

Matrixx CPP1B10

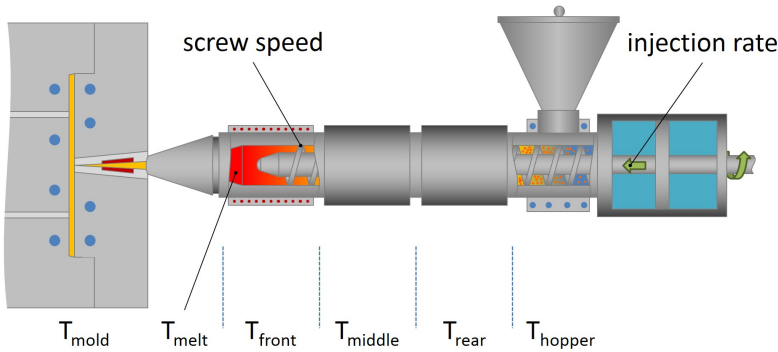
Polypropylene
LyondellBasell Industries
Engineering Plastics

General			
Filler / Reinforcement	• Calcium Carbonate, 10% Filler by Weight		
Forms	• Pellets		
Processing Method	• Injection Molding		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	0.970	0.968 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 Kg)	10 g/10 min	10 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength (Yield)	4400 psi	30.3 MPa	ASTM D638
Flexural Modulus - Tangent	240000 psi	1650 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact	0.70 ft·lb/in	37 J/m	ASTM D256
Gardner Impact	20.0 in·lb	2.26 J	ASTM D5420
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load 66 Psi (0.45 Mpa), Unannealed	200 °F	93.3 °C	ASTM D648
RTI Str	150 °F	65.6 °C	UL 746B
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating (0.06 In (1.5 Mm))	HB	HB	UL 94



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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	180 to 220 °F	82 to 104 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Rear Temperature	370 to 450 °F	188 to 232 °C
Middle Temperature	370 to 450 °F	188 to 232 °C
Front Temperature	370 to 450 °F	188 to 232 °C
Processing (Melt) Temp	390 to 450 °F	199 to 232 °C
Mold Temperature	70 to 120 °F	21 to 49 °C
Injection Rate	Moderate	Moderate
Back Pressure	20.0 to 300 psi	0.138 to 2.07 MPa
Cushion	0.250 to 0.500 in	6.35 to 12.7 mm

Injection Notes

- Drying not normally required
- Injection Booster Pressure: Maximum without flash, 60% of machine maximum, target
- Screw Speed: Slow to Medium

Notes

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

