

# Kingfa API-1530

Polypropylene

Kingfa

Message:

PP-EPDM-T15

| General Information                                             |                                   |                   |                 |
|-----------------------------------------------------------------|-----------------------------------|-------------------|-----------------|
| Filler / Reinforcement                                          | Talc filler, 15% filler by weight |                   |                 |
| Additive                                                        | Rubber 2                          |                   |                 |
|                                                                 | UV stabilizer                     |                   |                 |
| Features                                                        | Rigidity, high                    |                   |                 |
|                                                                 | Good UV resistance                |                   |                 |
|                                                                 | High liquidity                    |                   |                 |
| Uses                                                            | Car interior parts                |                   |                 |
| Appearance                                                      | Unspecified Color                 |                   |                 |
| Processing Method                                               | Injection molding                 |                   |                 |
| Physical                                                        | Nominal Value                     | Unit              | Test Method     |
| Density                                                         | 0.980 - 1.02                      | g/cm <sup>3</sup> | ISO 1183        |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)                       | 23 - 28                           | g/10 min          | ISO 1133        |
| Molding Shrinkage (23°C)                                        | 0.011 - 0.012                     | %                 | Internal method |
| Ash Content <sup>1</sup> (750°C)                                | 15 - 18                           | %                 | ISO 3451        |
| Weather Resistance <sup>2</sup>                                 | 4.00 - 5.00                       |                   | SAE J1960       |
| Mechanical                                                      | Nominal Value                     | Unit              | Test Method     |
| Tensile Stress (Break)                                          | 24.0                              | MPa               | ISO 527-2/50    |
| Tensile Strain (Break)                                          | 25                                | %                 | ISO 527-2/50    |
| Flexural Modulus <sup>3</sup>                                   | 1800                              | MPa               | ISO 178         |
| Flexural Stress <sup>4</sup>                                    | 36.0                              | MPa               | ISO 178         |
| Impact                                                          | Nominal Value                     | Unit              | Test Method     |
| Notched Izod Impact <sup>5</sup> (23°C)                         | 5.5                               | kJ/m <sup>2</sup> | ISO 180         |
| Thermal                                                         | Nominal Value                     | Unit              | Test Method     |
| Heat Deflection Temperature (0.45 MPa, unannealed, 4.00mm span) | 120                               | °C                | ISO 75-2/B      |
| Flammability                                                    | Nominal Value                     |                   | Test Method     |
| Flame Rating <sup>6</sup>                                       | HB                                |                   | ISO 3795        |
| 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. | 30 min                |
| 2. | 250 kJ/m <sup>2</sup> |
| 3. | 2.0 mm/min            |
| 4. | 2.0 mm/min            |
| 5. | 4 mm                  |
| 6. | 360×100×3             |

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