



Designation: D4101 – 17^{ε1}

Standard Classification System and Basis for Specification for Polypropylene Injection and Extrusion Materials¹

This standard is issued under the fixed designation D4101; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the U.S. Department of Defense.

^{ε1} NOTE—Editorially corrected Table X1.1 in June 2019.

INTRODUCTION

This classification system is not intended for the selection of materials but only as a means to call out plastic materials to be used for the manufacture of parts. The selection and specification of these materials is to be made by personnel with expertise in the plastics field where other factors including the use environment, inherent properties of the materials, performance of the part, part design, manufacturing process, and economics are considered.

1. Scope*

1.1 This classification system covers polypropylene materials suitable for injection molding and extrusion. Polymers consist of homopolymer, copolymers, and elastomer compounded with or without the addition of impact modifiers, for example, ethylene-propylene rubber, polyisobutylene rubber, and butyl rubber, colorants, stabilizers, lubricants, or reinforcements.

1.2 This classification system allows for the use of those polypropylene materials that can be recycled, reconstituted, and reground, provided that: (1) the requirements as stated in this classification system are met, and (2) the material has not been modified in any way to alter its conformance to food contact regulations or similar requirements. The proportions of recycled, reconstituted, and reground material used, as well as the nature and the amount of any contaminant, cannot be practically covered in this classification system. It is the responsibility of the supplier and the buyer of recycled, reconstituted, and reground materials to ensure compliance. (See Guide D7209.)

1.3 The values stated in SI units are to be regarded as standard. No other units of measurement are included in this standard.

NOTE 1—The properties included in this classification system are those required to identify the compositions covered. If other requirements are necessary to identify particular characteristics important to specific

applications, these shall be designated by using the suffixes given in Section 1.

1.4 The following safety hazards caveat pertains only to the test methods portion, Section 13, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

NOTE 2—This classification system and ISO 19069-1 and -2 address the same subject matter, but differ in technical content.

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

C177 Test Method for Steady-State Heat Flux Measurements and Thermal Transmission Properties by Means of the Guarded-Hot-Plate Apparatus

D149 Test Method for Dielectric Breakdown Voltage and Dielectric Strength of Solid Electrical Insulating Materials at Commercial Power Frequencies

D150 Test Methods for AC Loss Characteristics and Permittivity (Dielectric Constant) of Solid Electrical Insulation

¹ This classification system is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.15 on Thermoplastic Materials.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

