

WPP PP PPC2CF-2

Polypropylene Copolymer
Washington Penn Plastic Co. Inc.

Message:

Versions are available with various levels of copolymer to achieve desired levels of impact and modulus balance. Colors available meeting FDA requirements for food contact applications. Compounds are offered with higher gloss.
Note: Custom colors available upon request.

General Information			
Filler / Reinforcement	Calcium carbonate filler, 20% filler by weight		
Features	Copolymer		
	Impact resistance, good		
	Medium liquidity		
	ductility		
Uses	Electrical appliances		
	Household goods		
	Toys		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.4 - 2.2	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	83		ASTM D785
Durometer Hardness (Shore D)	67		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	18.6	MPa	ASTM D638
Tensile Elongation ² (Break)	440	%	ASTM D638
Flexural Modulus - Tangent	986	MPa	ASTM D790
Flexural Strength	30.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.18 mm	40	J/m	ASTM D256
23°C, 3.18 mm	190	J/m	ASTM D256
Unnotched Izod Impact (23°C, 3.18 mm)	1400	J/m	ASTM D256
Dart Drop Impact			ASTM D3029
-30°C	24.4	J	ASTM D3029
23°C	18.1	J	ASTM D3029

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	83.3	°C	ASTM D648
1.8 MPa, not annealed	43.9	°C	ASTM D648

Additional Information

Flexural Modulus, ASTM D790, 2% Secant: 142000 psi

Injection	Nominal Value	Unit
Drying Temperature	71.1 - 87.8	°C
Drying Time	1.0	hr
Rear Temperature	224 - 229	°C
Middle Temperature	224 - 229	°C
Front Temperature	227 - 232	°C
Nozzle Temperature	232 - 243	°C
Mold Temperature	15.6 - 48.9	°C
Injection Pressure	4.14 - 7.58	MPa
Holding Pressure	1.72 - 4.83	MPa
Back Pressure	0.517 - 1.03	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: 450 to 460°F Hot Runner Temperature: 450 to 480°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

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