Technical Data Sheet

Ferropak TPP40WA04NA

Polypropylene
LyondellBasell Industries
Engineering Plastics

General	
Filler / Reinforcement	• Talc, 41% Filler by Weight
Features	• Homopolymer
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.26	1.26 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°c/2.16 Kg)	1.5 g/10 min	1.5 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength (Yield)	5200 psi	35.9 MPa	ASTM D638
Tensile Elongation (Break)	7.0 %	7.0 %	ASTM D638
Flexural Modulus			ASTM D790
1% Secant	558000 psi	3850 MPa	
Tangent	742000 psi	5120 MPa	
Flexural Strength (Yield)	9200 psi	63.4 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact	0.50 ft·lb/in	27 J/m	ASTM D256
Unnotched Izod Impact	4.6 ft·lb/in	250 J/m	ASTM D4812
Gardner Impact	16.5 in·lb	1.86 J	ASTM D3029
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	290 °F	143 °C	
264 Psi (1.8 Mpa), Unannealed	220 °F	104 °C	

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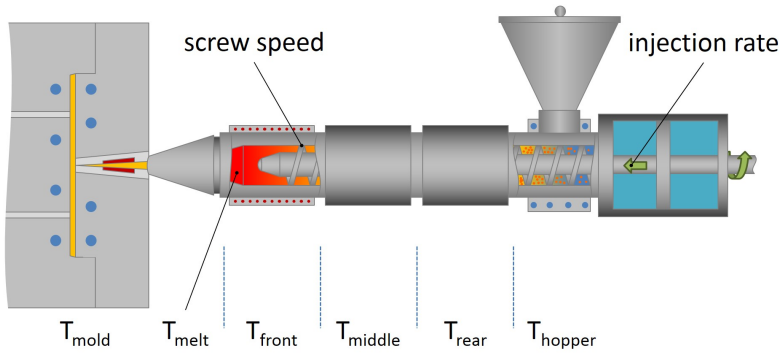

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	200 °F	93 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Rear Temperature	400 to 410 °F	204 to 210 °C
Middle Temperature	410 to 415 °F	210 to 213 °C
Front Temperature	415 to 420 °F	213 to 216 °C
Nozzle Temperature	420 to 425 °F	216 to 218 °C
Mold Temperature	110 to 130 °F	43 to 54 °C
Back Pressure	20.0 to 50.0 psi	0.138 to 0.345 MPa
Screw Speed	100 to 150 rpm	100 to 150 rpm
Clamp Tonnage	2.0 to 3.0 tons/in²	2.8 to 4.1 kN/cm²
Screw L/D Ratio	20.0:1.0	20.0:1.0
Screw Compression Ratio	2.0:1.0	2.0:1.0

Notes

These are typical property values not to be construed as specification limits.