



Technical Datasheet

Trade Name	Expond	Material Type	PP	Grade Name	PP C6540L-F
Feature		<ul style="list-style-type: none">• Neat PP• High Flow• Excellent Impact Resistance			
Appearance		<ul style="list-style-type: none">• Colors Optional			
Material Standard		<ul style="list-style-type: none">• WSS-M4D638-C, WSS-M4D638-D2			
Availability		<ul style="list-style-type: none">• Asian-Pacific, America			
Processing method		<ul style="list-style-type: none">• Injection Molding			
Applications		<ul style="list-style-type: none">• Interior and Exterior Automotive parts			

General Properties

No.	Properties	Unit	Result	Method	Test condition
1	Density	g/cm ³	0.90	ISO 1183-1	23°C
2	Tensile Strength at yield	MPa	19	ISO 527-2	50 mm/min
3	Flexural Strength	MPa	27	ISO 178	2 mm/min, 64 mm
4	Flexural Modulus	MPa	950	ISO 178	2 mm/min, 64 mm
5	Notched Charpy Impact Strength	KJ/m ²	42	ISO 179-1/1	23 °C
6	Notched Charpy Impact Strength	KJ/m ²	4.7	ISO 179-1/1	-30 °C
7	Heat Deflection Temperature	°C	49	ISO 75-2	1.8 MPa, 120 °C/h
8	Melt Flow Rate	g/10min	18	ISO 1133-1	230°C×2.16kg

Processing Conditions

Drying condition	<ul style="list-style-type: none">• 80 - 90°C 1-2h
Barrel Temp.	<ul style="list-style-type: none">• 210 - 230 °C (F), 200 - 220 °C (M), 180 - 200 °C (B)
Screw Speed	<ul style="list-style-type: none">• 40 - 80 rpm
Injection Press.	<ul style="list-style-type: none">• 50 - 80 Mpa
Back Press.	<ul style="list-style-type: none">• 0.3 - 1.0 Mpa
Mold Temp.	<ul style="list-style-type: none">• 20 - 60 °C

Notes. These technical data in the product brochures are typical test results for reference, and could not be defined as minimum value.