

Technical Data Sheet
POLYFORT® FIPP 20 T LE
K1731



Polypropylene Copolymer
 Engineering Plastics

Product Description

20% talc filled PP-Copolymer with low emission; UV- and high heat stabilized

General

Filler / Reinforcement	• Talc, 20% Filler by Weight
Features	• Low Emissions
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.05 g/cm ³	1.05 g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	7.00 cm ³ /10min	7.00 cm ³ /10min	ISO 1133
Molding Shrinkage	0.90 to 1.3 %	0.90 to 1.3 %	ISO 294-4

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	305000 psi	2100 MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	3340 psi	23.0 MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	5.0 %	5.0 %	ISO 527-2/1A/50

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	1.9 ft·lb/in ²	4.0 kJ/m ²	
73°F (23°C)	3.3 ft·lb/in ²	7.0 kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	17 ft·lb/in ²	36 kJ/m ²	
73°F (23°C)	No Break	No Break	

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	210 °F	99.0 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	140 °F	60.0 °C	ISO 75-2/ Af
Vicat Softening Temperature			
--	293 °F	145 °C	ISO 306/A50
--	153 °F	67.0 °C	ISO 306/B50

Electrical	Nominal Value (English)	Nominal Value (SI)	Test Method
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1

Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	ISO 3795
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	FMVSS 302
Flammability Classification			IEC 60695-11-10, -20
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	

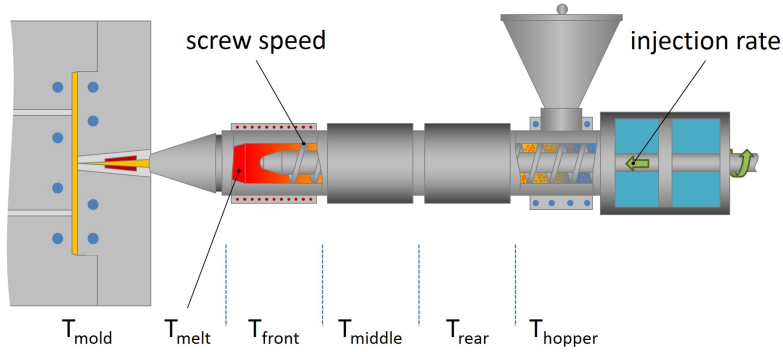
Additional Information

- 1.) Not for use in food contact applications
- 2.) Not for use in medical or pharmaceutical applications

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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
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	446 to 518 °F	230 to 270 °C
Mold Temperature	104 to 158 °F	40 to 70 °C

Injection Notes

Drying normally not necessary.

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.