



# WPP PP PPH3TF4-Natural

Washington Penn Plastic Co. Inc. - Polypropylene Homopolymer

Wednesday, October 9, 2019

## General Information

### Product Description

Properties shown below for this filled blend are typical for a 40% talc- enforced polypropylene homopolymer. This product satisfies many application needs. Special compounds are available to meet application requirements.

### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Talc, 40% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Heat Stabilized	• Homopolymer	
Uses	• Appliances	• Automotive Applications	• Toys
Appearance	• Colors Available	• Natural Color	
Forms	• Pellets		

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield)	33.0	MPa	ASTM D638
Flexural Modulus - Secant <sup>3</sup>	3500	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	23	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	89.0	°C	ASTM D648

### Additional Information

Tested at 23 ± 2°C (73.4 ± 3.6°F) and 50 ± 5% relative humidity unless otherwise noted.

## Processing Information

Injection	Nominal Value	Unit
Drying Temperature	71 to 88	°C
Drying Time	1.0	hr
Rear Temperature	221 to 227	°C
Middle Temperature	221 to 227	°C
Front Temperature	224 to 229	°C
Nozzle Temperature	229 to 241	°C
Mold Temperature	16 to 49	°C
Injection Pressure	4.14 to 7.58	MPa
Holding Pressure	1.72 to 4.83	MPa
Back Pressure	0.689 to 1.38	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

Injection Speed: 1.5 to 2.5 in/s

Zone 4 Temperature: 445 to 455°F

Hot Runner Temperature: 445 to 475°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> 50 mm/min

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