

# RAMOFIN PPH300G3

Polypropylene Homopolymer

Polyram Ram-On Industries

Message:

15% GLASS-FIBER REINFORCED POLYPROPYLENE FOR INJECTION MOULDING APPLICATION.

| General Information                             |                                  |                   |                         |
|-------------------------------------------------|----------------------------------|-------------------|-------------------------|
| Filler / Reinforcement                          | Glass Fiber,15% Filler by Weight |                   |                         |
| RoHS Compliance                                 | RoHS Compliant                   |                   |                         |
| Processing Method                               | Injection Molding                |                   |                         |
| Physical                                        | Nominal Value                    | Unit              | Test Method             |
| Specific Gravity                                | 1.00                             | g/cm <sup>3</sup> | ASTM D792, ISO 1183     |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)       | 4.5                              | g/10 min          | ASTM D1238, ISO 1133    |
| Molding Shrinkage                               |                                  |                   |                         |
| Flow                                            | 0.30 to 0.70                     | %                 |                         |
| --                                              | 0.30 to 0.70                     | %                 | ISO 2577                |
| Mechanical                                      | Nominal Value                    | Unit              | Test Method             |
| Tensile Modulus                                 | 3800                             | MPa               | ASTM D638, ISO 527-2    |
| Tensile Strength (Yield)                        | 65.0                             | MPa               | ASTM D638, ISO 527-2    |
| Tensile Elongation (Break)                      | 4.0                              | %                 | ASTM D638, ISO 527-2    |
| Flexural Modulus                                | 3000                             | MPa               | ASTM D790, ISO 178      |
| Flexural Strength                               | 80.0                             | MPa               | ASTM D790, ISO 178      |
| Impact                                          | Nominal Value                    | Unit              | Test Method             |
| Notched Izod Impact                             |                                  |                   |                         |
| 23°C                                            | 80                               | J/m               | ASTM D256               |
| 23°C                                            | 8.0                              | kJ/m <sup>2</sup> | ISO 180                 |
| Thermal                                         | Nominal Value                    | Unit              | Test Method             |
| Deflection Temperature Under Load               |                                  |                   |                         |
| 0.45 MPa, Unannealed                            | 150                              | °C                | ASTM D648, ISO 75-2/B   |
| 1.8 MPa, Unannealed                             | 120                              | °C                | ASTM D648, ISO 75-2/A   |
| Maximum Use Temperature - Short Peaks Operation | 155                              | °C                |                         |
| Maximum Continuous Use Temperature              | 100                              | °C                |                         |
| 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 to 220                       | °C                |                         |
| Middle Temperature                              | 200 to 225                       | °C                |                         |
| Front Temperature                               | 205 to 230                       | °C                |                         |

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

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