WPP PP PPC3225

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		
Forms	• Pellets		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.898	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20	g/10 min	ASTM D1238
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2] (Yield)	22.0	MPa	ASTM D638
Flexural Modulus - Tangent [3]	1000	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C)	120	J/m	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore D)	70		ASTM D2240

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/cm²
Cushion	3.18 to 6.35	mm

Injection Notes

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

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Notes

[1] Typical properties: these are not to be construed as specifications.

[2] 50 mm/min

[3] 1.3 mm/min