

Technical Data Sheet

**Polyfort FIPPMKF4025K2311 BLKSN**



Polypropylene Copolymer

**Product Description**

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

<b>Processing Method</b>	Injection Molding
<b>Attribute</b>	Heat Stabilized; High Strength; High Toughness; Low Warpage
<b>Filler/Reinforcement</b>	Glass Fiber/Mineral, 40%
<b>Resin ID</b>	PP-C 25%GF 15% MF

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Melt Volume Flow Rate, (230 °C/2.16 kg)	17	cm <sup>3</sup> /10 min	ISO 1133
Density, (Method A)	1.22	g/cm <sup>3</sup>	ISO 1183
<b>Mechanical</b>			
Tensile Strain at Break, (Type 1A, 5 mm/min)	2.8	%	ISO 527-2
Tensile Stress at Break, (Type 1A, 5 mm/min)	62.0	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	6500	MPa	ISO 527-1
<b>Impact</b>			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	8.0	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	6.0	kJ/m <sup>2</sup>	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	29	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise)	27	kJ/m <sup>2</sup>	ISO 179
<b>Hardness</b>			
Ball Indentation Hardness, (H 358/30)	90.0	MPa	ISO 2039-1
<b>Thermal</b>			
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	157	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	142	°C	ISO 75-2/A
<b>Flammable</b>			
Burning Rate			
(2.00 mm)	<100	mm/min	ISO 3795
(2.00 mm)	<100	mm/min	FMVSS 302

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 3.0	hr
Drying Temperature	80	°C
Processing (Melt) Temp	220 to 260	°C
Mold Temperature	30 to 60	°C