

Technical Data Sheet

Ferro Pp TPP20AN53NA

Polypropylene
LyondellBasell Industries
Engineering Plastics

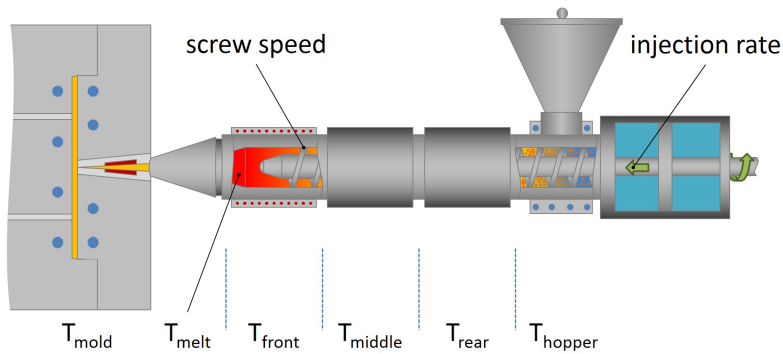
General			
Filler / Reinforcement	• Talc, 20% Filler by Weight		
Features	• General Purpose	• Good Dimensional Stability	• Good Impact Resistance
Uses	• Automotive Applications		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.06	1.06 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 Kg)	7.0 g/10 min	7.0 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	4500 psi	31.0 MPa	ASTM D638
Tensile Elongation (Break)	25 %	25 %	ASTM D638
Flexural Modulus	300000 psi	2070 MPa	ASTM D790
Flexural Strength (Yield)	6500 psi	44.8 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (73°F (23°C))	0.70 ft·lb/in	37 J/m	ASTM D256
Unnotched Izod Impact (73°F (23°C))	14 ft·lb/in	750 J/m	ASTM D4812
Gardner Impact (0.125 In (3.18 Mm))	20.0 in·lb	2.26 J	ASTM D3029
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Durometer Hardness (Shore D)	71	71	ASTM D2240
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	250 °F	121 °C	
264 Psi (1.8 Mpa), Unannealed	155 °F	68.3 °C	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °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
Processing (Melt) Temp	428 to 500 °F	220 to 260 °C
Mold Temperature	86 to 140 °F	30 to 60 °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.