

## 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 <sup>3</sup> | 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 <sup>1</sup>                            | 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<br>66 Psi (0.45 Mpa), Unannealed | 176 °F                  | 80.0 °C                 | ASTM D648   |

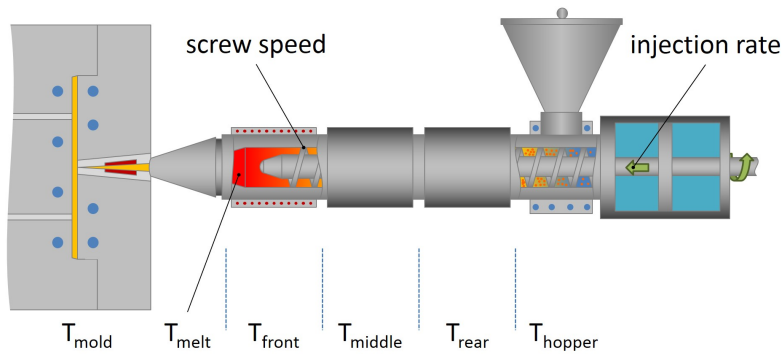
### Additional Information

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.

### Notes

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