

POLYFLAM® RPP 60335 CS1 5V

Polypropylene Homopolymer

A. Schulman Europe

Message:

25% mineral filled flame-retardant PP-Homopolymer; without PBDE

General Information			
UL YellowCard	E86615-100078340	E188844-102210990	
Filler / Reinforcement	Mineral filler, 25% filler by weight		
Features	Homopolymer		
	Good strength		
	Copper contact stability		
	Flame retardancy		
UL File Number	E86615		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	1.50	cm³/10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	24.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	2.5	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	10	kJ/m²	ISO 179/1eU
23°C	30	kJ/m²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	101	°C	ISO 75-2/Bf
1.8 MPa, not annealed	58.0	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	150	°C	ISO 306/A50
--	85.0	°C	ISO 306/B50
Ball Pressure Test (130°C)	Pass		IEC 60695-10-2
RTI Elec			UL 746
0.750 mm	65.0	°C	UL 746
1.50 mm	65.0	°C	UL 746
2.00 mm	65.0	°C	UL 746

3.00 mm	65.0	°C	UL 746
RTI Imp			UL 746
0.750 mm	65.0	°C	UL 746
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2.00 mm	65.0	°C	UL 746
3.00 mm	65.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Burning Rate			ISO 3795
0.750mm, automatic fire extinguishing	0.0	mm/min	ISO 3795
1.50mm, automatic fire extinguishing	0.0	mm/min	ISO 3795
3.00mm, automatic fire extinguishing	0.0	mm/min	ISO 3795
Flame Rating			UL 94, IEC 60695-11-10, -20
0.750 mm	V-0		UL 94, IEC 60695-11-10, -20
1.50 mm	V-0		UL 94, IEC 60695-11-10, -20
	V-0		
3.00 mm	5VB		UL 94, IEC 60695-11-10, -20
2.00 mm	5VB		UL 94, 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	800	°C	IEC 60695-2-13
1.50 mm	800	°C	IEC 60695-2-13
3.00 mm	800	°C	IEC 60695-2-13
Oxygen Index	35	%	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
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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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