

Ravago Compounds PP-4290

Polypropylene Impact Copolymer

Ravago Manufacturing Americas, LLC

Message:

Key Features:

Polypropylene Impact Copolymer

UL Recognition listing - UL-94 V0

Designed for Injection molded applications

Good balance of processability and physical properties

General Information			
Features	Impact copolymer		
	Workability, good		
	Flame retardancy		
UL File Number	E141240		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.01	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	17	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 23°C)	23.1	MPa	ASTM D638
Tensile Elongation (Yield, 23°C)	10	%	ASTM D638
Flexural Modulus - Tangent ¹	1100	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	80	J/m	ASTM D256
Dart Drop Impact ² (23°C)	> 36.2	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Annealed)	104	°C	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.57 mm)	V-0		UL 94
Oxygen Index	29	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature	71.1 - 93.3	°C	
Drying Time	0.0 - 8.0	hr	
Rear Temperature	177 - 216	°C	
Middle Temperature	177 - 216	°C	
Front Temperature	171 - 216	°C	
Nozzle Temperature	182 - 216	°C	

Processing (Melt) Temp	< 260	°C
Mold Temperature	26.7 - 60.0	°C
Back Pressure	0.00 - 0.689	MPa
Screw Speed	50 - 150	rpm

Injection instructions

Hot Runner: 380 to 450°F

NOTE

- | | |
|----|-------------|
| 1. | 1.3 mm/min |
| 2. | Geometry GB |

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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