

Technical Data Sheet

Ferrex GPP20CF65HB-GN

Polypropylene
LyondellBasell Industries
Engineering Plastics

| General | |
|------------------------|--|
| Filler / Reinforcement | • Calcium Carbonate, 22% Filler by Weight |
| Features | • Good Processability • High Gloss • Homopolymer |
| Uses | • Appliances • Housings |
| Agency Ratings | • FDA |
| Appearance | • Green |
| Forms | • Pellets |
| Processing Method | • Injection Molding |

| Physical | Nominal Value (English) | Nominal Value (SI) | Test Method |
|---|-------------------------|------------------------|-------------|
| Density / Specific Gravity | 1.07 | 1.07 g/cm ³ | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 Kg) | 25 g/10 min | 25 g/10 min | ASTM D1238 |

| Mechanical | Nominal Value (English) | Nominal Value (SI) | Test Method |
|----------------------------|-------------------------|--------------------|-------------|
| Tensile Strength (Yield) | 4500 psi | 31.0 MPa | ASTM D638 |
| Tensile Elongation (Break) | 35 % | 35 % | ASTM D638 |
| Flexural Modulus | 290000 psi | 2000 MPa | ASTM D790 |
| Flexural Strength (Yield) | 7100 psi | 49.0 MPa | ASTM D790 |

| Impact | Nominal Value (English) | Nominal Value (SI) | Test Method |
|-------------------------------------|-------------------------|--------------------|-------------|
| Notched Izod Impact (73°F (23°C)) | 0.56 ft·lb/in | 30 J/m | ASTM D256 |
| Unnotched Izod Impact (73°F (23°C)) | 16 ft·lb/in | 850 J/m | ASTM D4812 |
| Gardner Impact | 120 in·lb | 13.6 J | ASTM D3029 |

| Hardness | Nominal Value (English) | Nominal Value (SI) | Test Method |
|------------------------------|-------------------------|--------------------|-------------|
| Durometer Hardness (Shore D) | 75 | 75 | ASTM D2240 |

| Thermal | Nominal Value (English) | Nominal Value (SI) | Test Method |
|-----------------------------------|-------------------------|--------------------|-------------|
| Deflection Temperature Under Load | | | ASTM D648 |
| 66 Psi (0.45 Mpa), Unannealed | 236 °F | 113 °C | |
| 264 Psi (1.8 Mpa), Unannealed | 150 °F | 65.6 °C | |

| Flammability | Nominal Value (English) | Nominal Value (SI) | Test Method |
|--------------|-------------------------|--------------------|-------------|
| Flame Rating | HB | HB | UL 94 |

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| Injection | Nominal Value (English) | Nominal Value (SI) |
|-------------------------|---------------------------------|-------------------------------|
| Drying Temperature | 200 °F | 93 °C |
| Drying Time | 2.0 to 3.0 hr | 2.0 to 3.0 hr |
| Rear Temperature | 390 to 400 °F | 199 to 204 °C |
| Middle Temperature | 400 to 410 °F | 204 to 210 °C |
| Front Temperature | 410 to 420 °F | 210 to 216 °C |
| Nozzle Temperature | 420 to 430 °F | 216 to 221 °C |
| Mold Temperature | 115 to 140 °F | 46 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.