

## Technical Data Sheet

### Polyfort PP-68/TC/20 NATLNAT



Polypropylene Copolymer

#### Product Description

Polyfort PP-68/TC/20 NATLNAT is a Polypropylene Copolymer Talc, 20% filled material. Features include: Copolymer.

Attribute	Copolymer
Forms	Pellets
Filler/Reinforcement	Talc, 20%

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Melt Flow Rate, (230 °C/2.16 kg)	7.0	g/10 min	ASTM D1238
Density - Specific Gravity	1.06	g/cm <sup>3</sup>	ASTM D792
<b>Mechanical</b>			
Tensile Strength, (23 °C)	27.6	MPa	ASTM D638
Tensile Elongation at Yield, (23 °C)	30	%	ASTM D638
Flexural Modulus, (23 °C, Tangent)	2340	MPa	ASTM D790
Tensile Modulus, (23 °C)	2480	MPa	ASTM D638
Flexural Strength, (23 °C)	40.0	MPa	ASTM D790
<b>Impact</b>			
Notched Izod Impact, (23 °C, 3.18 mm)	80	J/m	ASTM D256
<b>Hardness</b>			
Rockwell Hardness, (R-Scale)	80 to 85		ASTM D785
<b>Thermal</b>			
Deflection Temperature Under Load Unannealed (264 psi)	76.7	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	82.2	°C	ASTM D648
<b>Additional Information</b>			
Water Absorption at 24 hrs	0.02	%	ASTM D570

Injection Parameters	Nominal Value	Units
Drying Time	2	hr
Drying Temperature	77	°C
Suggested Max Moisture	0.2	%
Nozzle Temperature	182 to 193	°C
Processing (Melt) Temp	199 to 232	°C
Front Temperature	182 to 199	°C
Middle Temperature	204 to 227	°C
Rear Temperature	199 to 210	°C
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 0.689	MPa
Mold Temperature	32 to 71	°C