

WPP PP PPH4TF-3

Polypropylene Homopolymer
Washington Penn Plastic Co. Inc.

Message:

WPP PP PPH4TF-3 is a polypropylene homopolymer (PP Homopoly) product, which contains 30% talc filler. It is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. Typical application areas are: medical/health care. The main characteristics are: homopolymer.

General Information			
Filler / Reinforcement	Talc filler, 30% filler by weight		
Features	Homopolymer		
Uses	Medical/nursing supplies		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 - 1.2	%	ASTM D955
Water Absorption (24 hr)	0.020	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	90		ASTM D2240
Shaw D	74		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	33.8	MPa	ASTM D638
Tensile Elongation (Break)	12	%	ASTM D638
Flexural Modulus	3280	MPa	ASTM D790
Flexural Strength (Yield)	51.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, 3.18 mm	35	J/m	ASTM D256
23°C, 6.35 mm	29	J/m	ASTM D256
Unnotched Izod Impact			ASTM D256
23°C, 3.18 mm	360	J/m	ASTM D256
23°C, 6.35 mm	310	J/m	ASTM D256
Dart Drop Impact (23°C)	1.02	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	124	°C	ASTM D648
1.8 MPa, not annealed	70.0	°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

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Susheng Import & Export Trading Co., Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

