

RAMOFIN PPH353M8

Polypropylene Homopolymer

Polyram Ram-On Industries

Message:

40% MINERAL FILLED POLYPROPYLENE FOR INJECTION MOULDING APPLICATION.

General Information			
Filler / Reinforcement	Mineral,40% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	5.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.80 to 1.2	%	
--	0.80 to 1.2	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2100	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	30.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	3.0	%	ASTM D638, ISO 527-2
Flexural Modulus	2000	MPa	ASTM D790, ISO 178
Flexural Strength	60.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	75	J/m	ASTM D256
23°C	7.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	125	°C	ASTM D648, ISO 75-2/B
1.8 MPa, Unannealed	82.0	°C	ASTM D648, ISO 75-2/A
Maximum Use Temperature - Short Peaks Operation	140	°C	
Maximum Continuous Use Temperature	110	°C	
Melting Temperature	165	°C	ISO 11357-3, ASTM D3417
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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