

POLYFORT® FPP 30 GFC K1079 LE

Polypropylene Homopolymer

A. Schulman Europe

Message:

30 % glass fiber reinforced PP-Homopolymer, long term heat stabilized; low emission

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Processing Method	Injection molding		
Resin ID (ISO 1043)	PP-H GF30		
Physical	Nominal Value	Unit	Test Method
Density	1.11	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	5.00	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	128	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6500	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	84.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.8	%	ISO 527-2/1A/5
Flexural Modulus ¹	6000	MPa	ISO 178
Flexural Stress ²			ISO 178
3.6% strain ³	126	MPa	ISO 178
3.4% strain	128	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	8.0	kJ/m ²	ISO 179/1eA
23°C	9.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	45	kJ/m ²	ISO 179/1eU
23°C	48	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	159	°C	ISO 75-2/Bf
1.8 MPa, not annealed	145	°C	ISO 75-2/Af
Ball Pressure Test (145°C)	Pass		IEC 60695-10-2
Flammability	Nominal Value	Unit	Test Method
Burning Rate	< 100	mm/min	ISO 3795
Flammability Classification			IEC 60695-11-10, -20
1.50 mm	HB		IEC 60695-11-10, -20

3.00 mm	HB		IEC 60695-11-10, -20
Glow Wire Flammability Index			IEC 60695-2-12
1.50 mm	750	°C	IEC 60695-2-12
3.00 mm	750	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
1.50 mm	775	°C	IEC 60695-2-13
3.00 mm	775	°C	IEC 60695-2-13

Additional Information

1.)

Not for use in food contact applications2.)

Not for use in medical or pharmaceutical applicationsPolyfort is the brand name for modified and filled/reinforced PP compounds . Polyfort grades can easily be processed and offer a very good resistance to many chemicals. The resistance to aromatic and chlorinated solvents is limited. Avoid any contact between the melt and copper or alloys containing copper.

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Regrind	10	%
Hopper Temperature	70.0	°C
Rear Temperature	205 - 245	°C
Middle Temperature	210 - 250	°C
Front Temperature	215 - 255	°C
Nozzle Temperature	220 - 260	°C
Processing (Melt) Temp	215 - 255	°C
Mold Temperature	40.0 - 70.0	°C
Injection Pressure	160	MPa
Holding Pressure	90.0	MPa
Back Pressure	10.0	MPa
Cushion	5.00 - 10.0	mm
Vent Depth	0.020	mm

Injection instructions

PredryingIn many cases predrying of Polyfort grades is not necessary. If the moisture content is higher than 0.2% predrying at 80°C for 2-4 hours is recommended.ProcessingExcessive stress on the material as a result of high temperatures, friction or residence time should be avoided.ReprocessingUp to 10 % regrind may be usedShut downThe material should not be left in the cylinder. If in doubt purge with virgin poleolefin before restartingFinishingPretreatments which activate the surface are suitable for varnishing and glueing

NOTE

- | | |
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| 1. | 2.0 mm/min |
| 2. | 2.0 mm/min |
| 3. | at Break |

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