

WPP PP PPH4TF-2

Polypropylene Homopolymer

Washington Penn Plastic Co. Inc.

Message:

WPP PP PPH4TF-2 is a polypropylene homopolymer (PP Homopoly) product, which contains 20% talc filler. It is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. WPP PPH4TF-2 applications include industrial applications, furniture and automobile industries.

Features include:

Homopolymer

Antistatic

Good UV resistance

heat stabilizer

UV stability

General Information

Filler / Reinforcement	Talc filler, 20% filler by weight
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Additive	Antistatic property heat stabilizer UV stabilizer
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Features	Homopolymer Antistatic property Good UV resistance Medium liquidity Thermal Stability
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Uses	Industrial application Furniture Application in Automobile Field General
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Forms	Particle
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Physical	Nominal Value	Unit	Test Method
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Specific Gravity	1.07	g/cm ³	ASTM D792
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Melt Mass-Flow Rate (MFR)	10	g/10 min	ASTM D1238
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Molding Shrinkage - Flow	1.3 - 1.7	%	ASTM D955
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Hardness	Nominal Value	Unit	Test Method
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Rockwell Hardness (R-Scale)	93		ASTM D785
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Durometer Hardness (Shore D)	75		ASTM D2240
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Mechanical	Nominal Value	Unit	Test Method
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Tensile Strength ¹ (Yield)	33.8	MPa	ASTM D638
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Tensile Elongation ² (Break)	17	%	ASTM D638
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Flexural Modulus - Tangent	3190	MPa	ASTM D790
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Flexural Strength	48.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.18 mm	27	J/m	ASTM D256
23°C, 3.18 mm	31	J/m	ASTM D256
Unnotched Izod Impact (23°C, 3.18 mm)	340	J/m	ASTM D256
Dart Drop Impact			ASTM D3029
-30°C	2.71	J	ASTM D3029
23°C	0.678	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	131	°C	ASTM D648
1.8 MPa, not annealed	74.4	°C	ASTM D648
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	0.689 - 1.38	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/s Zone 4 Temperature: 440 to 450°F Hot Runner Temperature: 440 to 470°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

NOTE

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

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