

Technical Data Sheet

Polyfort M-2356 BK6453BLK

Polypropylene, Unspecified (PP, Unspecified)

Product Description

Polyfort M-2356 BK6453BLK is a Polypropylene, Unspecified material.

Forms Pellets

Appearance Black

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density - Specific Gravity	1.05	g/cm ³	ASTM D792
Mechanical			
Tensile Strength, (23 °C)	54.5	MPa	ASTM D638
Flexural Modulus, (23 °C)	4140	MPa	ASTM D790
Tensile Elongation at Break, (23 °C)	5.0	%	ASTM D638
Flexural Strength, (23 °C)	84.8	MPa	ASTM D790
Impact			
Notched Izod Impact, (23 °C, 6.35 mm)	130	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	138	°C	ASTM D648

Injection Parameters	Nominal Value	Units
Drying Time	2	hr
Drying Temperature	77	°C
Nozzle Temperature	182 to 193	°C
Processing (Melt) Temp	199 to 232	°C
Front Temperature	182 to 199	°C
Middle Temperature	204 to 227	°C
Rear Temperature	199 to 210	°C
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 0.345	MPa
Mold Temperature	38 to 71	°C