

Technical Data Sheet

Ferropak TPP40WA04NA

Polypropylene
LyondellBasell Industries
Engineering Plastics

General			
Filler / Reinforcement	• Talc, 41% Filler by Weight		
Features	• Homopolymer		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.26	1.26 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 Kg)	1.5 g/10 min	1.5 g/10 min	ASTM D1238

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	5200 psi	35.9 MPa	ASTM D638
Tensile Elongation (Break)	7.0 %	7.0 %	ASTM D638
Flexural Modulus			ASTM D790
1% Secant	558000 psi	3850 MPa	
Tangent	742000 psi	5120 MPa	
Flexural Strength (Yield)	9200 psi	63.4 MPa	ASTM D790

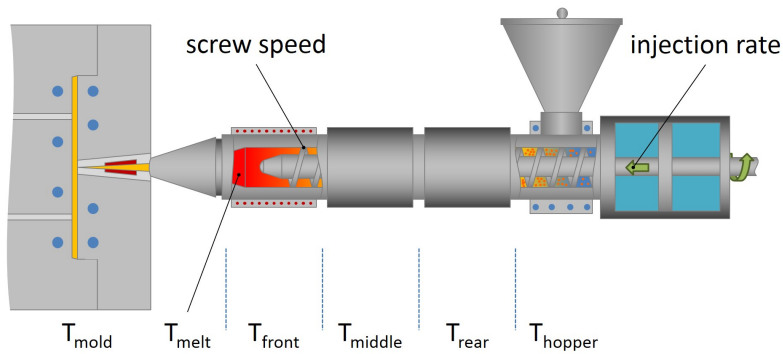
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact	0.50 ft·lb/in	27 J/m	ASTM D256
Unnotched Izod Impact	4.6 ft·lb/in	250 J/m	ASTM D4812
Gardner Impact	16.5 in·lb	1.86 J	ASTM D3029

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	290 °F	143 °C	
264 Psi (1.8 Mpa), Unannealed	220 °F	104 °C	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	200 °F	93 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Rear Temperature	400 to 410 °F	204 to 210 °C
Middle Temperature	410 to 415 °F	210 to 213 °C
Front Temperature	415 to 420 °F	213 to 216 °C
Nozzle Temperature	420 to 425 °F	216 to 218 °C
Mold Temperature	110 to 130 °F	43 to 54 °C
Back Pressure	20.0 to 50.0 psi	0.138 to 0.345 MPa
Screw Speed	100 to 150 rpm	100 to 150 rpm
Clamp Tonnage	2.0 to 3.0 tons/in ²	2.8 to 4.1 kN/cm ²
Screw L/D Ratio	20.0:1.0	20.0:1.0
Screw Compression Ratio	2.0:1.0	2.0:1.0

Notes

These are typical property values not to be construed as specification limits.