

WPP PP PPH3TF4-Natural

Polypropylene Homopolymer
Washington Penn Plastic Co. Inc.

Message:

Properties shown below for this filled blend are typical for a 40% talc- enforced polypropylene homopolymer. This product satisfies many application needs. Special compounds are available to meet application requirements.

General Information			
Filler / Reinforcement	Talc filler, 40% filler by weight		
Additive	heat stabilizer		
Features	Homopolymer		
	Thermal Stability		
Uses	Electrical appliances		
	Application in Automobile Field		
	Toys		
Appearance	Available colors		
	Natural color		
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)	5.0	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	33.0	MPa	ASTM D638
Flexural Modulus - Secant ²	3500	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	23	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	89.0	°C	ASTM D648
Additional Information			
Tested at 23 ± 2°C (73.4 ± 3.6°F) and 50 ± 5% relative humidity unless otherwise noted.			
Injection	Nominal Value	Unit	
Drying Temperature	71.1 - 87.8	°C	
Drying Time	1.0	hr	
Rear Temperature	221 - 227	°C	
Middle Temperature	221 - 227	°C	
Front Temperature	224 - 229	°C	

Nozzle Temperature	229 - 241	°C
Mold Temperature	15.6 - 48.9	°C
Injection Pressure	4.14 - 7.58	MPa
Holding Pressure	1.72 - 4.83	MPa
Back Pressure	0.689 - 1.38	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: 445 to 455°FHot Runner Temperature: 445 to 475°FHydraulic Oil Temperature: 110 to 125°FShot Capacity vs. Barrel Capacity: 2.5 to 4Screw Decompression: 0.1 to 0.25 in

NOTE

1.	50 mm/min
2.	1.3 mm/min

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