

Technical Data Sheet

Polyfort J-60/40/FD NATLNAT



Polypropylene, Homopolymer

Product Description

Molding Parameters: For 2-zone machines, the rear temperature is 480-550°F, and the front temperature is 400-450°F.

Processing Method	Injection Molding
Forms	Pellets
Filler/Reinforcement	Glass Fiber, 40%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density - Specific Gravity	1.22	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Break, (23 °C)	42.7	MPa	ASTM D638
Flexural Modulus, (23 °C)	6270	MPa	ASTM D790
Flexural Strength at Break, (23 °C)	53.8	MPa	ASTM D790
Impact			
Notched Izod Impact, (23 °C, 3.18 mm)	64	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	129	°C	ASTM D648
Additional Information			
Water Absorption at 24 hrs	0.05	%	ASTM D570

Injection Parameters	Nominal Value	Units
Nozzle Temperature	182 to 193	°C
Processing (Melt) Temp	199 to 232	°C
Front Temperature	193 to 216	°C
Middle Temperature	204 to 227	°C
Rear Temperature	199 to 210	°C
Mold Temperature	38 to 71	°C