

WPP PP PPC3220-Natural

Polypropylene Copolymer
Washington Penn Plastic Co. Inc.

Message:

WPP PP PPC3220-Natural is a polypropylene copolymer (PP Copoly) product. It is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. Typical application areas are: automotive industry.
Features include:
Copolymer
Good stiffness
Impact resistance

General Information			
Features	Rigid, good		
	Copolymer		
	Impact resistance, good		
	Medium liquidity		
Uses	Application in Automobile Field		
	Car interior equipment		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	39	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	26.9	MPa	ASTM D638
Flexural Modulus - Tangent ²	1170	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	64	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	100	°C	ASTM D648
Additional Information			
Dart Impact, GM 9300P, -30°C: 18J			
Injection	Nominal Value	Unit	
Drying Temperature	71.1 - 87.8	°C	
Drying Time	1.0	hr	
Rear Temperature	204 - 210	°C	
Middle Temperature	210 - 216	°C	

Front Temperature	216 - 221	°C
Nozzle Temperature	221 - 227	°C
Mold Temperature	15.6 - 48.9	°C
Injection Pressure	4.14 - 7.58	MPa
Holding Pressure	1.03 - 4.14	MPa
Back Pressure	0.517 - 1.03	MPa
Clamp Tonnage	3.4 - 5.5	kN/cm ²
Cushion	3.18 - 6.35	mm

Injection instructions

Injection Speed: 1.5 to 2.5 in/s Zone 4 Temperature: 420 to 430°F Hot Runner Temperature: 410 to 440°F Hydraulic Oil Temperature: 110 to 125°F Shot Capacity vs. Barrel Capacity: 2.5 to 4 Screw Decompression: 0.1 to 0.25 in

NOTE

1. 51 mm/min
2. 1.3 mm/min

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