

PRODUCT DATA SHEET

LEXPRENE EPP-215T

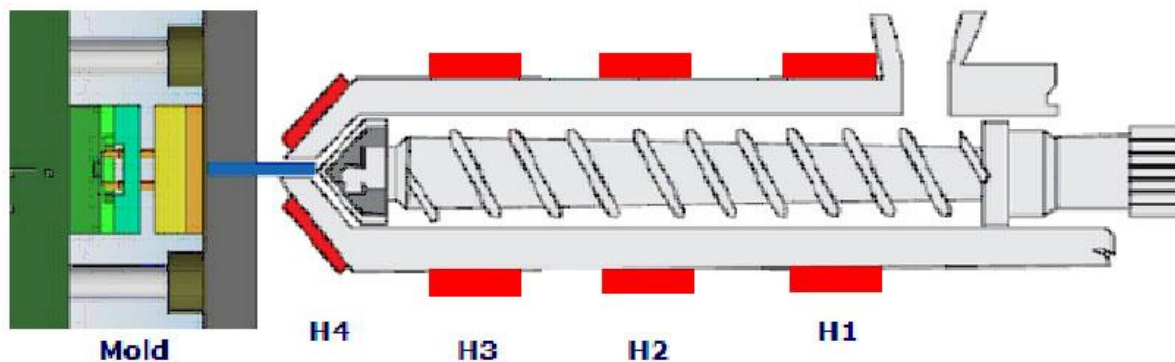
Description : Lexprene EPP-215T is composed of 15 % talc filled PP compound with high flow & high stiffness stability. The product is available in black color pellet form which have good melt flow rate for easy injection molding ,specifically design to provide an excellent balance of stiffness and impact for air-conditioning parts. This compounded PP+Talc can be supplied in black or pre-colored. Suggested molding conditions: melt temperature 220-240° C, mold temperature 40-80° C

Application : Electric & Electronics housing

General properties	EPP-215T value	Unit	Test method
Density	1.00	g/cm ³	ISO 1183
Melt flow rate ,@230°C, 2.16kgf	28	g/10min	ISO 1133
Shrink-rate as-molded	1.3 ~ 1.4	% (13~14/1,000)	Polylex method
Mechanical properties			
Izod impact strength, 4 mm notched @+23°C	10	KJ / m ²	ISO 180
Tensile stress, @ yield, 50 mm/min	22	MPa	ISO 527-1.-2
Tensile strain, @ yield, 50 mm/min	10	%	ISO 527-1.-2
Flexural strength, @yield, 10mm/min	33	MPa	ISO 178
Flexural modulus, @yield, 10mm/min	2,800	MPa	ISO 178
Thermal properties			
Deflection temperature @ 0.45MPa, 4 mm	110	°C	ISO 75-2

* The above values are for the representatives

PROCESSING GUIDE of EPP-215T



Parameter Injection Molding		Value	Unit
Drying Temperature		°C	80 ~ 90
Drying Time		Hr	2 ~ 3
Maximum moisture content		%	0.02
Melt Temperature		°C	220 ~ 240
Cylinder Temperature	H4	°C	220 ~ 240
	H3	°C	220 ~ 230
	H2	°C	220 ~ 230
	H1	°C	210 ~ 220
Mold Temperature		°C	40 ~ 80
Back Pressure		MPa	0.3 ~ 0.7
Screw rotating speed		rpm	20 ~ 100