

Kingfa PP-KF06

Polypropylene

Kingfa

Message:

PP-T20

General Information			
Filler / Reinforcement	Talc filler, 20% filler by weight		
Features	Rigid, good		
	Good coloring		
	Thermal stability, good		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.02 - 1.08	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	1.1 - 1.2	%	Internal method
Ash Content ¹ (750°C)	18 - 22	%	ISO 3451
Long Term Aging (150°C)	> 700.0	hr	ISO 188
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	32.0	MPa	ISO 527-2/50
Flexural Modulus ²	2400	MPa	ISO 178
Flexural Stress ³	45.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	3.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, unannealed, 4.00mm span)	125	°C	ISO 75-2/B
Flammability	Nominal Value	Test Method	
Flame Rating (3.00 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	2.0	hr	
Rear Temperature	180 - 210	°C	
Middle Temperature	190 - 230	°C	
Front Temperature	200 - 240	°C	
Processing (Melt) Temp	190 - 245	°C	
Mold Temperature	20.0 - 50.0	°C	
Injection Rate	Slow-Moderate		

Back Pressure	10.0	MPa
Injection instructions		
Processing Temp. Limit: 260°C		
NOTE		
1.	30 min	
2.	2.0 mm/min	
3.	2.0 mm/min	

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