

Ferro PP TPP40AC38WH

Polypropylene Homopolymer

Ferro Corporation

Message:

Meets/Exceeds Ford Engineering Specification WSK-M4D644-A4.
Primary end use is for instrument clusters.

General Information			
Filler / Reinforcement	Talc filler, 43% filler by weight		
Additive	heat stabilizer		
Features	Homopolymer		
	Thermal Stability		
Appearance	White		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.32	g/cm ³	ASTM D792
--	1.30	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
230°C/2.16 kg	5.7	g/10 min	ASTM D1238
230°C/2.16 kg	5.2	g/10 min	ISO 1133
Molding Shrinkage			
Flow	1.0	%	ASTM D955
--	1.3	%	ISO 294-4
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	74		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield	29.0	MPa	ASTM D638
Yield, 23°C	27.6	MPa	ISO 527-2
Tensile Elongation (Break)	11	%	ASTM D638
Flexural Modulus			
--	2900	MPa	ASTM D790
--	3800	MPa	ISO 178
Flexural Strength (Yield)	48.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	27	J/m	ASTM D256
-40°C	1.7	kJ/m ²	ISO 180

23°C	2.0	kJ/m ²	ISO 180
Unnotched Izod Impact (23°C)	270	J/m	ASTM D256
Dart Drop Impact	1.02	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	129	°C	ASTM D648
0.45 MPa, not annealed	130	°C	ISO 75-2/B
1.8 MPa, not annealed	82.2	°C	ASTM D648
1.8 MPa, not annealed	82.0	°C	ISO 75-2/A
Additional Information			
Tensile/Izod Change, ISO 188, 2000 hours, 150°C: +11%/-8%			
Injection	Nominal Value	Unit	
Drying Temperature	93.3	°C	
Drying Time	2.0 - 3.0	hr	
Rear Temperature	204 - 210	°C	
Middle Temperature	210 - 213	°C	
Front Temperature	213 - 216	°C	
Nozzle Temperature	216 - 218	°C	
Mold Temperature	43.3 - 54.4	°C	
Back Pressure	0.138 - 0.345	MPa	
Screw Speed	100 - 150	rpm	
Clamp Tonnage	2.8 - 4.1	kN/cm ²	
Screw L/D Ratio	20.0:1.0		
Screw Compression Ratio	2.0:1.0		

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