Technical Data Sheet

Polyfort FPP 1640

Polypropylene
LyondellBasell Industries
Engineering Plastics

Product Description			
PP 35% Talc/Glass Fiber			
General			
Material Status	• Commercial: Active		
Availability	• North America		
Filler / Reinforcement	• Glass\Talc, 35% Filler by Weight		
Automotive Specifications	• ASTM D4000 PP110 R35 A22450 AA002 • CHRYSLER MS-DB-500 CPN4079	• GM GMP.PP.032 Color: Black • GM GMP.PP.032 Color: Natural	• NISSAN NES M8012 PP(HXX) 1C1-Y-1
Processing Method	• Injection Molding		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.20 g/cm³	1.20 g/cm³	ISO 1183
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Stress (Yield)	9140 psi	63.0 MPa	ISO 527-2/50
Flexural Modulus [1]	841000 psi	5800 MPa	ISO 178
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact Strength	2.7 ft·lb/in²	5.7 kJ/m²	ISO 180
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ISO 75-2/A
264 Psi (1.8 Mpa), Unannealed	275 °F	135 °C	

Additional Information	Nominal Value (English)	Nominal Value (SI)	Test Method
Filler Content	35 %	35 %	ASTM D5630

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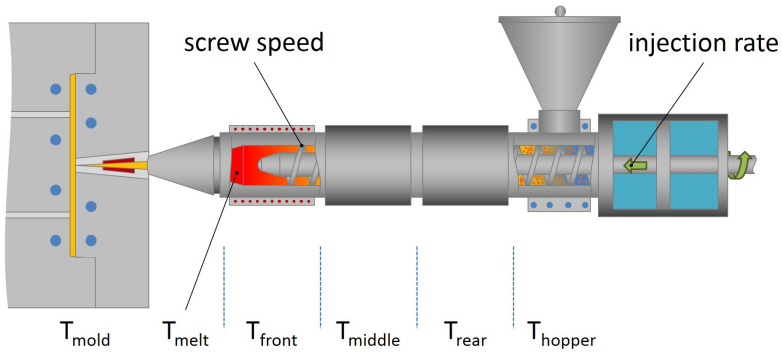

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Processing (Melt) Temp	428 to 500 °F	220 to 260 °C
Mold Temperature	86 to 140 °F	30 to 60 °C
Injection Rate	Moderate-Fast	Moderate-Fast

Injection Notes

Polypropylene is not hygroscopic and generally does not require drying. As a good practice and to avoid residual humidity from transport or storage conditions, we recommend drying the material.

Ensure good mold venting

Injection molding parameters also influence emission properties, which are often required for automotive interior applications. Generally speaking, the emission, odor and fogging behavior of finished parts is improved by lowering the melt temperature, reducing residence time and avoiding high shear stress.

Notes

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