

Technical Data Sheet

Polyfort GPP30CN33HB-NAT



Polypropylene, Unspecified (PP, Unspecified)

Product Description

Polyfort GPP30CN33HB-NAT is a Polypropylene, Unspecified Calcium Carbonate, 30% filled material and is typically used in Injection Molding applications. Features include: High Gloss.

Processing Method	Injection Molding
Attribute	High Gloss
Forms	Pellets
Appearance	Natural Color
Filler/Reinforcement	Calcium Carbonate, 30%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (230 °C/2.16 kg)	25	g/10 min	ASTM D1238
Density - Specific Gravity	1.13	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	22.1	MPa	ASTM D638
Flexural Strength at Yield	34.5	MPa	ASTM D790
Flexural Modulus	1590	MPa	ASTM D790
Tensile Elongation at Break	85	%	ASTM D638
Impact			
Gardner Impact	26	J	ASTM D3029
Unnotched Izod Impact, (23 °C)	800	J/m	ASTM D4812
Notched Izod Impact, (23 °C)	59	J/m	ASTM D256
Hardness			
Durometer Hardness, (Shore D)	70		ASTM D2240
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	60	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	104	°C	ASTM D648

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 3.0	hr
Drying Temperature	93	°C
Clamp Tonnage	2.8 to 4.1	kN/cm ²
Nozzle Temperature	216 to 221	°C
Screw Speed	100 to 150	rpm
Front Temperature	210 to 216	°C
Screw L/D Ratio	20.0-1.0	
Screw Compression Ratio	2.0-1.0	
Middle Temperature	204 to 210	°C
Rear Temperature	199 to 204	°C
Back Pressure	0.138 to 0.345	MPa
Mold Temperature	46 to 60	°C