

Technical Data Sheet

Polyfort CPP3C20HBNANAT



Polypropylene, Unspecified (PP, Unspecified)

Product Description

CPP3C20HB is a 20% Calcium Carbonate Filled Polypropylene

Processing Method	Injection Molding
Forms	Pellets
Appearance	Colors Available
Filler/Reinforcement	Calcium Carbonate, 20%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (230 °C/2.16 kg)	18	g/10 min	ASTM D1238
Mechanical			
Tensile Elongation at Yield	11	%	ASTM D638
Tensile Strength at Yield, (23 °C, 3.18 mm)	22.7	MPa	ASTM D638
Flexural Modulus, (23 °C, 3.18 mm)	1710	MPa	ASTM D790
Impact			
Gardner Impact, (23 °C, 3.18 mm)	21.1	J	ASTM D5420
Notched Izod Impact, (23 °C, 3.18 mm)	130	J/m	ASTM D256

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 4.0	hr
Drying Temperature	82 to 104	°C
Processing (Melt) Temp	199 to 232	°C
Front Temperature	188 to 232	°C
Middle Temperature	188 to 232	°C
Rear Temperature	188 to 232	°C
Injection Rate	Moderate	
Back Pressure	0.138 to 2.07	MPa
Mold Temperature	21 to 49	°C
Cushion	6.35 to 12.7	mm