

## Technical Data Sheet

### *Polyfort* TPP20AO27NA-NANAT



Polypropylene, Unspecified (PP, Unspecified)

#### Product Description

20% Talc Filled, Impact Modified, UV and Heat Stabilized Polypropylene, Natural

<b>Processing Method</b>	Injection Molding
<b>Attribute</b>	Good Dimensional Stability; Good Impact Resistance; Impact Modified
<b>Forms</b>	Pellets
<b>Appearance</b>	Natural Color
<b>Additive</b>	Impact Modifier
<b>Application</b>	General Purpose
<b>Filler/Reinforcement</b>	Talc, 20%

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Melt Flow Rate, (230 °C/2.16 kg)	16	g/10 min	ISO 1133
Density	1.05	g/cm <sup>3</sup>	ISO 1183
<b>Mechanical</b>			
Tensile Strength, (23 °C)	29.5	MPa	ASTM D638
Flexural Modulus, (Chord)	2690	MPa	ISO 178
<b>Impact</b>			
Charpy Impact Strength - Notched	3.1	kJ/m <sup>2</sup>	ISO 179
<b>Thermal</b>			
Deflection Temperature Under Load Unannealed (0.45 MPa)	105	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa)	69	°C	ISO 75-2/A

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 3.0	hr
Drying Temperature	80	°C
Clamp Tonnage	2.8 to 4.1	kN/cm <sup>2</sup>
Nozzle Temperature	216 to 218	°C
Screw Speed	100 to 150	rpm
Processing (Melt) Temp	220 to 260	°C
Front Temperature	213 to 216	°C
Screw L/D Ratio	20.0-1.0	
Screw Compression Ratio	2.0-1.0	
Middle Temperature	210 to 213	°C
Rear Temperature	204 to 210	°C
Back Pressure	0.138 to 0.345	MPa
Mold Temperature	30 to 60	°C