

Kingfa API-2500

Polypropylene

Kingfa

Message:

PP-T25

General Information			
Filler / Reinforcement	Talc filler, 25% filler by weight		
Additive	UV stabilizer		
Features	Good UV resistance		
Uses	Application in Automobile Field		
Appearance	Unspecified Color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.05 - 1.10	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20	g/10 min	ISO 1133
Molding Shrinkage (23°C)	9.0E-3 - 0.011	%	Internal method
Ash Content ¹ (750°C)	23 - 27	%	ISO 3451
Weather Resistance ²	4.00 - 5.00		SAE J1960
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	21.0	MPa	ISO 527-2/50
Tensile Strain (Break)	30	%	ISO 527-2/50
Flexural Modulus ³	2050	MPa	ISO 178
Flexural Stress ⁴	31.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ⁵ (23°C)	7.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, unannealed, 4.00mm span)	110	°C	ISO 75-2/B
Flammability	Nominal Value	Unit	Test Method
Burning Rate ⁶	45	mm/min	ISO 3795
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	0.0 - 2.0	hr	
Rear Temperature	92.0 - 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.	4 mm	
6.	360×100×3	

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