

Technical Data Sheet
Fiberfil® PP-68/TC/20
Polypropylene Copolymer
Engineering Plastics



General			
Filler / Reinforcement	• Talc, 20% Filler by Weight		
Features	• Copolymer		
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.06	1.06 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	7.0 g/10 min	7.0 g/10 min	ASTM D1238
Molding Shrinkage - Flow			ASTM D955
0.125 in (3.18 mm)	0.010 in/in	1.0 %	
0.250 in (6.35 mm)	0.012 in/in	1.2 %	
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))	360000 psi	2480 MPa	ASTM D638
Tensile Strength (73°F (23°C))	4000 psi	27.6 MPa	ASTM D638
Tensile Elongation (Yield, 73°F (23°C))	30 %	30 %	ASTM D638
Flexural Modulus - Tangent (73°F (23°C))	340000 psi	2340 MPa	ASTM D790
Flexural Strength (73°F (23°C))	5800 psi	40.0 MPa	ASTM D790

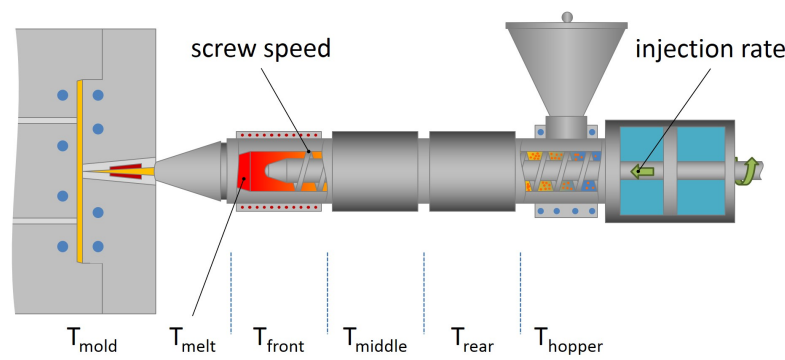
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.125 in (3.18 mm)	1.5 ft·lb/in	80 J/m	

Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-Scale)	80 to 85	80 to 85	ASTM D785

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi (0.45 MPa), Unannealed	180 °F	82.2 °C	
264 psi (1.8 MPa), Unannealed	170 °F	76.7 °C	



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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	390 to 410 °F	199 to 210 °C
Middle Temperature	400 to 440 °F	204 to 227 °C
Front Temperature	360 to 390 °F	182 to 199 °C
Nozzle Temperature	360 to 380 °F	182 to 193 °C
Processing (Melt) Temp	390 to 450 °F	199 to 232 °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: Medium to Fast

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

