

Ferro PP TPP20AC17BK

Polypropylene Homopolymer

Ferro Corporation

Message:

Meets/Exceeds Ford Engineering Specification ESH-M4D293-B.
Primary end use is for AC/heater ducts and similar components.

General Information			
Filler / Reinforcement	Talc,20% Filler by Weight		
Additive	Heat Stabilizer		
Features	General Purpose		
	Heat Stabilized		
	Homopolymer		
Appearance	Black		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	6.2	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.6	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	100		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (23°C)	30.7	MPa	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
Flexural Modulus	2400	MPa	ASTM D790
Flexural Strength (Yield)	51.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	32	J/m	ASTM D256
Unnotched Izod Impact (23°C)	510	J/m	ASTM D256
Gardner Impact	0.678	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	120	°C	
1.8 MPa, Unannealed	69.0	°C	
Injection	Nominal Value	Unit	
Drying Temperature	93.3	°C	
Drying Time	2.0 to 3.0	hr	
Rear Temperature	204 to 210	°C	

Middle Temperature	210 to 213	°C
Front Temperature	213 to 216	°C
Nozzle Temperature	216 to 218	°C
Mold Temperature	43.3 to 54.4	°C
Back Pressure	0.138 to 0.345	MPa
Screw Speed	100 to 150	rpm
Clamp Tonnage	2.8 to 4.1	kN/cm ²
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.0:1.0	

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