



# WPP PP PPH5GF2-7894 Black

Washington Penn Plastic Co. Inc. - Polypropylene Homopolymer

Wednesday, October 9, 2019

## General Information

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Features	• High Stiffness	• High Tensile Strength	• Homopolymer
Appearance	• Black	• Colors Available	
Processing Method	• Injection Molding		

## ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	12	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield, 23°C)	63.4	MPa	ASTM D638
Flexural Modulus <sup>3</sup> (23°C)	3430	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	64	J/m	ASTM D256

## Processing Information

Injection	Nominal Value	Unit
Drying Temperature	71 to 88	°C
Drying Time	1.0	hr
Rear Temperature	216 to 227	°C
Middle Temperature	221 to 232	°C
Front Temperature	227 to 238	°C
Nozzle Temperature	216 to 227	°C
Mold Temperature	27 to 49	°C
Injection Pressure	4.14 to 8.96	MPa
Holding Pressure	1.03 to 4.14	MPa
Back Pressure	0.345 to 1.03	MPa
Clamp Tonnage	3.4 to 5.5	kN/cm <sup>2</sup>
Cushion	3.18 to 6.35	mm

### Injection Notes

Injection Speed: 1.0 - 2.5 in/s  
 Hot Runner Temperature: 420 - 450°F  
 Hydraulic Oil Temperature: 110 - 125°F  
 Shot Capacity vs. Barrell Capacity: 2.5 - 4.0  
 Screw Decompression: 0.10 - 0.25 in

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.  
<sup>2</sup> 51 mm/min  
<sup>3</sup> 13 mm/min

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