

WPP PP PPH3MG3.5-Black

Polypropylene Homopolymer
Washington Penn Plastic Co. Inc.

Message:

Properties shown below for this filled blend are typical for a 35% mica and glass fiber reinforced polypropylene homopolymer. This product satisfies many application needs. Special compounds are available. UV stabilization for improved weatherability available.

| General Information | | | |
|---|----------------------------------|-------------------|-------------|
| Filler / Reinforcement | Glass/Mica, 35% filler by weight | | |
| Additive | heat stabilizer | | |
| Features | Homopolymer | | |
| | Heat resistance, high | | |
| | Thermal Stability | | |
| Uses | Application in Automobile Field | | |
| Appearance | Black | | |
| | Available colors | | |
| Forms | Particle | | |
| Physical | Nominal Value | Unit | Test Method |
| Specific Gravity | 1.17 | g/cm ³ | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 11 | g/10 min | ASTM D1238 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Strength ¹ (Yield) | 56.0 | MPa | ASTM D638 |
| Flexural Modulus - Secant ² | 4150 | MPa | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (23°C) | 43 | J/m | ASTM D256 |
| Unnotched Izod Impact (23°C) | 400 | J/m | ASTM D256 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load | | | ASTM D648 |
| 0.45 MPa, not annealed | 153 | °C | ASTM D648 |
| 1.8 MPa, not annealed | 140 | °C | ASTM D648 |
| Additional Information | | | |
| Tested at 23 ± 2°C (73.4 ± 3.6°F) and 50 ± 5% relative humidity unless otherwise noted.Filler Content, In-house #1003-02: 35% | | | |
| Injection | Nominal Value | Unit | |
| Drying Temperature | 71.1 - 87.8 | °C | |
| Drying Time | 1.0 - 3.0 | hr | |
| Rear Temperature | 221 - 229 | °C | |
| Middle Temperature | 229 - 235 | °C | |
| Front Temperature | 229 - 241 | °C | |

| | | |
|--------------------|--------------|--------------------|
| Nozzle Temperature | 221 - 243 | °C |
| Mold Temperature | 15.6 - 48.9 | °C |
| Injection Pressure | 4.14 - 10.3 | MPa |
| Holding Pressure | 1.03 - 4.14 | MPa |
| Back Pressure | 0.345 - 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 2.75 in/s Zone 4 Temperature: 450 to 475°F Hot Runner Temperature: 430 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

NOTE

1. 5.0 mm/min
2. 1.3 mm/min

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Recommended distributors for this material

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

