

# WPP PP PPC3220-Natural

Washington Penn Plastic Co. Inc. - Polypropylene Copolymer

Wednesday, October 9, 2019

## General Information

### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Copolymer • Good Impact Resistance	• Good Stiffness • Medium Flow	
Uses	• Automotive Applications	• Automotive Interior Trim	
Appearance	• Colors Available	• Natural Color	
Forms	• Pellets		

## ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	39	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield)	26.9	MPa	ASTM D638
Flexural Modulus - Tangent <sup>3</sup>	1170	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	64	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	100	°C	ASTM D648
Additional Information			
Dart Impact, GM 9300P, -30°C: 18J			

## Processing Information

Injection	Nominal Value	Unit
Drying Temperature	71 to 88	°C
Drying Time	1.0	hr
Rear Temperature	204 to 210	°C
Middle Temperature	210 to 216	°C
Front Temperature	216 to 221	°C
Nozzle Temperature	221 to 227	°C
Mold Temperature	16 to 49	°C
Injection Pressure	4.14 to 7.58	MPa
Holding Pressure	1.03 to 4.14	MPa
Back Pressure	0.517 to 1.03	MPa
Clamp Tonnage	3.4 to 5.5	kN/cm <sup>2</sup>
Cushion	3.18 to 6.35	mm

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### Injection Notes

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Injection Speed: 1.5 to 2.5 in/s

Zone 4 Temperature: 420 to 430°F

Hot Runner Temperature: 410 to 440°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

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 51 mm/min

<sup>3</sup> 1.3 mm/min