

Fiberfil M-1812

Polypropylene Homopolymer

LyondellBasell Industries

Engineering Plastics

General			
Filler / Reinforcement	• Talc, 45% Filler by Weight		
Features	• Homopolymer		
Forms	• Pellets		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.29	1.29 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 Kg)	20 g/10 min	20 g/10 min	ASTM D1238
Water Absorption (24 Hr)	0.030 %	0.030 %	ASTM D570

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus (73°F (23°C))	675000 psi	4650 MPa	ASTM D638
Tensile Strength (73°F (23°C))	4500 psi	31.0 MPa	ASTM D638
Tensile Elongation (Yield, 73°F (23°C))	9.0 %	9.0 %	ASTM D638
Flexural Modulus - Tangent (73°F (23°C))	650000 psi	4480 MPa	ASTM D790
Flexural Strength (73°F (23°C))	7700 psi	53.1 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)	0.50 ft·lb/in	27 J/m	

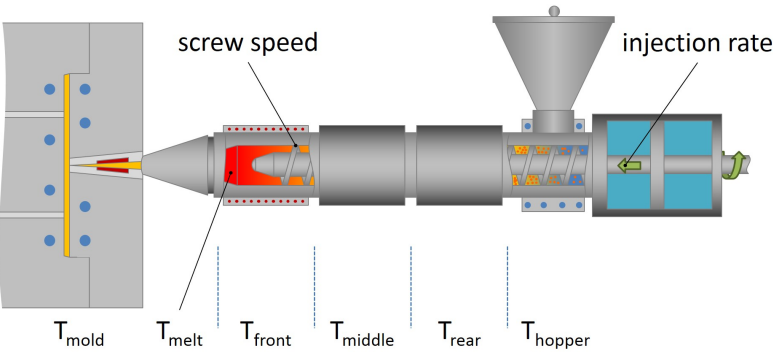
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (R-scale)	95 to 100	95 to 100	ASTM D785

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 Psi (0.45 Mpa), Unannealed	295 °F	146 °C	
264 Psi (1.8 Mpa), Unannealed	240 °F	116 °C	



Fiberfil M-1812

Polypropylene Homopolymer
LyondellBasell Industries
Engineering Plastics



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	Moderate-Fast	Moderate-Fast
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.

