

Technical Data Sheet
Fiberfil® PP-61/CC/20
Polypropylene Copolymer
Engineering Plastics



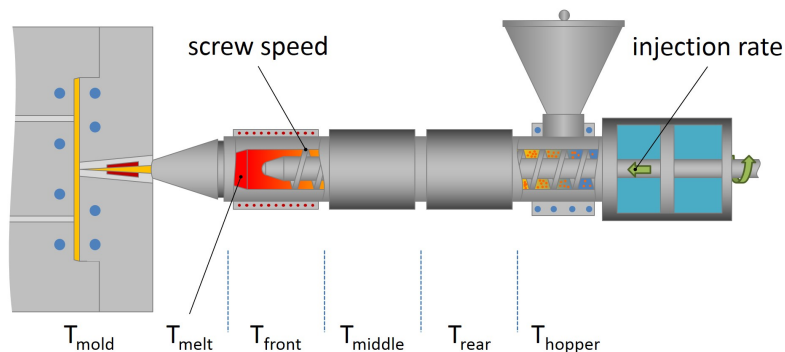
General			
Filler / Reinforcement	• Calcium Carbonate, 20% Filler by Weight		
Features	• Copolymer		
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.07	1.07 g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	10 to 15 g/10 min	10 to 15 g/10 min	ASTM D1238
Molding Shrinkage - Flow			ASTM D955
0.125 in (3.18 mm)	0.012 to 0.014 in/in	1.2 to 1.4 %	
0.250 in (6.35 mm)	0.014 to 0.016 in/in	1.4 to 1.6 %	
Water Absorption (24 hr)	0.10 %	0.10 %	ASTM D570
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus (73°F (23°C))	240000 psi	1650 MPa	ASTM D638
Tensile Strength (73°F (23°C))	3400 psi	23.4 MPa	ASTM D638
Tensile Elongation (Break, 73°F (23°C))	50 %	50 %	ASTM D638
Flexural Modulus - Tangent (73°F (23°C))	220000 psi	1520 MPa	ASTM D790
Flexural Strength (73°F (23°C))	4200 psi	29.0 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.125 in (3.18 mm)	0.90 ft·lb/in	48 J/m	
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-Scale)	75 to 85	75 to 85	ASTM D785
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi (0.45 MPa), Unannealed	215 °F	102 °C	
264 psi (1.8 MPa), Unannealed	140 °F	60.0 °C	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	170 °F	77 °C
Drying Time	2.0 hr	2.0 hr
Suggested Max Moisture	0.20 %	0.20 %
Rear Temperature	390 to 410 °F	199 to 210 °C
Middle Temperature	400 to 440 °F	204 to 227 °C
Front Temperature	360 to 390 °F	182 to 199 °C
Nozzle Temperature	360 to 380 °F	182 to 193 °C
Processing (Melt) Temp	390 to 450 °F	199 to 232 °C
Mold Temperature	90 to 160 °F	32 to 71 °C
Injection Rate	Moderate-Fast	Moderate-Fast
Back Pressure	0.00 to 100 psi	0.00 to 0.689 MPa

Injection Notes

Screw speed: Medium to Fast

Notes

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