



·20% PP 20% long glass fiber reinforced PP		Injection molding		
Excellent heat resistance performance		Excellent mechanical properties, especially low temperature impact performance		
Specific Gravity	ISO 1183	23	g/cm ³	1.04
Ash	ISO 3451	800 ,30min	%	20
Tensile Strength	ISO 527	5mm/min	MPa	88
Tensile Modulus	ISO 527	1mm/min	MPa	5100
Elongation at break	ISO 527	5mm/min	%	2.7
Flexural Strength	ISO 178	2mm/min	MPa	130
Flexural Modulus	ISO 178	2mm/min	MPa	4750
Notched Charpy Impact Strength	ISO 179-1eA	23	kJ/m ²	15
Notched Charpy Impact Strength	ISO 179-1eA	-30	kJ/m ²	20
Unotched Charpy Impact Strength	ISO 179-1eU	23	kJ/m ²	47
Unotched Charpy Impact Strength	ISO 179-1eU	-30	kJ/m ²	27
Heat Deflection Temp.	ISO 75	1.80MPa		159
		0.45MPa		-
shrinkage ⁽¹⁾	internal method	flow direction	%	0.10-0.30
		cross flow dirction	%	0.70-0.90
Flammability	ISO 3795	—	mm/min	45

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		210-260
Barrel Temperature	, Rear	220--235
	, Center	225--245
	, Front	240--260
Mold Temperature		50-80
Pre-Dry needed		90-110 , 2-4 h

(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.

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