

Kingfa APO-3012

Polypropylene

Kingfa

Message:

PP-EPDM-T30

General Information			
Filler / Reinforcement	Talc filler, 30% filler by weight		
Additive	Rubber 2		
	UV stabilizer		
Features	Good UV resistance		
	Workability, good		
	Good coloring		
Uses	Automotive exterior parts		
	Car exterior decoration		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.10 - 1.16	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	8.0 - 14	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.011 - 0.012	%	Internal method
Ash Content ¹ (750°C)	28 - 32	%	ISO 3451-1
Weather Resistance ²	4.00 - 5.00		SAE J1960
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	20.0	MPa	ISO 527-2/50
Flexural Modulus ³	2000	MPa	ISO 178
Flexural Stress ⁴	31.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	9.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, unannealed, 4.00mm span)	115	°C	ISO 75-2/A
Flammability	Nominal Value	Unit	Test Method
Burning Rate ⁵	40	mm/min	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/m²
3. 2.0 mm/min
4. 2.0 mm/min
5. 360×100×3

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