Polyfort TPP20AC17BK-BKBLK

LyondellBasell Industries - Polypropylene Homopolymer

General Information

Product Description

Meets/Exceeds Ford Engineering Specification ESH-M4D293-B.
Primary end use is for AC/heater ducts and similar components.

General

Filler / Reinforcement	• Talc, 20% Filler by Weight	
Additive	• Heat Stabilizer	
Features	• Heat Stabilized	• Homopolymer
Uses	• General Purpose	
Appearance	• Black	
Forms	• Pellets	
Processing Method	• Injection Molding	

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.06		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20	g/10 min	ASTM D1238
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (73°F)	4450	psi	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
Flexural Modulus	348000	psi	ASTM D790
Flexural Strength (Yield)	7500	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F)	0.60	ft·lb/in	ASTM D256
Unnotched Izod Impact (73°F)	9.6	ft·lb/in	ASTM D4812
Gardner Impact	6.00	in·lb	ASTM D3029
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	100		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	248	°F	ASTM D648
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed	156	°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	399 to 410	°F
Middle Temperature	410 to 415	°F
Front Temperature	415 to 421	°F
Nozzle Temperature	421 to 424	°F
Processing (Melt) Temp	428 to 500	°F
Mold Temperature	86 to 140	°F
Back Pressure	20.0 to 50.0	psi

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Injection	Nominal Value	Unit
Screw Speed	100 to 150	rpm
Clamp Tonnage	2.0 to 3.0	tons/in²