

Technical Data Sheet

**Polyfort FPP 2478**

Polypropylene
LyondellBasell Industries
Engineering Plastics

Product Description

PP 25% Mineral

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Mineral, 25% Filler by Weight
Processing Method	• Injection Molding

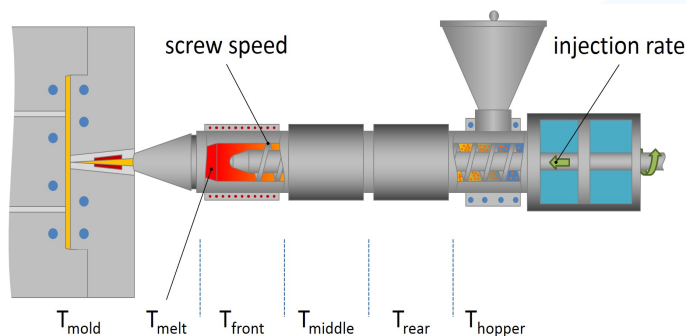
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.10 g/cm ³	1.10 g/cm ³	ISO 1183
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Stress (Yield)	3190 psi	22.0 MPa	ISO 527-2/50
Flexural Modulus ¹	399000 psi	2750 MPa	ISO 178
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength	10 ft·lb/in ²	22 kJ/m ²	ISO 179
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed	136 °F	58.0 °C	ISO 75-2/A
Additional Information	Nominal Value (English)	Nominal Value (SI)	Test Method
Filler Content	26 %	26 %	ASTM D5630

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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 Rate	Moderate-Fast	Moderate-Fast

Injection Notes

Polypropylene is not hygroscopic and generally does not require drying. As a good practice and to avoid residual humidity from transport or storage conditions, we recommend drying the material.

Ensure good mold venting

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.

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Notes

¹ 0.079 in/min (2.0 mm/min)

Notes

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

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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