

# 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 <sup>3</sup>	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 <sup>1</sup> (Yield)	56.0	MPa	ASTM D638
Flexural Modulus - Secant <sup>2</sup>	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 <sup>2</sup>
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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