

POLYFLAM® RIPP 2000 HI

Polypropylene Copolymer

A. Schulman Europe

Message:

Unfilled flame-retardant PP-Copolymer grade, halogen free acc. DIN VDE 0172 part 815, high impact

General Information			
Features	Impact modification		
	Copolymer		
	Impact resistance, high		
	Workability, good		
	Halogen-free		
	Flame retardancy		
Processing Method	Injection molding		
Resin ID (ISO 1043)	PP FR(40)		
Physical	Nominal Value	Unit	Test Method
Density	0.910	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	10.0	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1100	MPa	ISO 527-2/1A/1
Tensile Stress			ISO 527-2/1A/50
Yield	23.0	MPa	ISO 527-2/1A/50
Fracture	18.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	10	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	300	%	ISO 527-2/1A/50
Flexural Modulus ¹	1100	MPa	ISO 178
Flexural Stress ²			ISO 178
6.4% strain	27.0	MPa	ISO 178
3.5% strain	22.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	12	kJ/m ²	ISO 179/1eA
23°C	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	80	kJ/m ²	ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			

0.45 MPa, not annealed	71.0	°C	ISO 75-2/Bf
1.8 MPa, not annealed	45.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	140	°C	ISO 306/A50
--	61.0	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94, IEC 60695-11-10, -20
0.8 mm	V-2		UL 94, IEC 60695-11-10, -20
1.6 mm	V-2		UL 94, IEC 60695-11-10, -20
3.2 mm	V-2		UL 94, IEC 60695-11-10, -20
Glow Wire Flammability Index			IEC 60695-2-12
0.75 mm	960	°C	IEC 60695-2-12
1.5 mm	960	°C	IEC 60695-2-12
2.0 mm	960	°C	IEC 60695-2-12
3.0 mm	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
0.75 mm	775	°C	IEC 60695-2-13
1.5 mm	725	°C	IEC 60695-2-13
2.0 mm	725	°C	IEC 60695-2-13
3.0 mm	750	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	70	°C	
Drying Time	2.0 - 4.0	hr	
Processing (Melt) Temp	180 - 220	°C	
Mold Temperature	40 - 80	°C	
Injection Pressure	80.0 - 120	MPa	
Injection Rate	Slow-Moderate		
Holding Pressure	40.0 - 90.0	MPa	
Back Pressure	5.00 - 10.0	MPa	
Screw Speed		mm/sec	
Injection instructions			
PredryingPredrying at 70°C for 2-4 hours is recommended as a precaution.ReprocessingAddition of regrind is normally possible, but it must be tested in each case regarding the percentage and requirements of the article. Thermal damage during first processing depends on processing parameters and the geometry of flow path and article.Shut downAvoid long melt residence time. Purge with base polymer or with polyolefines.FinishingMachining is usually possible.			
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		

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