



Polyfort TPP13AC03BK-BKBLK

LyondellBasell Industries - Polypropylene Homopolymer

General Information

Product Description

Meets/Exceeds Ford Engineering Specification ESB-M4D606-A.
 Primary end use is for armrest inserts and visor panel cores.

General

Filler / Reinforcement	• Talc, 13% Filler by Weight
Additive	• Heat Stabilizer
Features	• Heat Stabilized • Homopolymer
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.01		ASTM D792
Density	1.01	g/cm ³	ISO 1183/A
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)	5110	psi	ASTM D638
Tensile Stress (Yield, 73°F)	4760	psi	ISO 527-2
Tensile Elongation (Break)	26	%	ASTM D638
Flexural Modulus	280000	psi	ASTM D790
Flexural Modulus	339000	psi	ISO 178
Flexural Strength (Yield)	7300	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	0.60	ft·lb/in	ASTM D256
Notched Izod Impact Strength			ISO 180
-40°F	1.1	ft·lb/in ²	
73°F	1.3	ft·lb/in ²	
Unnotched Izod Impact (73°F)	12	ft·lb/in	ASTM D4812
Gardner Impact	10.0	in·lb	ASTM D3029
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	73		ASTM D2240
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	241	°F	ASTM D648
Deflection Temperature Under Load (66 psi, Unannealed)	235	°F	ISO 75-2/B
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed	150	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed	147	°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F

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Injection	Nominal Value	Unit
Drying Time	2.0 to 3.0	hr
Rear Temperature	399 to 410	°F
Middle Temperature	410 to 415	°F
Front Temperature	415 to 421	°F
Nozzle Temperature	421 to 424	°F
Processing (Melt) Temp	428 to 500	°F
Mold Temperature	86 to 140	°F
Back Pressure	20.0 to 50.0	psi
Screw Speed	100 to 150	rpm
Clamp Tonnage	2.0 to 3.0	tons/in ²