Technical Data Sheet

Polyfort FPP 3810

Polypropylene
LyondellBasell Industries
Engineering Plastics

Product Description	
20% calcium carbonate filled, impact copolymer polypropylene	

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Calcium Carbonate, 20% Filler by Weight
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.12	1.12 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°c/2.16 Kg)	22 g/10 min	22 g/10 min	ASTM D1238
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Strength [1] (Yield)	2760 psi	19.0 MPa	ASTM D638
Tensile Elongation (Break)	200 %	200 %	ASTM D638
Flexural Modulus [2]	193000 psi	1330 MPa	ASTM D790
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Notched Izod Impact (73°f (23°c))	2.0 ft·lb/in	110 J/m	ASTM D256
Instrumented Dart Impact (73°f (23°c))	292 in·lb	33.0 J	ASTM D3763
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	176 °F	80.0 °C	
264 Psi (1.8 Mpa), Unannealed	120 °F	49.0 °C	

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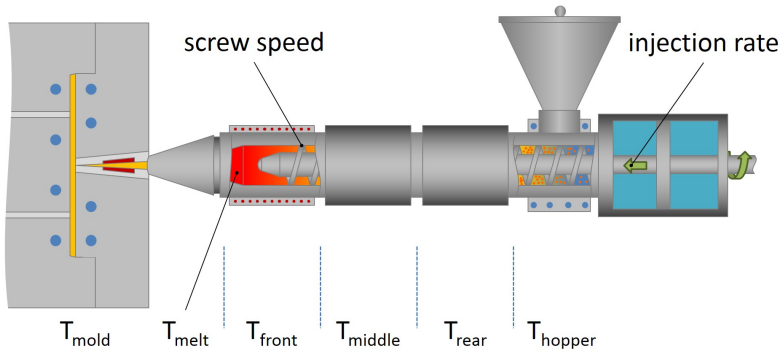

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Processing (Melt) Temp	428 to 500 °F	220 to 260 °C
Mold Temperature	86 to 140 °F	30 to 60 °C
Injection Rate	Moderate-Fast	Moderate-Fast

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.