

## Technical Data Sheet

### *Polyfort* TPP1D20HUNANAT



Polypropylene, Homopolymer

#### Product Description

*Polyfort* TPP1D20HUNANAT is a Polypropylene Homopolymer Talc, 20% filled material and is typically used in Injection Molding applications. Features include: Homopolymer.

<b>Processing Method</b>	Injection Molding
<b>Attribute</b>	Homopolymer
<b>Forms</b>	Pellets
<b>Filler/Reinforcement</b>	Talc, 20%

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Melt Flow Rate	35	g/10 min	ASTM D1238
Density - Specific Gravity	1.05	g/cm <sup>3</sup>	ASTM D792
<b>Mechanical</b>			
Tensile Strength at Yield, (23 °C)	32.4	MPa	ASTM D638
Flexural Modulus, (23 °C, Tangent)	2590	MPa	ASTM D790
<b>Impact</b>			
Gardner Impact	0.452	J	ASTM D3029
Notched Izod Impact, (23 °C, 3.18 mm)	27	J/m	ASTM D256
<b>Hardness</b>			
Durometer Hardness, (Shore D)	74		ASTM D2240
<b>Thermal</b>			
Deflection Temperature Under Load Unannealed (264 psi)	68.3	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	116	°C	ASTM D648

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	82 to 104	°C
Processing (Melt) Temp	199 to 227	°C
Front Temperature	177 to 221	°C
Middle Temperature	177 to 221	°C
Rear Temperature	177 to 221	°C
Injection Rate	Moderate	
Back Pressure	0.138 to 2.07	MPa
Mold Temperature	21 to 49	°C
Cushion	6.35 to 12.7	mm