

CERTENE™ PHM-35R

Polypropylene Homopolymer
Muehlstein

Message:

PHM-35R is a certified prime grade CONTROLLED RHEOLOGY developed for INJECTION MOLDING of high performance general purpose applications. PHM-35R combines high flow and easy processability with fast cycling and mechanical properties of moldings similar to a 4 to 6 Melt Flow grade. PHM-35R applications include thin-walled multi-cavity caps, closures and lids, household articles, medical syringes, and items requiring good dimensional stability free of warpage, such as straight-sided video cassette boxes. PHM-35R processing temperature is 220° to 240°C with mold at 20°- 50°C. PHM-35R complies with FDA regulation 21CFR 177.1520 (c)1.1a concerning the Polypropylene use in contact with food articles.

General Information			
Features	Controlled Rheology		
	Fast Molding Cycle		
	Food Contact Acceptable		
	Good Dimensional Stability		
	Good Processability		
	High Flow		
	Homopolymer		
	Warp Resistant		
Uses	Caps		
	Closures		
	Household Goods		
	Lids		
	Medical/Healthcare Applications		
	Thin-walled Parts		
Agency Ratings	FDA 21 CFR 177.1520(c) 1.1a		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	35	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness ¹ (R-Scale)	89		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	34.0	MPa	ASTM D638
Tensile Elongation (Yield)	9.0	%	ASTM D638
Flexural Modulus - 1% Secant ²	1310	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ³ (23°C)	32	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load ⁴ (0.45 MPa, Unannealed)	102	°C	ASTM D648
Vicat Softening Temperature ⁵	150	°C	ASTM D1525
Injection	Nominal Value	Unit	
Processing (Melt) Temp	220 to 240	°C	
Mold Temperature	20.0 to 50.0	°C	
NOTE			

1.	Test made on injection molded Type 1 tension test specimen according to ASTM D 2146.
2.	1.3 mm/min
3.	Test made on injection molded Type 1 tension test specimen according to ASTM D 2146.
4.	Test made on injection molded Type 1 tension test specimen according to ASTM D 2146.
5.	Test made on injection molded Type 1 tension test specimen according to ASTM D 2146.

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