

Kingfa ABP-1010

Polypropylene

Kingfa

Message:

PP-EPDM-T10

General Information			
Filler / Reinforcement	Talc filler, 10% filler by weight		
Additive	Rubber 2		
Features	Impact resistance, high		
	Sprayable		
	Good coloring		
Uses	Car anti-collision bar		
	Automotive exterior parts		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.950 - 0.980	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	10 - 15	g/10 min	ISO 1133
Molding Shrinkage			Internal method
23°C	8.5E-3 - 9.0E-3	%	Internal method
80°C, 30 minutes	1.0E-3 - 1.5E-3	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	17.0	MPa	ISO 527-2/50
Tensile Strain (Break)	100	%	ISO 527-2/50
Flexural Modulus ¹	1000	MPa	ISO 178
Flexural Stress ²	20.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ³ (23°C)	40	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, unannealed, 4.00mm span)	100	°C	ISO 75-2/B
Flammability	Nominal Value		Test Method
Flame Rating ⁴	HB		ISO 3795
Additional Information	Nominal Value		Test Method
Weather Resistance ⁵	4.00 - 5.00		SAE J1960
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. | 2.0 mm/min |
| 2. | 2.0 mm/min |
| 3. | 4 mm |
| 4. | 360×100×3 |
| 5. | 2500 KJ/m ² |

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