

RAMOFIN PPC361T4

Polypropylene Copolymer

Polyram Ram-On Industries

Message:

20% MINERAL FILLED, HEAT RESISTANT POLYPROPYLENE FOR INJECTION MOULDINDG APPLICATIONS.

General Information			
Filler / Reinforcement	Mineral filler, 20% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.80 - 1.2	%	ASTM D955
--	0.80 - 1.2	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2200	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	17.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	30	%	ASTM D638, ISO 527-2
Flexural Modulus	1900	MPa	ASTM D790, ISO 178
Flexural Strength	40.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	150	J/m	ASTM D256
23°C	15	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	105	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	60.0	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	120	°C	
Maximum Continuous Use Temperature	110	°C	
Melting Temperature	165	°C	ISO 11357-3, ASTM D3418
Thermal Conductivity	140	W/m/K	ASTM C177, DIN 52612
Flammability	Nominal Value	Test Method	
Flame Rating (3.00 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Rear Temperature	190 - 220	°C	
Middle Temperature	200 - 225	°C	
Front Temperature	205 - 230	°C	

Mold Temperature	30.0 - 65.0	°C
Injection Pressure	70.0 - 105	MPa
Holding Pressure	35.0 - 70.0	MPa
Back Pressure	0.350 - 0.700	MPa
Screw Speed	60 - 90	rpm

Injection instructions

Fill Speed: 25 to 50 mm/sec

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