

POLYFLAM® RPP 3225 CS1

Polypropylene Homopolymer

A. Schulman Europe

Message:

25% glass fibre reinforced flame retardant PP homo polymer compound; without PBDE

General Information			
UL YellowCard	E86615-509046	E188844-102210983	
Filler / Reinforcement	Glass fiber reinforced material, 25% filler by weight		
Features	High strength		
	Homopolymer		
	Copper contact stability		
	Flame retardancy		
UL File Number	E86615		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.48	g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	5.00	cm³/10min	ISO 1133
Water Absorption (23°C, 24 hr)	0.16	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7900	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	83.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.0	%	ISO 527-2/1A/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	9.0	kJ/m²	ISO 179/1eA
23°C	10	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	39	kJ/m²	ISO 179/1eU
23°C	40	kJ/m²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	157	°C	ISO 75-2/Bf
1.8 MPa, not annealed	145	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	161	°C	ISO 306/A50
--	129	°C	ISO 306/B50
Ball Pressure Test (145°C)	Pass		IEC 60695-10-2

RTI Elec			UL 746
1.50 mm	65.0	°C	UL 746
3.00 mm	65.0	°C	UL 746
RTI Imp			UL 746
1.50 mm	65.0	°C	UL 746
3.00 mm	65.0	°C	UL 746
RTI			UL 746
1.50 mm	65.0	°C	UL 746
3.00 mm	65.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+13	ohms·cm	IEC 60093
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Burning Rate			ISO 3795
1.50mm, automatic fire extinguishing	0.0	mm/min	ISO 3795
3.00mm, automatic fire extinguishing	0.0	mm/min	ISO 3795
Flame Rating			UL 94, IEC 60695-11-10, -20
1.50 mm	V-0		UL 94, IEC 60695-11-10, -20
3.00 mm	V-0		UL 94, IEC 60695-11-10, -20
Glow Wire Flammability Index			IEC 60695-2-12
1.50 mm	960	°C	IEC 60695-2-12
3.00 mm	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
1.50 mm	700	°C	IEC 60695-2-13
3.00 mm	775	°C	IEC 60695-2-13
Oxygen Index	28	%	ISO 4589-2
Additional Information			
1.)			
Not for use in food contact applications2.)			
Not for use in medical or pharmaceutical applications			
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 80.0	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	180	°C	
Middle Temperature	200	°C	
Front Temperature	210	°C	
Nozzle Temperature	220	°C	
Processing (Melt) Temp	180 - 220	°C	
Mold Temperature	40.0 - 80.0	°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
Cushion	< 5.00	mm
Screw Speed		mm/sec

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