Technical Data Sheet

Polyfort FIPP MKF 4025 K2311

Polypropylene Copolymer
LyondellBasell Industries
Engineering Plastics

Product Description
40% glass fibre and mineral reinforced / filled PP-Copolymer compound with reduced warpage

General		
Filler / Reinforcement	• Glass\Mineral, 40% Filler by Weight	
Features	• Heat Stabilized • High Strength	• High Toughness • Low Warpage
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PP-C 25%GF 15% MF	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.22 g/cm³	1.22 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (230°c/2.16 Kg)	17 cm³/10min	17 cm³/10min	ISO 1133
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	943000 psi	6500 MPa	ISO 527-1/1A/1
Tensile Stress (Break)	8990 psi	62.0 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.8 %	2.8 %	ISO 527-2/1A/5
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°f (-30°c)	2.9 ft·lb/in²	6.0 kJ/m²	
73°f (23°c)	3.8 ft·lb/in²	8.0 kJ/m²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°f (-30°c)	13 ft·lb/in²	27 kJ/m²	
73°f (23°c)	14 ft·lb/in²	29 kJ/m²	
Hardness	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Ball Indentation Hardness (H 358/30)	13100 psi	90.0 MPa	ISO 2039-1
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			
66 Psi (0.45 Mpa), Unannealed	315 °F	157 °C	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	288 °F	142 °C	ISO 75-2/Af
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

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

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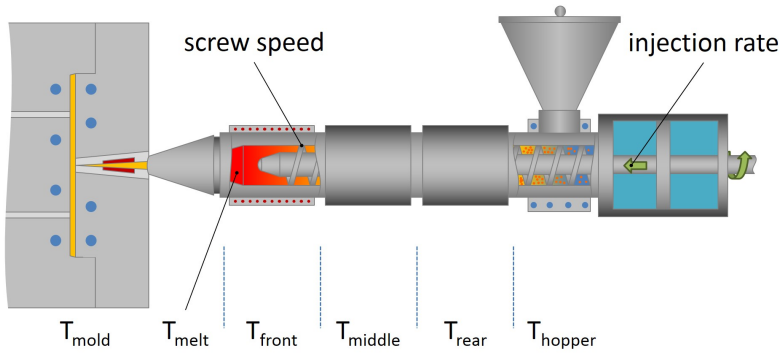

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Processing (Melt) Temp	428 to 500 °F	220 to 260 °C
Mold Temperature	86 to 140 °F	30 to 60 °C

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.