

WPP TPO TPO-247

Compounded Polypropylene
Washington Penn Plastic Co. Inc.

Message:

This TPO compound has been tailored specifically to meet the requirements of each of the major automobile producers. Features include good scuff, nick and wear resistance and also very good ductility and practical toughness. This compound also features medium flow and an excellent balance of impact strength and rigidity. Typical applications include air dams, facias, cladding, and other various automotive applications.

General Information			
Features	Rigidity, high		
	Impact resistance, good		
	Medium liquidity		
	Scratch resistance		
	Good wear resistance		
	Good toughness		
	ductility		
Uses	Application in Automobile Field		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.908	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)	9.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.90 - 1.3	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	55		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	17.9	MPa	ASTM D638
Tensile Elongation ² (Break)	500	%	ASTM D638
Flexural Modulus - Tangent ³	621	MPa	ASTM D790
Flexural Strength ⁴	16.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (21°C)	690	J/m	ASTM D256
Instrumented Dart Impact (-30°C)	22.6	J	ASTM D3763
Dart Drop Impact			ASTM D3029
-30°C	31.6	J	ASTM D3029
21°C	17.2	J	ASTM D3029
Injection	Nominal Value	Unit	
Drying Temperature	71.1 - 87.8	°C	
Drying Time	1.0	hr	

Rear Temperature	199 - 210	°C
Middle Temperature	210 - 216	°C
Front Temperature	216 - 227	°C
Nozzle Temperature	210 - 227	°C
Mold Temperature	15.6 - 48.9	°C
Injection Pressure	4.14 - 7.58	MPa
Holding Pressure	1.72 - 4.14	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: 0.5 to 2.5 in/s Zone 4 Temperature: 420 to 445°F Hot Runner Temperature: 420 to 450°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 |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |

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