



·10% ,20% 10% glass fiber reinforced PP and 20% mineral filled		· Injection molding		
· Good mechanical properties balance		· Automotive parts		
· Excellent heat stability				
Specific Gravity	ISO 1183	23	g/cm³	1.13
Ash	ISO 3451	800 ,30min	%	30
Tensile Strength	ISO 527	5mm/min	MPa	56
Flexural Modulus	ISO 178	2mm/min	MPa	4300
Flexural Strength	ISO 178	2mm/min	MPa	95
Charpy Notched Impact Strength	ISO 179-1eA	23	kJ/m²	5
Charpy Unotched Impact Strength	ISO 179-1eU	23	kJ/m²	40
Heat Deflection Temp.	ISO 75	1.8 Mpa	°C	135
Melting Point	ISO 11375	DSC	°C	163
Mold Shrinkage ¹	internal test method	48 hours after tool	%	0.50-1.00
Flammability	ISO 3795	—	mm/min	29

The data above is typical value for reference, not guarantee value. The data will vary with tool design such as gate type , gate location, gate number, injection molding process and part thickness. The data will vary with different color as well. Prior to use the material, please consult with Sunway polymer.

Melt Temperature		210-250
Barrel Temperature	, Rear	210--225
	, Center	220--235
	, Front	230--250
Mold Temperature		30-60
Pre-Dry needed		90-100 , 2-4h

(1) 210*140*2.8mm

(2)

(1) The dimension of shrinkage plaque is 210*140*2.8mm. The part's shrinkage will have deviation due to part thickness, number of gate and type of gate; It is better to do mold trial on similar tool before cutting a new tool.

(2) The above process condition is only for reference. The actual process should be adjusted according to different type of machine, mold design and product design.

version 1: Jan. 2021