

**WPP351-Natural**

PP

Washington Penn Plastic Co., Inc.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	20	g/10min	ISO 1133

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	1000	MPa	ISO 527
Yield stress	18	MPa	ISO 527
Yield strain	5	%	ISO 527
Flexural modulus, 23°C	860	MPa	ISO 178
Charpy notched impact strength, +23°C	42	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	41	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength Temperature	7 -40	kJ/m <sup>2</sup> °C	ISO 180/1A -

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	50	°C	ISO 75-1/-2

Other properties	Value	Unit	Test Standard
Density	890	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	70 - 90	°C	-
Pre-drying - Time	1 - 2	h	-
Melt temperature	230 - 250	°C	-
Mold temperature	15 - 55	°C	-
Zone 1	220 - 240	°C	-
Zone 2	220 - 240	°C	-
Zone 3	220 - 245	°C	-
Zone 4	225 - 245	°C	-
Nozzle temperature	230 - 250	°C	-
Injection speed	19 - 64	mm/s	-
Injection pressure	4.1 - 9	MPa	-
Back pressure	0.52 - 0.86	MPa	-
Holding pressure	1 - 6.2	MPa	-

**Characteristics****Processing**

Injection Molding

**Features**

Copolymer

**Delivery form**

Natural Color

**Regional Availability**

North America