

Technical Data Sheet

Polyfort TPP20AO27NA-NANAT



Polypropylene, Unspecified (PP, Unspecified)

Product Description

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

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

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (230 °C/2.16 kg)	16	g/10 min	ISO 1133
Density	1.05	g/cm ³	ISO 1183
Mechanical			
Tensile Strength, (23 °C)	29.5	MPa	ASTM D638
Flexural Modulus, (Chord)	2690	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched	3.1	kJ/m ²	ISO 179
Thermal			
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 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