**Technical Data Sheet**

# Fiberfil® PP-68/V2

Polypropylene Copolymer
Engineering Plastics

lyondellbasell

| General | | |
|---|---|---|
| Features | • Copolymer | • Flame Retardant |
| Forms | • Pellets | |

| Physical | Nominal Value (English) | Nominal Value (SI) | Test Method |
|---|---|---|---|
| Density / Specific Gravity | 0.980 | 0.978 g/cm³ | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 20 g/10 min | 20 g/10 min | ASTM D1238 |
| Molding Shrinkage - Flow | | | ASTM D955 |
| 0.125 in (3.18 mm) | 0.017 to 0.021 in/in | 1.7 to 2.1 % | |
| 0.250 in (6.35 mm) | 0.020 to 0.024 in/in | 2.0 to 2.4 % | |
| Water Absorption (24 hr) | 0.020 % | 0.020 % | ASTM D570 |
| **Mechanical** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Tensile Modulus (73°F (23°C)) | 130000 psi | 896 MPa | ASTM D638 |
| Tensile Strength (73°F (23°C)) | 2760 psi | 19.0 MPa | ASTM D638 |
| Tensile Elongation (Yield, 73°F (23°C)) | 25 % | 25 % | ASTM D638 |
| Flexural Modulus - Tangent (73°F (23°C)) | 120000 psi | 827 MPa | ASTM D790 |
| Flexural Strength (73°F (23°C)) | 4600 psi | 31.7 MPa | ASTM D790 |
| **Impact** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Notched Izod Impact | | | ASTM D256 |
| 73°F (23°C), 0.125 in (3.18 mm) | 6.0 ft·lb/in | 320 J/m | |
| **Hardness** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Rockwell Hardness (R-Scale) | 85 to 90 | 85 to 90 | ASTM D785 |
| **Thermal** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Deflection Temperature Under Load | | | ASTM D648 |
| 66 psi (0.45 MPa), Unannealed | 160 °F | 71.1 °C | |
| 264 psi (1.8 MPa), Unannealed | 145 °F | 62.8 °C | |
| **Flammability** | **Nominal Value (English)** | **Nominal Value (SI)** | **Test Method** |
| Flame Rating (0.06 in (1.5 mm)) | V-2 | V-2 | UL 94 |

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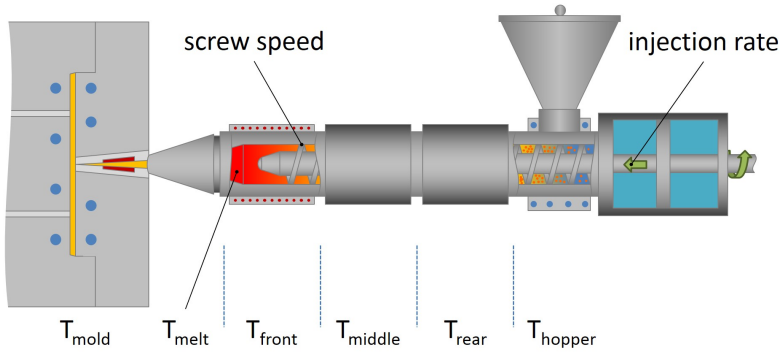


| Injection | Nominal Value (English) | Nominal Value (SI) |
|---|---|---|
| Drying Temperature | 170 °F | 77 °C |
| Drying Time | 2.0 hr | 2.0 hr |
| Suggested Max Moisture | 0.20 % | 0.20 % |
| Rear Temperature | 360 to 390 °F | 182 to 199 °C |
| Middle Temperature | 380 to 410 °F | 193 to 210 °C |
| Front Temperature | 370 to 400 °F | 188 to 204 °C |
| Nozzle Temperature | 360 to 380 °F | 182 to 193 °C |
| Processing (Melt) Temp | 380 to 420 °F | 193 to 216 °C |
| Mold Temperature | 90 to 160 °F | 32 to 71 °C |
| Injection Rate | Slow-Moderate | Slow-Moderate |
| Back Pressure | 0.00 to 100 psi | 0.00 to 0.689 MPa |
| **Injection Notes** | | |
| Screw speed: Slow to Medium | | |

## Notes

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