

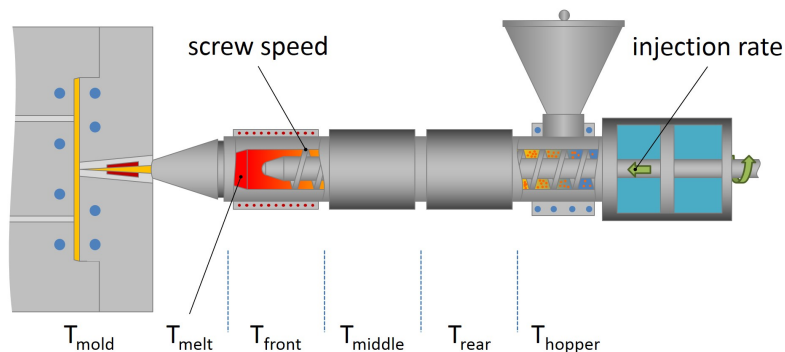
Technical Data Sheet
FERREX® GPP35CN
Polypropylene
Engineering Plastics



General			
Filler / Reinforcement	• Calcium Carbonate, 36% Filler by Weight		
Features	• Good Impact Resistance	• Good Processability	• High Gloss
Uses	• Lawn and Garden Equipment		
Forms	• Pellets		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.20	1.19 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	21 g/10 min	21 g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.012 to 0.014 in/in	1.2 to 1.4 %	ASTM D955
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	3500 psi	24.1 MPa	ASTM D638
Tensile Elongation (Break)	33 %	33 %	ASTM D638
Flexural Modulus	350000 psi	2410 MPa	ASTM D790
Flexural Strength (Yield)	6100 psi	42.1 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (73°F (23°C))	0.50 ft·lb/in	27 J/m	ASTM D256
Unnotched Izod Impact (73°F (23°C))	10 ft·lb/in	530 J/m	ASTM D256
Gardner Impact (0.125 in (3.18 mm))	50.0 in·lb	5.65 J	ASTM D3029
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Durometer Hardness (Shore D)	67	67	ASTM D2240
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi (0.45 MPa), Unannealed	225 °F	107 °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	200 °F	93 °C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Rear Temperature	390 to 400 °F	199 to 204 °C
Middle Temperature	400 to 410 °F	204 to 210 °C
Front Temperature	410 to 420 °F	210 to 216 °C
Nozzle Temperature	420 to 430 °F	216 to 221 °C
Mold Temperature	115 to 140 °F	46 to 60 °C
Back Pressure	20.0 to 50.0 psi	0.138 to 0.345 MPa
Screw Speed	100 to 150 rpm	100 to 150 rpm
Clamp Tonnage	2.0 to 3.0 tons/in ²	2.8 to 4.1 kN/cm ²
Screw L/D Ratio	20.0:1.0	20.0:1.0
Screw Compression Ratio	2.0:1.0	2.0:1.0

Notes

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