

## Technical Data Sheet

**Polyfort TPP40AC28HB-NANAT**

Polypropylene, Homopolymer

**Product Description**

TPP40AC28HB-NA is a 40% Talc-Filled Polypropylene Homopolymer

<b>Processing Method</b>	Injection Molding
<b>Attribute</b>	Homopolymer
<b>Forms</b>	Pellets
<b>Appearance</b>	Natural Color
<b>Application</b>	General Purpose
<b>Filler/Reinforcement</b>	Talc, 40%

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Melt Flow Rate, (230 °C/2.16 kg)	6.3	g/10 min	ASTM D1238
<b>Mechanical</b>			
Tensile Strength, (23 °C)	31.0	MPa	ASTM D638
Flexural Modulus, (23 °C, Tangent)	3650	MPa	ASTM D790
<b>Impact</b>			
Unnotched Izod Impact, (23 °C)	300	J/m	ASTM D4812

Injection Parameters	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