

Technical Data Sheet

Ferro PP TPP20AO27NA-NA

Polypropylene
Engineering Plastics

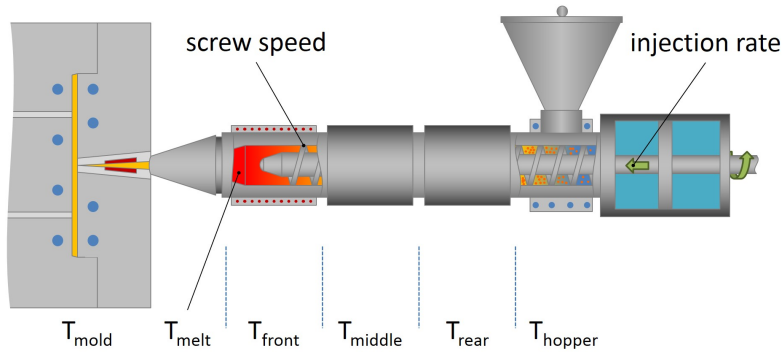


Product Description			
20% Talc Filled, Impact Modified, UV and Heat Stabilized Polypropylene, Natural			
General			
Filler / Reinforcement	• Talc, 20% Filler by Weight		
Additive	• Impact Modifier		
Features	• General Purpose • Good Impact Resistance • Good Dimensional Stability • Impact Modified		
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.05 g/cm³	1.05 g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	16 g/10 min	16 g/10 min	ISO 1133
Molding Shrinkage	0.60 to 1.1 %	0.60 to 1.1 %	ISO 294-4
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (73°F (23°C))	4280 psi	29.5 MPa	ASTM D638
Flexural Modulus - Chord	390000 psi	2690 MPa	ISO 178
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength	1.5 ft·lb/in²	3.1 kJ/m²	ISO 179
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	221 °F	105 °C	ISO 75-2/B
264 psi (1.8 MPa), Unannealed	156 °F	69.0 °C	ISO 75-2/A

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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.