

RAMOFIN RPPC711

Polypropylene Copolymer
Polyram Ram-On Industries

Message:
UV STABILIZED POLYPROPYLENE COPOLYMER FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	UV stabilizer		
Features	Good UV resistance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.900	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	1.2 - 2.5	%	
--	1.2 - 2.5	%	ISO 2577
Water Absorption			
Saturation	> 0.030	%	ASTM D570
Saturated, 23°C	> 0.030	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	80		ASTM D785
R scale	80		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	22.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	25	%	ASTM D638, ISO 527-2
Flexural Modulus	1350	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	120	J/m	ASTM D256
23°C	12	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	82.0	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	150	°C	ASTM D1525, ISO 306
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+17	ohms · cm	IEC 60093
Dielectric Strength	500	kV/mm	IEC 60243-1
Dielectric Constant (1 MHz)	2.30		IEC 60250

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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

