

Technical Data Sheet

# Polyfort PP 1329

Polypropylene  
LyondellBasell Industries  
Engineering Plastics

**Product Description**  
PP Medium Impact Unfilled

| General                   |                                |
|---------------------------|--------------------------------|
| Material Status           | • Commercial: Active           |
| Availability              | • North America                |
| Features                  | • Medium Impact Resistance     |
| Automotive Specifications | • GM GMP.PP.002 Color: Natural |
| Processing Method         | • Injection Molding            |

| Physical                   | Nominal Value (English) | Nominal Value (SI)      | Test Method |
|----------------------------|-------------------------|-------------------------|-------------|
| Density / Specific Gravity | 0.912                   | 0.910 g/cm <sup>3</sup> | ASTM D792   |

| Mechanical                              | Nominal Value (English) | Nominal Value (SI) | Test Method |
|---|-------------------------|--------------------|-------------|
| Tensile Strength <sup>1</sup> (Yield)   | 3920 psi                | 27.0 MPa           | ASTM D638   |
| Tensile Elongation <sup>1</sup> (Break) | 650 %                   | 650 %              | ASTM D638   |
| Flexural Modulus <sup>2</sup>           | 160000 psi              | 1100 MPa           | ASTM D790   |

| Impact              | Nominal Value (English) | Nominal Value (SI) | Test Method |
|---------------------|-------------------------|--------------------|-------------|
| Notched Izod Impact | 1.4 ft·lb/in            | 75 J/m             | ASTM D256   |

| Thermal  | Nominal Value (English) | Nominal Value (SI) | Test Method |
|--|-------------------------|--------------------|-------------|
| Deflection Temperature Under Load<br>66 Psi (0.45 Mpa), Unannealed | 190 °F                  | 88.0 °C            | ASTM D648   |

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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.