

RAMOFIN PPH300G4

Polypropylene Homopolymer
Polyram Ram-On Industries

Message:
20% GLASS-FIBER REINFORCED POLYPROPYLENE FOR INJECTION MOULDING APPLICATION.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.01 to 1.07	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	4.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.20 to 0.50	%	ISO 2577
--	0.20 to 0.50	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4400	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	75.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.0	%	ASTM D638, ISO 527-2
Flexural Modulus	3500	MPa	ASTM D790, ISO 178
Flexural Strength	100	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	95	J/m	ASTM D256
23°C	10	kJ/m²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	152	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed	137	°C	ASTM D648, ISO 75-2/A
Maximum Use Temperature - Short Peaks Operation	155	°C	ISO 11357-3, ASTM D3418
Maximum Continuous Use Temperature	100	°C	
Melting Temperature	165	°C	
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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