

## Technical Data Sheet

### *Polyfort* GPP-0215U BK2115BLK



Polypropylene, Unspecified (PP, Unspecified)

#### Product Description

GPP-0215U is a 15% Glass-Reinforced, UV Stabilized Polypropylene

|                      |                   |
|----------------------|-------------------|
| Processing Method    | Injection Molding |
| Attribute            | UV Stabilized     |
| Forms                | Pellets           |
| Appearance           | Black             |
| Additive             | Impact Modifier   |
| Filler/Reinforcement | Glass Fiber, 15%  |

| Typical Properties               | Nominal Value | Units    | Test Method |
|----------------------------------|---------------|----------|-------------|
| <b>Physical</b>                  |               |          |             |
| Melt Flow Rate, (230 °C/2.16 kg) | 12            | g/10 min | ASTM D1238  |
| <b>Mechanical</b>                |               |          |             |
| Tensile Strength, (23 °C)        | 53.1          | MPa      | ASTM D638   |
| Flexural Modulus                 | 3120          | MPa      | ASTM D790   |
| <b>Impact</b>                    |               |          |             |
| Notched Izod Impact, (23 °C)     | 75            | J/m      | ASTM D256   |

| Injection Parameters    | Value          | Units              |
|-------------------------|----------------|--------------------|
| Drying Time             | 2.0 to 3.0     | hr                 |
| Drying Temperature      | 93             | °C                 |
| Clamp Tonnage           | 2.8 to 4.1     | kN/cm <sup>2</sup> |
| Nozzle Temperature      | 216 to 221     | °C                 |
| Screw Speed             | 100 to 150     | rpm                |
| Front Temperature       | 210 to 216     | °C                 |
| Screw L/D Ratio         | 20.0-1.0       |                    |
| Screw Compression Ratio | 2.0-1.0        |                    |
| Middle Temperature      | 204 to 210     | °C                 |
| Rear Temperature        | 199 to 204     | °C                 |
| Back Pressure           | 0.138 to 0.345 | MPa                |
| Mold Temperature        | 46 to 60       | °C                 |