

RAMOFIN PPH313V4

Polypropylene Homopolymer

Polyram Ram-On Industries

Message:

20% MINERAL FILLED, IMPACT MODIFIED POLYPROPYLENE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Mineral filler, 20% filler by weight		
Additive	Impact modifier		
Features	Impact modification		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.03	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	11	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	1.1 - 1.5	%	ASTM D955
--	1.1 - 1.5	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1800	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	30.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	40	%	ASTM D638, ISO 527-2
Flexural Modulus	1600	MPa	ASTM D790, ISO 178
Flexural Strength	50.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	45	J/m	ASTM D256
23°C	4.5	kJ/m ²	ISO 180
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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