

Technical Data Sheet

Polyfort GPP30CN33HB-NAT



Polypropylene, Unspecified (PP, Unspecified)

Product Description

Polyfort GPP30CN33HB-NAT is a Polypropylene, Unspecified Calcium Carbonate, 30% filled material and is typically used in Injection Molding applications. Features include: High Gloss.

Regulatory Status

For regulatory compliance information, see GPP30CN33HB-NAT [Product Stewardship Bulletin \(PSB\)](#) and [Safety Data Sheet \(SDS\)](#).

Status	Commercial: Active
Availability	Latin America; North America
Processing Method	Injection Molding
Attribute	High Gloss
Forms	Pellets
Appearance	Natural Color
Filler/Reinforcement	Calcium Carbonate, 30%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (230 °C/2.16 kg)	25	g/10 min	ASTM D1238
Density - Specific Gravity	1.13	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	22.1	MPa	ASTM D638
Flexural Strength at Yield	34.5	MPa	ASTM D790
Flexural Modulus	1590	MPa	ASTM D790
Tensile Elongation at Break	85	%	ASTM D638
Impact			
Gardner Impact	26	J	ASTM D3029
Unnotched Izod Impact, (23 °C)	800	J/m	ASTM D4812
Notched Izod Impact, (23 °C)	59	J/m	ASTM D256
Hardness			
Durometer Hardness, (Shore D)	70		ASTM D2240
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	60	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	104	°C	ASTM D648



Injection Parameters	Nominal Value	Units
Drying Time	2.0 to 3.0	hr
Drying Temperature	93	°C
Clamp Tonnage	2.8 to 4.1	kN/cm ²
Nozzle Temperature	216 to 221	°C
Screw Speed	100 to 150	rpm
Front Temperature	210 to 216	°C
Screw L/D Ratio	20.0-1.0	
Screw Compression Ratio	2.0-1.0	
Middle Temperature	204 to 210	°C
Rear Temperature	199 to 204	°C
Back Pressure	0.138 to 0.345	MPa
Mold Temperature	46 to 60	°C

Notes

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

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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