

Technical Data Sheet
Fiberfil® PP-68/V2
 Polypropylene Copolymer
 Engineering Plastics

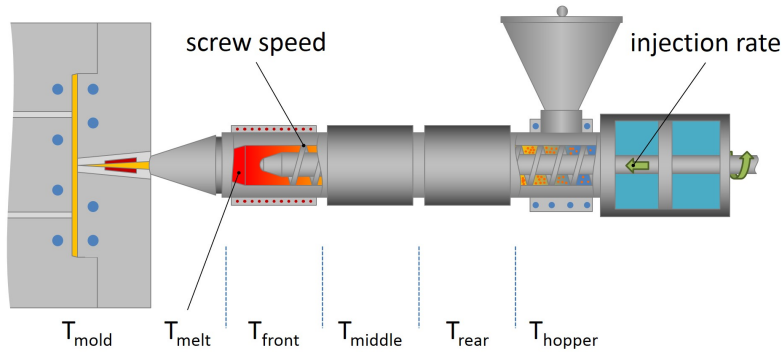


General

Features	• Copolymer	• Flame Retardant
Forms	• Pellets	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	0.980	0.978 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20 g/10 min	20 g/10 min	ASTM D1238
Molding Shrinkage - Flow			ASTM D955
0.125 in (3.18 mm)	0.017 to 0.021 in/in	1.7 to 2.1 %	
0.250 in (6.35 mm)	0.020 to 0.024 in/in	2.0 to 2.4 %	
Water Absorption (24 hr)	0.020 %	0.020 %	ASTM D570
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus (73°F (23°C))	130000 psi	896 MPa	ASTM D638
Tensile Strength (73°F (23°C))	2760 psi	19.0 MPa	ASTM D638
Tensile Elongation (Yield, 73°F (23°C))	25 %	25 %	ASTM D638
Flexural Modulus - Tangent (73°F (23°C))	120000 psi	827 MPa	ASTM D790
Flexural Strength (73°F (23°C))	4600 psi	31.7 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.125 in (3.18 mm)	6.0 ft-lb/in	320 J/m	
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-Scale)	85 to 90	85 to 90	ASTM D785
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi (0.45 MPa), Unannealed	160 °F	71.1 °C	
264 psi (1.8 MPa), Unannealed	145 °F	62.8 °C	
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.06 in (1.5 mm))	V-2	V-2	UL 94

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	170 °F	77 °C
Drying Time	2.0 hr	2.0 hr
Suggested Max Moisture	0.20 %	0.20 %
Rear Temperature	360 to 390 °F	182 to 199 °C
Middle Temperature	380 to 410 °F	193 to 210 °C
Front Temperature	370 to 400 °F	188 to 204 °C
Nozzle Temperature	360 to 380 °F	182 to 193 °C
Processing (Melt) Temp	380 to 420 °F	193 to 216 °C
Mold Temperature	90 to 160 °F	32 to 71 °C
Injection Rate	Slow-Moderate	Slow-Moderate
Back Pressure	0.00 to 100 psi	0.00 to 0.689 MPa

Injection Notes
 Screw speed: Slow to Medium

Notes

These are typical property values not to be construed as specification limits.