

# Polyfort RPP20DA04BK-BKBLK

## LyondellBasell Industries - Polypropylene

### General Information

#### Product Description

Polyfort RPP20DA04BK-BKBLK is a Polypropylene, Unspecified Glass Fiber, 20% filled material and is typically used in Injection Molding applications. Features include: Creep Resistant, Homopolymer, and Low Shrinkage.

#### General

Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Features	• Creep Resistant	• Homopolymer	• Low Shrinkage
Uses	• Automotive Applications		
Forms	• Pellets		
Processing Method	• Injection Molding		

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.04		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	5800	psi	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	529000	psi	ASTM D790
Flexural Strength (Yield)	8600	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	0.60	ft-lb/in	ASTM D256
Unnotched Izod Impact (73°F)	3.6	ft-lb/in	ASTM D4812
Gardner Impact (0.125 in)	2.00	in-lb	ASTM D3029
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	72		ASTM D2240
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	295	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	241	°F	ASTM D648

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	160 to 180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	430 to 460	°F
Middle Temperature	441 to 469	°F
Front Temperature	450 to 500	°F
Nozzle Temperature	450 to 500	°F
Processing (Melt) Temp	430 to 460	°F
Mold Temperature	100 to 151	°F
Injection Rate	Slow-Moderate	
Back Pressure	20.0 to 50.0	psi
Cushion	0.200 to 0.500	in