*A Summary of Changes section appears at the end of this standard

- D256** Test Methods for Determining the Izod Pendulum Impact Resistance of Plastics
- D257** Test Methods for DC Resistance or Conductance of Insulating Materials
- D495** Test Method for High-Voltage, Low-Current, Dry Arc Resistance of Solid Electrical Insulation
- D523** Test Method for Specular Gloss
- D543** Practices for Evaluating the Resistance of Plastics to Chemical Reagents
- D570** Test Method for Water Absorption of Plastics
- D618** Practice for Conditioning Plastics for Testing
- D638** Test Method for Tensile Properties of Plastics
- D648** Test Method for Deflection Temperature of Plastics Under Flexural Load in the Edgewise Position
- D695** Test Method for Compressive Properties of Rigid Plastics
- D696** Test Method for Coefficient of Linear Thermal Expansion of Plastics Between -30°C and 30°C with a Vitreous Silica Dilatometer
- D732** Test Method for Shear Strength of Plastics by Punch Tool
- D746** Test Method for Brittleness Temperature of Plastics and Elastomers by Impact
- D785** Test Method for Rockwell Hardness of Plastics and Electrical Insulating Materials
- D790** Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials
- D792** Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement
- D883** Terminology Relating to Plastics
- D1238** Test Method for Melt Flow Rates of Thermoplastics by Extrusion Plastometer
- D1435** Practice for Outdoor Weathering of Plastics
- D1505** Test Method for Density of Plastics by the Density-Gradient Technique
- D1525** Test Method for Vicat Softening Temperature of Plastics
- D1531** Test Methods for Relative Permittivity (Dielectric Constant) and Dissipation Factor by Fluid Displacement Procedures (Withdrawn 2012)³
- D1600** Terminology for Abbreviated Terms Relating to Plastics
- D1822** Test Method for Tensile-Impact Energy to Break Plastics and Electrical Insulating Materials
- D2117** Test Methods for Carbon Black—Surface Area by Nitrogen Adsorption (Withdrawn 1999)³
- D2240** Test Method for Rubber Property—Durometer Hardness
- D2565** Practice for Xenon-Arc Exposure of Plastics Intended for Outdoor Applications
- D2584** Test Method for Ignition Loss of Cured Reinforced Resins
- D2990** Test Methods for Tensile, Compressive, and Flexural Creep and Creep-Rupture of Plastics
- D3012** Test Method for Thermal-Oxidative Stability of Polypropylene Using a Specimen Rotator Within an Oven
- D3418** Test Method for Transition Temperatures and Enthalpies of Fusion and Crystallization of Polymers by Differential Scanning Calorimetry
- D3641** Practice for Injection Molding Test Specimens of Thermoplastic Molding and Extrusion Materials
- D3763** Test Method for High Speed Puncture Properties of Plastics Using Load and Displacement Sensors
- D3835** Test Method for Determination of Properties of Polymeric Materials by Means of a Capillary Rheometer
- D3892** Practice for Packaging/Packing of Plastics
- D4000** Classification System for Specifying Plastic Materials
- D4329** Practice for Fluorescent Ultraviolet (UV) Lamp Apparatus Exposure of Plastics
- D4364** Practice for Performing Outdoor Accelerated Weathering Tests of Plastics Using Concentrated Sunlight
- D4805** Terminology for Plastics Standards (Withdrawn 2002)³
- D4812** Test Method for Unnotched Cantilever Beam Impact Resistance of Plastics
- D5279** Test Method for Plastics: Dynamic Mechanical Properties: In Torsion
- D5420** Test Method for Impact Resistance of Flat, Rigid Plastic Specimen by Means of a Striker Impacted by a Falling Weight (Gardner Impact)
- D5630** Test Method for Ash Content in Plastics
- D5947** Test Methods for Physical Dimensions of Solid Plastics Specimens
- D6110** Test Method for Determining the Charpy Impact Resistance of Notched Specimens of Plastics
- D6290** Test Method for Color Determination of Plastic Pellets
- D7209** Guide for Waste Reduction, Resource Recovery, and Use of Recycled Polymeric Materials and Products (Withdrawn 2015)³
- E29** Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
- E313** Practice for Calculating Yellowness and Whiteness Indices from Instrumentally Measured Color Coordinates
- E831** Test Method for Linear Thermal Expansion of Solid Materials by Thermomechanical Analysis
- 2.2 *Military Standard:*
- MIL-STD-105** Sampling Procedure and Tables for Inspection by Attributes⁴
- 2.3 *SAE Standards:*⁵
- SAE J1545** Instrumental Color Difference Measurement for Exterior Finishes, Textiles and Color Trim
- SAE J1767** Instrumental Color Difference Measurement for Colorfastness of Automotive Interior Trim Materials
- SAE J2412** Accelerated Exposure of Automotive Interior Trim Components Using a Controlled Irradiance Xenon-Arc Apparatus

³ The last approved version of this historical standard is referenced on www.astm.org.

⁴ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094.

⁵ Available from Society of Automotive Engineers (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://www.sae.org>.

SAE J2527 Performance Based Standard for Accelerated Exposure of Automotive Exterior Materials Using a Controlled Irradiance Xenon-Arc Apparatus
SAE J1976 Outdoor Weathering of Exterior Materials

2.4 *ISO Standards:*

ISO 19069-1 Plastics—Polypropylene (PP) moulding and extrusion materials—Part 1: Designation system and basis for specifications

ISO 19069-2 Plastics—Polypropylene (PP) moulding and extrusion materials—Part 2: Preparation of test specimens and determination of properties

3. Terminology

3.1 *Definitions*— See Terminologies **D883** and **D4805** for definitions of terms related to this specification.

3.2 *Definitions of Terms Specific to This Standard:*

3.2.1 *back pressure, n*—the constant pressure that is applied to the end of the screw while the screw is rotating and retracting to prepare for the next injection.

3.2.2 *brittle failure, n*—one where the specimen test area is broken into two or more pieces, with sharp edges and shows almost no plastic flow.

3.2.3 *cooling time, n*—the time in which the material is in the closed mold with no pressure applied.

3.2.4 *cycle time, n*—the time required to complete a full injection molding cycle, including injection time, cooling time, and mold open time.

