5.0 kg	30	g/10 min	ISO 1133
Molding Shrinkage	1.0	%	Internal method
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	50.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	20.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	5.3	%	ISO 527-2/50
Flexural Modulus ¹	1600	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-20°C	4.3	kJ/m ²	ISO 179/1eA
23°C	25	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-20°C	51	kJ/m ²	ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	91.0	°C	ISO 75-2/B
1.8 MPa, not annealed	55.0	°C	ISO 75-2/A
Vicat Softening Temperature			

--	128	°C	ISO 306/A50
--	51.0	°C	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Fogging			DIN 75201
16 hrs : 100°C	5.0E-4	g	DIN 75201
3 hrs : 100°C	96	%	DIN 75201
Emission	45.0	µgC/g	VDA 277
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Processing (Melt) Temp	220 - 260	°C	
Mold Temperature	30.0 - 50.0	°C	
Holding Pressure	30.0 - 60.0	MPa	
Injection instructions			
Feeding Temperature: 40 to 80°C Back Pressure: Low to medium Screw Speed: Low to medium Flow front speed: 100 to 200 m/s			
NOTE			
1.	2.0 mm/min		

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