

Technical Data Sheet

**Polyfort PP 1329HU**

Polypropylene
LyondellBasell Industries
Engineering Plastics

Product Description

Polyfort® PP 1329HU is a high flow UV stabilized, medium impact copolymer polypropylene. It is suitable for applications which require a material with the following properties:

General

Material Status	• Commercial: Active
Availability	• North America
Features	• Medium Impact Resistance
Appearance	• Colors Available • Natural Color
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	0.903	0.901 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	16 to 20 g/10 min	16 to 20 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	3630 psi	25.0 MPa	ASTM D638
Tensile Elongation (Break)	130 %	130 %	ASTM D638
Flexural Modulus - Tangent ¹	162000 psi	1120 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact	2.3 ft·lb/in	120 J/m	ASTM D256
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-Scale)	83	83	ASTM D785
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 66 psi (0.45 MPa), Unannealed	176 °F	80.0 °C	ASTM D648

Additional Information

Material does not require drying, however if surface moisture present, then the material can be dried at 180F for 2-4 hours.

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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 0.051 in/min (1.3 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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