3.2.5 *ductile brittle transition temperature, n*—the temperature at which a 80% of the specimens exhibit ductile failure

3.2.6 *ductile failure, n*—one where the specimen deforms plastically before fracturing or one where the puncture of a test plaque does not have cracks radiating more than 10 mm beyond the center of the impact point.

3.2.7 *injection pressure, n*—the constant pressure that is applied to the end of the screw causing the melted material to fill the mold.

3.2.7.1 *Discussion*—The injection pressure along with the injection speed determines the volumetric fill rate of the mold.

3.2.8 *injection speed, n*—the forward velocity of the screw during the injection step.

3.2.8.1 *Discussion*—Injection speed is a set position on the injection molding machine ranging from slow to fast. The injection speed along with the injection pressure determines the volumetric fill rate of the mold.

3.2.9 *injection time, n*—the time in which a constant specified pressure is applied to the melted material.

3.2.10 *melt temperature, n*—the temperature of the material as it is being injected into the mold, measured by a pyrometer, or equivalent.

3.2.11 *mold open time, n*—the time beginning when the mold is opened and ending when the mold is closed.

3.2.12 *mold temperature, n*—the temperature of the mold during the molding cycle, measured in all mold cavities and on both platens, measured by a pyrometer, or equivalent.

3.2.13 *polypropylene (PP)*—a propylene plastic prepared by the polymerization of propylene or propylene with other alpha olefins. (See also PP-B, PP-H, and PP-R.)

3.2.14 *polypropylene heterophasic copolymers (PP-B, PP+EPR, or PP+EPDM)*—a propylene plastic consisting of two or more separate phases.

3.2.14.1 *Discussion*—The phases consist of a polypropylene homopolymer (PP-H) or a polypropylene random copolymer (PP-R) matrix containing a dispersed olefinic elastomer having no other functional group, added in situ or physically blended into the polypropylene matrix.

3.2.15 *polypropylene homopolymer (PP-H)*—a propylene plastic prepared by the polymerization of propylene only.

3.2.16 *polypropylene random copolymer (PP-R)*—a propylene plastic containing another olefinic monomer (or monomers) having no functional group other than the olefinic group copolymerized with propylene.

3.2.16.1 *Discussion*—Polypropylene random copolymers containing more than one additional monomer are often called “terpolymers.”

4. Classification

4.1 Unreinforced polypropylene materials are classified into groups according to basic composition. These groups are subdivided into classes and grades, as shown in Table PP.

NOTE 3—An example of this classification system is as follows. The designation PP0113 would indicate: PP = polypropylene, as found in Terminology **D1600**, 01 (group) = homopolymer, 1 (class) = general purpose, and 3 (grade) = with requirements given in Table PP.

4.1.1 To facilitate the incorporation of future or special materials not covered by Table PP, the “other/unspecified” category for group (00), class (0), and grade (0) is shown on the table with the basic properties to be obtained from Table A, Table B, Table C, Table G, Table H, and Table T, as they apply (see 4.3).

4.2 Reinforced versions of the polypropylene materials are classified in accordance with Table PP, Table A, Table C, Table G, and Table T. Table PP, Table B, and Table H specify the properties of the unreinforced material, and Tables A, C, G, or T specify the properties after the addition of reinforcements, pigments, fillers, or lubricants, at the nominal level indicated (see 4.2.1)

4.2.1 *Reinforcements and Additive Materials*—A symbol (single letter) will be used for the major reinforcement or combinations thereof, along with two numbers that indicate the percentage of addition by mass, with the tolerances as tabulated as follows:

Symbol	Material	Tolerance
G	Glass reinforced— <15 % >15 %	±2 percentage points ±3 percentage points to be specified
L	Lubricant (that is, graphite, silicone, and stearates)	
M	Mineral-reinforced— <15 % >15 %	±2 percentage points ±3 percentage points
R	Reinforced-combinations/ mixtures of reinforcements or other fillers/reinforcements	±3 percentage points based on the total reinforcement

NOTE 4—This part of the system uses the type and percentage of

additive to designate the modification of the base material. To facilitate this designation, the type and percentage of additive can be shown on the supplier's Technical Data Sheet, unless it is proprietary in nature. If necessary, additional requirements shall be indicated by the use of the suffix part of the system as given in Section 5.

