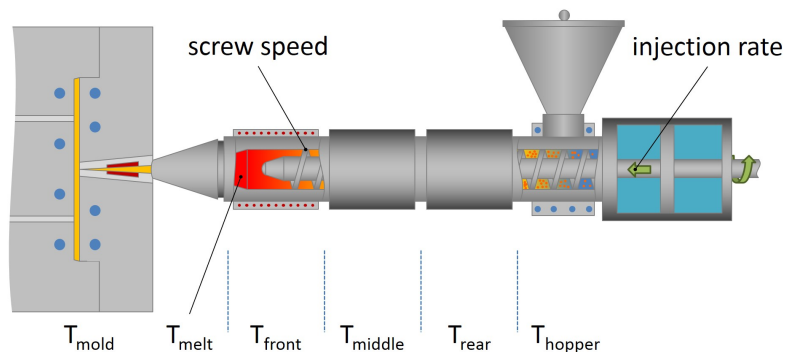


Technical Data Sheet
Matrixx TPP1B40
Polypropylene
Engineering Plastics



General			
Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Talc, 40% Filler by Weight		
Forms	• Pellets		
Processing Method	• Injection Molding		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.25	1.25 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	10 g/10 min	10 g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in (3.18 mm))	5.0E-3 to 9.0E-3 in/in	0.50 to 0.90 %	Internal Method
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	4500 psi	31.0 MPa	ASTM D638
Flexural Modulus - Tangent	540000 psi	3720 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
Gardner Impact	< 10.0 in·lb	< 1.13 J	ASTM D5420
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi (0.45 MPa), Unannealed	270 °F	132 °C	
264 psi (1.8 MPa), Unannealed	180 °F	82.2 °C	
RTI Str	65.0 °F	18.3 °C	UL 746
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.06 in (1.5 mm))	HB	HB	UL 94

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	180 to 220 °F	82 to 104 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Rear Temperature	350 to 430 °F	177 to 221 °C
Middle Temperature	350 to 430 °F	177 to 221 °C
Front Temperature	350 to 430 °F	177 to 221 °C
Processing (Melt) Temp	390 to 440 °F	199 to 227 °C
Mold Temperature	70 to 120 °F	21 to 49 °C
Injection Rate	Moderate	Moderate
Back Pressure	20.0 to 300 psi	0.138 to 2.07 MPa
Cushion	0.250 to 0.500 in	6.35 to 12.7 mm

Injection Notes

Drying not normally required
Injection Booster Pressure: Maximum without flash, 60% of machine maximum, target
Screw Speed: Slow to Medium

Notes

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