

WPP PP WPP2194-Natural

Polypropylene Copolymer
Washington Penn Plastic Co. Inc.

Message:

WPP PP WPP2194-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
Good toughness
Impact resistance
Wear-resistant

General Information			
Features	Rigid, good		
	Copolymer		
	Impact resistance, high		
	Durability		
	Good toughness		
Uses	Application in Automobile Field		
	Car interior equipment		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.898	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	10	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	20.0	MPa	ASTM D638
Flexural Modulus - Tangent ²	900	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	540	J/m	ASTM D256
Instrumented Dart Impact ³ (-30°C)	22.0	J	ASTM D3763
Injection	Nominal Value	Unit	
Drying Temperature	71.1 - 87.8	°C	
Drying Time	1.0	hr	
Rear Temperature	218 - 224	°C	
Middle Temperature	224 - 229	°C	
Front Temperature	224 - 229	°C	

Nozzle Temperature	218 - 229	°C
Mold Temperature	15.6 - 48.9	°C
Injection Pressure	4.14 - 8.27	MPa
Holding Pressure	2.07 - 4.14	MPa
Back Pressure	0.345 - 1.03	MPa
Clamp Tonnage	3.4 - 5.5	kN/cm ²
Cushion	3.18 - 6.35	mm

Injection instructions

Injection Speed: 1.25 to 2.75 in/s Zone 4 Temperature: 445 to 455°F Hot Runner Temperature: 425 to 455°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. 50 mm/min
2. 1.3 mm/min
3. 2.20 m/sec

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