

WPP PP PPH4CF-2

Polypropylene Homopolymer
Washington Penn Plastic Co. Inc.

Message:

Grades available with UL recognition for 110° C RTI at 0.120" minimum thickness. Available with antistatic properties. Good wet/dry stabilizer extraction resistance. Available in colors.
Note: Custom colors available upon request.

General Information			
Filler / Reinforcement	Calcium carbonate filler, 20% filler by weight		
Additive	Antistatic property		
Features	Homopolymer		
	Pull-out resistance		
	Good heat aging resistance		
Uses	Electrical appliances		
	General		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.2 - 1.6	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	98		ASTM D785
Durometer Hardness (Shore D)	77		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	31.7	MPa	ASTM D638
Tensile Elongation ² (Break)	250	%	ASTM D638
Flexural Modulus - Tangent	1990	MPa	ASTM D790
Flexural Strength	60.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.18 mm	29	J/m	ASTM D256
23°C, 3.18 mm	27	J/m	ASTM D256
Unnotched Izod Impact (23°C, 3.18 mm)	1000	J/m	ASTM D256
Dart Drop Impact			ASTM D3029
-30°C	3.39	J	ASTM D3029
23°C	18.1	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	110	°C	ASTM D648
1.8 MPa, not annealed	62.2	°C	ASTM D648

Additional Information

Flexural Modulus, ASTM D790, 2% Secant: 281000 psi

Injection	Nominal Value	Unit
Drying Temperature	71.1 - 87.8	°C
Drying Time	1.0	hr
Rear Temperature	218 - 224	°C
Middle Temperature	218 - 224	°C
Front Temperature	221 - 227	°C
Nozzle Temperature	227 - 238	°C
Mold Temperature	15.6 - 48.9	°C
Injection Pressure	4.14 - 7.58	MPa
Holding Pressure	1.72 - 4.83	MPa
Back Pressure	0.517 - 1.03	MPa
Clamp Tonnage	3.4 - 5.5	kN/cm ²
Cushion	3.18 - 6.35	mm

Injection instructions

Injection Speed: 1.5 to 2.5 in/sZone 4 Temperature: 440 to 450°FHot Runner Temperature: 440 to 470°FHydraulic Oil Temperature: 110 to 125°FShot Capacity vs. Barrel Capacity: 2.5 to 4Screw Decompression: 0.1 to 0.25 in

NOTE

1. 51 mm/min
2. 51 mm/min

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