

Technical Data Sheet

Polyfort TPP35AC23NA-NANAT



Polypropylene, Homopolymer

Product Description

TPP35AC23NA is a 35% Talc-Filled Polypropylene

Processing Method	Injection Molding
Attribute	Homopolymer
Forms	Pellets
Appearance	Natural Color
Filler/Reinforcement	Talc, 35%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (230 °C/2.16 kg)	4.7	g/10 min	ASTM D1238
Density - Specific Gravity	1.2	g/cm ³	ASTM D792
Mechanical			
Tensile Strength, (23 °C)	34.9	MPa	ASTM D638
Flexural Modulus			
(23 °C, 1% Secant)	3470	MPa	ASTM D790
(23 °C, Tangent)	3990	MPa	ASTM D790
Flexural Strength, (23 °C)	61.2	MPa	ASTM D790
Impact			
Unnotched Izod Impact, (23 °C)	350	J/m	ASTM D4812
Thermal			
Deflection Temperature Under Load Unannealed (66 psi)	139	°C	ASTM D648

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 ²
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