

## Technical Data Sheet

**Ferro Pp TPP20AC06HB**

Polypropylene Homopolymer  
LyondellBasell Industries  
Engineering Plastics

**Product Description**

Primary end use is for AC/heater blower wheels.

**General**

|                           |                                                                             |                                            |                        |
|---------------------------|-----------------------------------------------------------------------------|--------------------------------------------|------------------------|
| Material Status           | • Commercial: Active                                                        |                                            |                        |
| Availability              | • Latin America                                                             | • North America                            |                        |
| Filler / Reinforcement    | • Talc, 20% Filler by Weight                                                |                                            |                        |
| Additive                  | • Heat Stabilizer                                                           |                                            |                        |
| Features                  | • Heat Stabilized                                                           | • Homopolymer                              |                        |
| Uses                      | • Automotive Applications                                                   | • Housings                                 | • Protective Coverings |
| Automotive Specifications | • ASTM D5857 PP212 T20 Z1<br>• CHRYSLER MS-DB-500<br>CPN1733 Color: Natural | • FORD ESA-M4D293-A<br>• FORD ESH-M4D293-B |                        |
| Appearance                | • Natural Color                                                             |                                            |                        |
| Forms                     | • Pellets                                                                   |                                            |                        |
| Processing Method         | • Injection Molding                                                         |                                            |                        |

| Physical                                  | Nominal Value (English) | Nominal Value (SI)     | Test Method |
|-------------------------------------------|-------------------------|------------------------|-------------|
| Density / Specific Gravity                | 1.06                    | 1.06 g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 5.7 g/10 min            | 5.7 g/10 min           | ASTM D1238  |
| Mechanical                                | Nominal Value (English) | Nominal Value (SI)     | Test Method |
| Tensile Strength (73°F (23°C))            | 4860 psi                | 33.5 MPa               | ASTM D638   |
| Tensile Elongation (Break)                | 24 %                    | 24 %                   | ASTM D638   |
| Flexural Modulus                          | 392000 psi              | 2700 MPa               | ASTM D790   |
| Flexural Strength (Yield)                 | 7700 psi                | 53.1 MPa               | ASTM D790   |
| Impact                                    | Nominal Value (English) | Nominal Value (SI)     | Test Method |
| Notched Izod Impact (73°F (23°C))         | 0.69 ft·lb/in           | 37 J/m                 | ASTM D256   |
| Unnotched Izod Impact (73°F (23°C))       | 11 ft·lb/in             | 580 J/m                | ASTM D4812  |
| Gardner Impact                            | 6.00 in·lb              | 0.678 J                | ASTM D3029  |
| Hardness                                  | Nominal Value (English) | Nominal Value (SI)     | Test Method |
| Rockwell Hardness (R-Scale)               | 102                     | 102                    | ASTM D785   |
| Thermal                                   | Nominal Value (English) | Nominal Value (SI)     | Test Method |
| Deflection Temperature Under Load         |                         |                        | ASTM D648   |
| 66 psi (0.45 MPa), Unannealed             | 261 °F                  | 127 °C                 |             |
| 264 psi (1.8 MPa), Unannealed             | 162 °F                  | 72.0 °C                |             |

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| Injection               | Nominal Value (English)         | Nominal Value (SI)            |
|-------------------------|---------------------------------|-------------------------------|
| Drying Temperature      | 176 °F                          | 80 °C                         |
| Drying Time             | 2.0 to 3.0 hr                   | 2.0 to 3.0 hr                 |
| Rear Temperature        | 400 to 410 °F                   | 204 to 210 °C                 |
| Middle Temperature      | 410 to 415 °F                   | 210 to 213 °C                 |
| Front Temperature       | 415 to 420 °F                   | 213 to 216 °C                 |
| Nozzle Temperature      | 420 to 425 °F                   | 216 to 218 °C                 |
| Processing (Melt) Temp  | 428 to 500 °F                   | 220 to 260 °C                 |
| Mold Temperature        | 86 to 140 °F                    | 30 to 60 °C                   |
| Back Pressure           | 20.0 to 50.0 psi                | 0.138 to 0.345 MPa            |
| Screw Speed             | 100 to 150 rpm                  | 100 to 150 rpm                |
| Clamp Tonnage           | 2.0 to 3.0 tons/in <sup>2</sup> | 2.8 to 4.1 kN/cm <sup>2</sup> |
| Screw L/D Ratio         | 20.0:1.0                        | 20.0:1.0                      |
| Screw Compression Ratio | 2.0:1.0                         | 2.0:1.0                       |

## Notes

These are typical property values not to be construed as specification limits.

## Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

## Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

## Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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