

Ferro PP TPP40AC45BK

Polypropylene

Ferro Corporation

Message:

Meets/Exceeds Ford Engineering Specification ESA-M4D166-A.
Primary end use is for fan shrouds and battery covers.

General Information			
Filler / Reinforcement	Talc,40% Filler by Weight		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
	Homopolymer		
Appearance	Black		
Forms	Pellets		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	5.6	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.3	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	74		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (23°C)	31.7	MPa	ASTM D638
Tensile Elongation (Yield)	4.0	%	ASTM D638
Flexural Modulus	3800	MPa	ASTM D790
Flexural Strength (Yield)	52.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	27	J/m	ASTM D256
Unnotched Izod Impact (23°C)	240	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	131	°C	
1.8 MPa, Unannealed	80.0	°C	
Injection	Nominal Value	Unit	
Drying Temperature	93.3	°C	
Drying Time	2.0 to 3.0	hr	
Rear Temperature	204 to 210	°C	
Middle Temperature	210 to 213	°C	
Front Temperature	213 to 216	°C	
Nozzle Temperature	216 to 218	°C	

Mold Temperature	43.3 to 54.4	°C
Back Pressure	0.138 to 0.345	MPa
Screw Speed	100 to 150	rpm
Clamp Tonnage	2.8 to 4.1	kN/cm ²
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.0:1.0	

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

