

## 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 |
|-------------------------------------------------------|---------------|-------------------|-------------|
| <b>Physical</b>                                       |               |                   |             |
| Melt Flow Rate, (230 °C/2.16 kg)                      | 4.7           | g/10 min          | ASTM D1238  |
| Density - Specific Gravity                            | 1.2           | g/cm <sup>3</sup> | ASTM D792   |
| <b>Mechanical</b>                                     |               |                   |             |
| 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   |
| <b>Impact</b>                                         |               |                   |             |
| Unnotched Izod Impact, (23 °C)                        | 350           | J/m               | ASTM D4812  |
| <b>Thermal</b>                                        |               |                   |             |
| 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 <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                 |