



WPP PP PPH5CF3-Black

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 33% calcium carbonate filled polypropylene homopolymer.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Calcium Carbonate, 32% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Good Dimensional Stability • Good Impact Resistance	• Good Stiffness • Heat Stabilized	• Homopolymer
Uses	• Automotive Applications	• Consumer Applications	
Appearance	• Black	• Colors Available	
Forms	• Pellets		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	18	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	19.0	MPa	ISO 527-2/5
Flexural Modulus ²	2350	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-40°C	3.5	kJ/m ²	
23°C	4.8	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	65.0	°C	ISO 75-2/A

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	216 to 221	°C
Middle Temperature	216 to 221	°C
Front Temperature	218 to 224	°C
Nozzle Temperature	224 to 235	°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	0.517 to 1.03	MPa
Clamp Tonnage	3.4 to 5.5	kN/cm ²

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Injection	Nominal Value	Unit
Cushion	3.18 to 6.35	mm

Injection Notes

Injection Speed: 1.5 to 2.5 in/s

Zone 4 Temperature: 435 to 445°F

Hot Runner Temperature: 435 to 465°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

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

² 2.0 mm/min