Technical Data Sheet

Polyfort FPP 2478

Polypropylene
LyondellBasell Industries
Engineering Plastics

Product Description	
PP 25% Mineral	

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Mineral, 25% Filler by Weight
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.10 g/cm³	1.10 g/cm³	ISO 1183
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Stress (Yield)	3190 psi	22.0 MPa	ISO 527-2/50
Flexural Modulus [1]	399000 psi	2750 MPa	ISO 178
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength	10 ft·lb/in²	22 kJ/m²	ISO 179
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ISO 75-2/A
264 Psi (1.8 Mpa), Unannealed	136 °F	58.0 °C	

Additional Information	Nominal Value (English)	Nominal Value (SI)	Test Method
Filler Content	26 %	26 %	ASTM D5630

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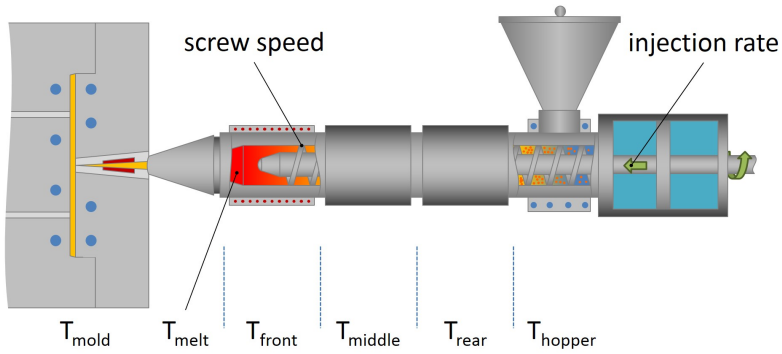

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Processing (Melt) Temp	428 to 500 °F	220 to 260 °C
Mold Temperature	86 to 140 °F	30 to 60 °C
Injection Rate	Moderate-Fast	Moderate-Fast

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.