

WPP PP PPH5GF2-7894 Black

Polypropylene Homopolymer
Washington Penn Plastic Co. Inc.

Message:

WPP PP PPH5GF2-7894 Black is a polypropylene homopolymer (PP Homopoly) product, which contains a 20% glass fiber reinforced material. It can be processed by injection molding and is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific.

Features include:

- High stiffness
- high strength
- Homopolymer

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Features	Rigidity, high		
	High tensile strength		
	Homopolymer		
Appearance	Black		
	Available colors		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	12	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 23°C)	63.4	MPa	ASTM D638
Flexural Modulus ² (23°C)	3430	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	64	J/m	ASTM D256
Injection	Nominal Value	Unit	
Drying Temperature	71.1 - 87.8	°C	
Drying Time	1.0	hr	
Rear Temperature	216 - 227	°C	
Middle Temperature	221 - 232	°C	
Front Temperature	227 - 238	°C	
Nozzle Temperature	216 - 227	°C	
Mold Temperature	26.7 - 48.9	°C	
Injection Pressure	4.14 - 8.96	MPa	
Holding Pressure	1.03 - 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: 1.0 - 2.5 in/s
Hot Runner Temperature: 420 - 450°F
Hydraulic Oil Temperature: 110 - 125°F
Shot Capacity vs. Barrell Capacity: 2.5 - 4.0
Screw Decompression: 0.10 - 0.25 in

NOTE

- | | |
|----|-----------|
| 1. | 51 mm/min |
| 2. | 13 mm/min |

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