

Technical Data Sheet

# Polyfort PP 1329HU

Polypropylene  
 LyondellBasell Industries  
 Engineering Plastics

**Product Description**

Polyfort® PP 1329HU is a high flow UV stabilized, medium impact copolymer polypropylene. It is suitable for applications which require a material with the following properties:

**General**

Material Status	• Commercial: Active
Availability	• North America
Features	• Medium Impact Resistance
Appearance	• Colors Available                      • Natural Color
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	0.903	0.901 g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 Kg)	16 to 20 g/10 min	16 to 20 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	3630 psi	25.0 MPa	ASTM D638
Tensile Elongation (Break)	130 %	130 %	ASTM D638
Flexural Modulus - Tangent <sup>1</sup>	162000 psi	1120 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact	2.3 ft·lb/in	120 J/m	ASTM D256
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-scale)	83	83	ASTM D785
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 66 Psi (0.45 Mpa), Unannealed	176 °F	80.0 °C	ASTM D648

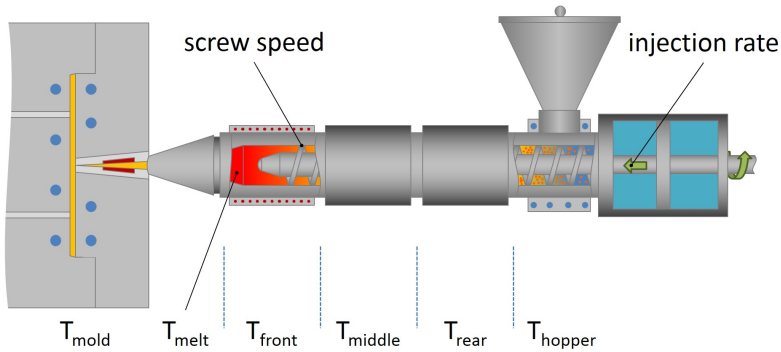
**Additional Information**

Material does not require drying, however if surface moisture present, then the material can be dried at 180F for 2-4 hours.

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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.