Ferro PP TPP13AC03BK

Polypropylene Homopolymer

Ferro Corporation

Message:

Meets/Exceeds Ford Engineering Specification ESB-M4D606-A.
Primary end use is for armrest inserts and visor panel cores.

General Information			
Filler / Reinforcement	Talc filler, 13% filler by weight		
Additive	heat stabilizer		
Features	Homopolymer Thermal Stability		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.01	g/cm³	ASTM D792, ISO 1183/A
Melt Mass-Flow Rate (MFR)			
230°C/2.16 kg	7.0	g/10 min	ASTM D1238
230°C/2.16 kg	6.0	g/10 min	ISO 1133
Molding Shrinkage			
Flow	1.5	%	ASTM D955
--	1.6	%	ISO 294-4
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness (Shore D)	73		ASTM D2240
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength			
Yield	35.2	MPa	ASTM D638
Yield, 23°C	32.8	MPa	ISO 527-2
Tensile Elongation (Break)	26	%	ASTM D638
Flexural Modulus			
--	1930	MPa	ASTM D790
--	2340	MPa	ISO 178
Flexural Strength (Yield)	50.3	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	32	J/m	ASTM D256
-40°C	2.3	kJ/m²	ISO 180
23°C	2.7	kJ/m²	ISO 180

Unnotched Izod Impact (23°C)	640	J/m	ASTM D256
Dart Drop Impact	1.13	J	ASTM D3029

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	116	°C	ASTM D648
0.45 MPa, not annealed	113	°C	ISO 75-2/B
1.8 MPa, not annealed	65.6	°C	ASTM D648
1.8 MPa, not annealed	64.0	°C	ISO 75-2/A

Additional Information
Tensile/Izod Change, ISO 188, 1000 hours, 140°C: +2%/-4%

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	

Recommended distributors for this material

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