

WPP TPO TPO-2561 P Black

Compounded Polypropylene
Washington Penn Plastic Co. Inc.

Message:

WPP TPO TPO-2561 P Black is a composite polypropylene 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:
Hard
Good toughness
Impact resistance
soft

General Information			
Features	Impact resistance, good		
	Sprayable		
	Good toughness		
	ductility		
	Medium hardness		
Uses	Application in Automobile Field		
	Strap		
Appearance	Black		
	Available colors		
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
Tensile Elongation ² (Break)	500	%	ASTM D638
Flexural Modulus - Tangent ³	700	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	530	J/m	ASTM D256
Instrumented Dart Impact ⁴ (-30°C)	23.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Linear thermal expansion coefficient			ASTM E831
Flow	1.3E-4	cm/cm/°C	ASTM E831
Lateral	2.1E-4	cm/cm/°C	ASTM E831
Additional Information			

Tensile Elongation at Break, ASTM D638, 50mm/min: >500%

Injection	Nominal Value	Unit
Drying Temperature	71.1 - 87.8	°C
Drying Time	1.0	hr
Rear Temperature	199 - 210	°C
Middle Temperature	210 - 216	°C
Front Temperature	216 - 227	°C
Nozzle Temperature	210 - 227	°C
Mold Temperature	15.6 - 48.9	°C
Injection Pressure	4.14 - 10.3	MPa
Holding Pressure	1.72 - 4.14	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: 0.25 to 2.5 in/s Zone 4 Temperature: 420 to 445°F Hot Runner Temperature: 420 to 460°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. 50 mm/min
3. 33 mm/min
4. 2.20 m/sec

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