

## Technical Data Sheet

### *Polyfort* FPP 2478U-3243 RXF BKBLK

Polypropylene, Unspecified (PP, Unspecified)

#### Product Description

PP 25% Mineral

**Processing Method** Injection Molding

**Filler/Reinforcement** Mineral, 25%

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Density	1.1	g/cm <sup>3</sup>	ISO 1183
<b>Mechanical</b>			
Tensile Stress at Yield, (50 mm/min)	22.0	MPa	ISO 527-2
Flexural Modulus, (2.0 mm/min)	2750	MPa	ISO 178
<b>Impact</b>			
Charpy Impact Strength - Notched	22	kJ/m <sup>2</sup>	ISO 179
<b>Thermal</b>			
Deflection Temperature Under Load Unannealed (1.80 MPa)	58	°C	ISO 75-2/A
<b>Additional Information</b>			
Filler Content	26	%	ASTM D5630

Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 3.0	hr
Drying Temperature	80	°C
Processing (Melt) Temp	220 to 260	°C
Injection Rate	Moderate-Fast	
Mold Temperature	30 to 60	°C