

## TDS Polyfort<sup>™</sup> FIPP 20 T Polypropylene Copolymer

20% talc filled PP-Copolymer				
General				
Material Status	Comme	ercial: Active		
Availability	Africa & Middle East		Asia Pacific	Europe
	Latin A	merica	North America	
Filler / Reinforcement	Talc, 20% Filler by Weight			
Processing Method	Processing Method Injection			
Physical		Nominal Value (English)	Nominal Value (SI)	Test Method
Density		1.05g/cm <sup>3</sup>	1.05g/cm <sup>3</sup>	ISO 1183/A
Melt Volume-Flow Rate (MVR) (230°C/2	2.16 kg)	0.427 in <sup>3</sup> /10min	7.00 cm³/10min	ISO 1133
Mechanical		Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus		319000 psi	2200 MPa	ISO 527-2/1A/1
Tensile Stress (Yield)		3630 psi	25.0 MPa	ISO 527-2/1A/50
Tensile Strain (Yield)		4.0 %	4.0 %	ISO 527-2/1A/50
Impact		Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)		1.9 ft·lb/in²	4.0 kJ/m <sup>2</sup>	
		3.1 ft·lb/in²	6.5 kJ/m²	
73°F (23°C)				ISO 179/1eU
73°F (23°C) Charpy Unnotched Impact Strength -22°F (-30°C)		17 ft·lb/in <sup>2</sup>	36 kJ/m²	

Page: 1 of 3

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Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Ball Indentation Hardness (H 358/30)	7830 psi	54.0 MPa	ISO 2039-1
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	217°F	103°C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	147°F	64°C	ISO 75-2/Af
Vicat Softening Temperature			
	293°F	145°C	ISO 306/A50
	158°F	70.0°C	ISO 306/B50

			<b>T</b>
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate (0.0787 in (2.00 mm))	< 1.4 in/min	< 36 mm/min	ISO 3795
Flammability Classification			IEC 60695-11-10, -20
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	
Glow Wire Flammability Index			IEC 60695-2-12
0.06 in (1.5 mm)	1290°F	700°C	
0.08 in (2.0 mm)	1290°F	700°C	
0.12 in (3.0 mm)	1290°F	700°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.06 in (1.5 mm)	1340°F	725°C	
0.08 in (2.0 mm)	1340°F	725°C	
0.12 in (3.0 mm)	1340°F	725°C	

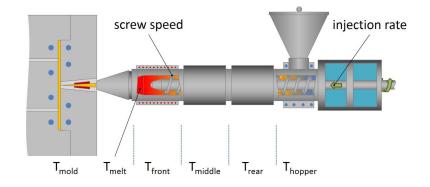
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Injection	Nominal Value (Engl	ish) Nominal Value (SI)
Drying Temperature	176°F	80°C
Drying Time	2.0 to 3.0 hr	2.0 to 3.0 hr
Suggested Max Regrind	20%	20%
Processing (Melt) Temp	446 to 518°F	230 to 270°C
Mold Temperature	104 to 158°F	40 to 70°C

## **Injection Notes**

\*Drying normally not necessary

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