

Technical Data Sheet



Ferro Pp TPP20AO27NA

Polypropylene
LyondellBasell Industries
Engineering Plastics

Product Description

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

General

Material Status	• Commercial: Active	
Availability	• Latin America	• North America
Filler / Reinforcement	• Talc, 20% Filler by Weight	
Additive	• Impact Modifier	
Features	• General Purpose • Good Dimensional Stability	• Good Impact Resistance • Impact Modified
Automotive Specifications	• FMVSS 302	
Appearance	• Natural Color	
Forms	• Pellets	
Processing Method	• Injection Molding	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.05 g/cm ³	1.05 g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	16 g/10 min	16 g/10 min	ISO 1133
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (73°F (23°C))	4280 psi	29.5 MPa	ASTM D638
Flexural Modulus - Chord	390000 psi	2690 MPa	ISO 178
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength	1.5 ft·lb/in ²	3.1 kJ/m ²	ISO 179
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			
66 psi (0.45 MPa), Unannealed	221 °F	105 °C	ISO 75-2/B
264 psi (1.8 MPa), Unannealed	156 °F	69.0 °C	ISO 75-2/A

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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 ²	2.8 to 4.1 kN/cm ²
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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