

CERTENE™ PHM-35

Polypropylene Homopolymer
Muehlstein

Message:

PHM-35 is a certified prime grade Polypropylene designed for injection molding of lightweight and thin-walled applications. PHM-35 combines a good balance of high flow processability with high clarity, good tensile strength, short cycling, excellent dimensional stability, and good surface finishing. PHM-35 applications include long-flow path moldings, multi-cavity molds difficult to fill such as caps, closures and lids, housewares articles, containers, and large flat trays. PHM-35 processing temperature is 215° to 235°C with mold at 20°-50°C. PHM-35 complies with FDA regulation 21CFR 177.1520 and most international regulations concerning the use of Polypropylene in contact with food.

General Information			
Features	Good dimensional stability		
	High tensile strength		
	Homopolymer		
	Workability, good		
	Fast molding cycle		
	High liquidity		
	Definition, high		
	Compliance of Food Exposure		
	Excellent appearance		
Uses	Thin wall container		
	Cover		
	Shield		
	Household goods		
	Bracket tray		
Agency Ratings	FDA 21 CFR 177.1520		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.903	g/cm ³	ASTM D1505
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	35	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	83		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, Injection Molded)	31.7	MPa	ASTM D638
Tensile Elongation ² (Yield, Injection Molded)	12	%	ASTM D638
Flexural Modulus - 1% Secant ³ (Injection Molded)	1170	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, Injection Molded)	32	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, Injection Molded)	93.0	°C	ASTM D648
Vicat Softening Temperature	152	°C	ASTM D1525
Additional Information			
All specimens were injection molded according to ASTM D2146 Type 1.			
Injection	Nominal Value	Unit	
Processing (Melt) Temp	102 - 113	°C	
Mold Temperature	-6.67 - 10.0	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	1.3 mm/min		

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