

POLYFLAM® RIPP 510 D

Polypropylene Copolymer

A. Schulman Europe

Message:

Flame retardant PP-copolymer - grade without PBDE

General Information			
UL YellowCard	E86615-252220	E188844-102210981	
Additive	Flame retardancy		
Features	Copolymer		
	Flame retardancy		
Processing Method	Injection molding		
Part Marking Code (ISO 11469)	>PP FR()		
Physical	Nominal Value	Unit	Test Method
Density	0.940	g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	5.50	cm³/10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	62.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1100	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	23.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	12	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	3.0	kJ/m²	ISO 179/1eA
23°C	8.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	60	kJ/m²	ISO 179/1eU
23°C	No Break		ISO 179/1eU
Notched Izod Impact (23°C)	10.0	kJ/m²	ASTM D256
Notched Izod Impact			ISO 180/1A
-40°C	4.5	kJ/m²	ISO 180/1A
23°C	7.0	kJ/m²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-40°C	45	kJ/m²	ISO 180/1U
23°C	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			

0.45 MPa, not annealed	105	°C	ISO 75-2/Bf
1.8 MPa, not annealed	60.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	142	°C	ISO 306/A120
--	74.0	°C	ISO 306/B50
Ball Pressure Test (120°C)	Pass		IEC 60695-10-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+13	ohms·cm	IEC 60093
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flammability Classification			IEC 60695-11-10, -20
0.750 mm	V-2		IEC 60695-11-10, -20
1.50 mm	V-2		IEC 60695-11-10, -20
Glow Wire Flammability Index			IEC 60695-2-12
0.750 mm	960	°C	IEC 60695-2-12
1.50 mm	960	°C	IEC 60695-2-12
3.00 mm	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			IEC 60695-2-13
0.750 mm	700	°C	IEC 60695-2-13
1.50 mm	675	°C	IEC 60695-2-13
3.00 mm	675	°C	IEC 60695-2-13
Oxygen Index	29	%	ISO 4589-2
Additional Information			

1.)
Not for use in food contact applications2.)
Not for use in medical or pharmaceutical applications

Injection	Nominal Value	Unit
Drying Temperature	70.0 - 80.0	°C
Drying Time	2.0 - 4.0	hr
Rear Temperature	180	°C
Middle Temperature	200	°C
Front Temperature	210	°C
Nozzle Temperature	220	°C
Processing (Melt) Temp	180 - 220	°C
Mold Temperature	40.0 - 80.0	°C
Injection Pressure	80.0 - 120	MPa
Injection Rate	Slow-Moderate	
Holding Pressure	40.0 - 90.0	MPa
Back Pressure	5.00 - 10.0	MPa
Cushion	< 5.00	mm
Screw Speed		mm/sec

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