4.2.2 Specific requirements for reinforced, pigmented, filled, or lubricant polypropylene materials will be shown by a six-character designation. The designation will consist of the letter A, B, C, G, or T and the five digits comprising the cell numbers for the property requirements in the order in which they appear in Table A, Table B, Table C, Table G, or Table T. For Table H the designation will consist of the letter H and three digits comprising the cell numbers for the property requirements in the order in which they appear in Table H.

4.2.2.1 Although the values listed are necessary to include the range of properties available in existing materials, they should not be interpreted as implying that every possible combination of the properties exists or can be obtained.

4.2.3 When the grade of the basic materials is not known or is not important, the use of "0" grade classification is to be used for reinforced materials in this system. (See Note 5.)

NOTE 5—An example of this classification system for a reinforced-polypropylene material is as follows. The designation PP0110M20A21130 would indicate the following, with the material requirements from Table A:

PP0110	= General-purpose polypropylene homopolymer from Table PP
M20	= Mineral reinforced, 20 %
A	= Table A property requirements.
2	= 35-MPa tensile stress, min,
1	= 1000-MPa flexural modulus (1 % secant), min,
1	= 15-J/m Izod impact, min,
3	= 110°C deflection temperature, min, and
0	= Unspecified.

If no properties are specified, the designation would be PP0110M20-A00000.

4.3 Table B has been incorporated into this specification to facilitate the classification of special materials where Table PP does not reflect the required properties of that unreinforced material. This table is to be used in a manner similar to Tables A, C, G, and T. Table H has been incorporated into this specification to improve the callout of random copolymers and impact copolymers. Table H has a reduced callout based on flexural modulus, Izod impact, and the Multiaxial Impact Ductile-Brittle Transition Temperature. If a full line callout is required, use Table B.

NOTE 6—Mechanical properties of polypropylene materials with pigments or colorants can differ from the mechanical properties of natural material, depending on the choice and the concentration.

NOTE 7—An example of a special material using this classification system is as follows. The designation PP0110B67253 would indicate the following with the material requirements from Table B:

PP0110	= homopolymer, general purpose, other,
B	= Table B property requirements,
6	= 30-MPa tensile stress at yield, min,
7	= 1500-MPa flexural modulus, min,

2	= 50-J/m Izod impact resistance, min,
5	= 90°C deflection temperature, min, and
3	= >1.0 to 3.0 nominal melt flow rate.

NOTE 8—An example of a polypropylene copolymer material using Table H would be as follows. The designation PP0500H585 would indicate a material with the following requirements:

PP0500	= copolymer or impact modified,
H	= Table H property requirements,
5	= 1200-MPa flexural modulus, min,
8	= Izod impact resistance, non-break failure mode, no value reported, and
5	= <-30°C ductile-brittle transition temperature

5. Suffixes

5.1 When additional requirements are needed for the materials covered in this specification that are not covered in Table PP, Table A, Table B, Table C, Table G, Table H, and Table T, those requirements shall be designated through the use of suffixes. The primary suffix list can be found in Suffix Requirements, Section 7, of Classification D4000. Other suffixes that pertain only to the material requirements in this specification are listed as follows. In general, the suffix letter indicates the requirement needed; the first number (digit) indicates the test condition, and the second number (digit) indicates the specimen requirement.

NOTE 9—Suffixes from Classification D4000 will contain two letters followed by three digits while suffixes from this specification will contain a single letter followed by two or three numbers. An example would be weatherability; a designation of WA510 would indicate that it is a Classification D4000 suffix with the following requirements:

W	= Weather resistant,
A	= Practice D1435,
5	= Elongation properties, and
10	= 10 % change.

A designation of W110 would indicate that it is a Specification D4101 suffix with the following requirements:

W	= Weatherability,
1	= Practice D2565, Test Cycle 1, specimens exposed in a xenon-arc accelerated test apparatus,
1	= 200-h exposure, and
0	= Change in properties to be specified.

Suffixes:

E = Electrical requirements as designated by the following digits:
First Digit

0	= To be specified by user.
1	= Specimens preconditioned 40 h at 23°C and 50 % relative humidity, then 14 days in distilled water at 23 ± 1°C.

Second Digit

0	= To be specified by user.
1	= Insulation resistance, dielectric constant, and dissipation factor meet property limits as shown below. These are electrical limits usually applied to unreinforced polypropylene when control of their electrical properties is required.

Electrical Properties: