

# Polifil® PP HM-20

Polypropylene

The Plastics Group

## Message:

Polifil® PP HM-20 is a Polypropylene product filled with 20% mineral. It can be processed by blow molding or injection molding and is available in North America.

Characteristics include:

Good Processability

Homopolymer

Low Shrinkage

General Information			
Filler / Reinforcement	Mineral,20% Filler by Weight		
Features	Good Processability		
	Homopolymer		
	Low Shrinkage		
Forms	Pellets		
Processing Method	Blow Molding		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR)	3.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.90	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	95		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	34.5	MPa	ASTM D638
Flexural Modulus	3450	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	27	J/m	ASTM D256
Unnotched Izod Impact	170	J/m	ASTM D256
Gardner Impact	0.463	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed)	113	°C	ASTM D648
Injection	Nominal Value	Unit	
Rear Temperature	193 to 204	°C	
Middle Temperature	199 to 210	°C	
Front Temperature	204 to 216	°C	
Nozzle Temperature	210 to 221	°C	

Mold Temperature	48.9 to 65.6	°C
Injection Pressure	82.7 to 110	MPa
Injection Rate	Moderate-Fast	
Back Pressure	0.345	MPa

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Recommended distributors for this material

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