

Kingfa API-1109

Polypropylene

Kingfa

Message:

PP-EPDM-T20

General Information			
Filler / Reinforcement	Talc filler, 20% filler by weight		
Additive	Rubber 2		
	UV stabilizer		
Features	Good UV resistance		
	Good toughness		
Uses	Car interior parts		
Appearance	Unspecified Color		
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 (23°C)	0.015 - 0.016	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	20.0	MPa	ISO 527-2/50
Tensile Strain (Break)	100	%	ISO 527-2/50
Flexural Modulus ¹	1300	MPa	ISO 178
Flexural Stress ²	25.0	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.	250 kJ/m ²

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