KOLON PLASTICS

KOPEL® KP3372

Injection Molding, TPC-ET

Application

Automotive parts, appliance, etc.

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Specific Gravity		ISO 1183	-	1.27
Melt Flow Index	240 ℃, 2.16kg	ISO 1133	g/10min	36
Shrinkage		ISO 294-4	%	1.65~1.70
Water Absorption	23℃, H_2O, 24hr	ISO 62	%	0.2
Mechanical				
Tensile Strength at Break (2.0mm)	50 mm/min	ISO 527	MPa	57
Elongation at Break (2.0mm)	50 mm/min	ISO 527	%	600↑
Flexural Modulus (4.0mm)	10 mm/min	ISO 178	MPa	1,100
Izod Impact strength (4.0mm)		ISO 180		
(Notched)	23 ℃		kJ/m^2	9.7
	-40 ℃		kJ/m^2	4.6
Charpy Impact Strength (4.0mm)		ISO 179/1eA		
(Notched)	23 ℃		kJ/m^2	10.1
	-40 ℃		kJ/m^2	4.1
Shore Hardness (Max)		ISO 868	Shore D	72
Thermal				
Melting Point	20 ℃/min	ISO 11357-1	℃	220
Vicat softening temperature	10N, 50℃/h	ISO 306	℃	210
Flammability (0.8mm)		UL94	Class	HB

※ (Test specimen Thickness)

Updated: 2018-09-30

Processing Guide (Injection Molding)

Drying Temperature(℃)	80 ~ 110	(Dehumidifying Dryer)		
Drying Time(hr)	3~6			
Processing Moisture Contents(%)	≤ 0.08			
Cylinder Temperature(℃)	Nozzle	Front	Middle	Rear
	230~240	230~240	225 ~ 235	210 ~ 220
Mold Temperature(℃)	20~40			

Updated: 2018-09-30