

WPP PP PPH4CF-4

Polypropylene Homopolymer
Washington Penn Plastic Co. Inc.

Message:

Available in colors with FDA recognition for food packaging applications. Compounds are offered with high gloss. Available in grades recognized by UL for RTI classification of 120°C at .120" minimum thickness. Good balance of ductility and stiffness. It is also offered with extra heat stabilizers or with UV stabilizers for improved weather resistance. Some versions incorporate antistatic additives and all can be color matched to meet styling requirements.
Note: Custom colors available upon request.

General Information			
Filler / Reinforcement	Calcium carbonate filler, 40% filler by weight		
Features	Homopolymer		
	General		
Uses	Industrial application		
	Furniture		
	Application in Automobile Field		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.23	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.4 - 1.8	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Durometer Hardness (Shore D)	79		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	26.5	MPa	ASTM D638
Tensile Elongation ² (Break)	46	%	ASTM D638
Flexural Modulus - Tangent	2530	MPa	ASTM D790
Flexural Strength	61.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.18 mm	32	J/m	ASTM D256
23°C, 3.18 mm	44	J/m	ASTM D256
Unnotched Izod Impact (23°C, 3.18 mm)	1400	J/m	ASTM D256
Dart Drop Impact			ASTM D3029
-30°C	12.9	J	ASTM D3029
23°C	18.1	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	115	°C	ASTM D648
1.8 MPa, not annealed	71.7	°C	ASTM D648

Additional Information

Flexural Modulus, ASTM D790, 2% Secant: 256000 psi

Injection	Nominal Value	Unit
Drying Temperature	71.1 - 87.8	°C
Drying Time	1.0	hr
Rear Temperature	218 - 224	°C
Middle Temperature	218 - 224	°C
Front Temperature	221 - 227	°C
Nozzle Temperature	227 - 238	°C
Mold Temperature	15.6 - 48.9	°C
Injection Pressure	4.14 - 7.58	MPa
Holding Pressure	1.72 - 4.83	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/sZone 4 Temperature: 440 to 450°FHot Runner Temperature: 440 to 470°FHydraulic Oil Temperature: 110 to 125°FShot Capacity vs. Barrel Capacity: 2.5 to 4Screw Decompression: 0.1 to 0.25 in

NOTE

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

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