

SolutionPartner


HYPERIER IP1306B

Blow Molding

Description

Barrier thermoplastic, Nylon blend with HDPE

Application

Agrochemical Container, SORE* Fuel Tank, PFC

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	0.96
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	
Melt Flow Rate	190 °C / 2.16kg	ASTM D1238	g/10min	0.35~0.4
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	255.4
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	-
@ Break	50mm/min		%	262.7
Flexural Strength, 6.4mm	10mm/min	ASTM D790	kg/cm ²	321
Flexural Modulus, 6.4mm	10mm/min	ASTM D790	kg/cm ²	8,525
IZOD Impact Strength, 6.4mm		ASTM D256		
(Notched)	23 °C		kg·cm/cm	65.4
	-40 °C		kg·cm/cm	6.8
Rockwell Hardness	R-Scale	ASTM D785	-	-
Thermal				
Heat Deflection Temperature, 3.2mm		ASTM D648		
(Unannealed)	4.6kg		°C	-

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection moulded specimens and after 48 hours storage at 23°C, 50% relative humidity.

Updated : 9-Nov-09

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Processing Guide (Blow Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	80 ~ 90
Drying Time		hrs	3 ~ 4
Minimum Moisture Content		%	0.01
Melt Temperature		°C	200 ~ 230
Barrel Temperature	Rear	°C	175 ~ 215
	Middle	°C	175 ~ 215
	Front	°C	175 ~ 215
Head Temperature		°C	175 ~ 215
Die Temperature		°C	175 ~ 215
Mold Temperature		kg/cm ²	30 ~ 50
Screw Speed		rpm	10 ~ 50

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