

Technical Data Sheet

# Matrixx TPP1B20HBBK

Polypropylene  
LyondellBasell Industries  
Engineering Plastics

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Talc, 20% Filler by Weight
Forms	• Pellets
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.05	1.05 g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 Kg)	10 g/10 min	10 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	4800 psi	33.1 MPa	ASTM D638
Flexural Modulus - Tangent	360000 psi	2480 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact	0.60 ft·lb/in	32 J/m	ASTM D256
Gardner Impact	< 10.0 in·lb	< 1.13 J	ASTM D5420
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	245 °F	118 °C	
264 Psi (1.8 Mpa), Unannealed	155 °F	68.3 °C	
RTI Str	150 °F	65.6 °C	UL 746B
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.06 In (1.5 Mm))	HB	HB	UL 94

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	180 to 220 °F	82 to 104 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Rear Temperature	350 to 430 °F	177 to 221 °C
Middle Temperature	350 to 430 °F	177 to 221 °C
Front Temperature	350 to 430 °F	177 to 221 °C
Processing (Melt) Temp	390 to 440 °F	199 to 227 °C
Mold Temperature	70 to 120 °F	21 to 49 °C
Injection Rate	Moderate	Moderate
Back Pressure	20.0 to 300 psi	0.138 to 2.07 MPa
Cushion	0.250 to 0.500 in	6.35 to 12.7 mm

**Injection Notes**

- Drying not normally required
- Injection Booster Pressure: Maximum without flash, 60% of machine maximum, target
- Screw Speed: Slow to Medium

**Notes**

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