

RAMOFIN PPC104

Polypropylene Copolymer
Polyram Ram-On Industries

Message:
HEAT STABILIZED POLYPROPYLENE COPOLYMER FOR INJECTION MOLDING APPLICATIONS.

General Information			
Additive	heat stabilizer		
Features	Thermal Stability		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.930	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	0.40	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	1.4 - 1.6	%	ASTM D955
--	1.4 - 1.6	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	35.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	120	%	ASTM D638, ISO 527-2
Flexural Modulus	1200	MPa	ASTM D790, ISO 178
Flexural Strength	35.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	160	J/m	ASTM D256
23°C	14	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	86.0	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	53.0	°C	ASTM D648, ISO 75-2/A
Melting Temperature	165	°C	ISO 11357-3, ASTM D3418
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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