

RAMOFIN PPC501

Polypropylene Copolymer
Polyram Ram-On Industries

Message:
FLAME RETARDANT POLYPROPYLENE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Flame retardancy		
Features	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	12	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	1.0 - 2.0	%	ASTM D955
--	1.0 - 2.0	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2510	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	20.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	50	%	ASTM D638, ISO 527-2
Flexural Modulus	2150	MPa	ASTM D790, ISO 178
Flexural Strength	30.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	40	J/m	ASTM D256
23°C	4.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	165	°C	ISO 11357-3, ASTM D3417
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.60 mm	V-0		UL 94
3.00 mm	V-0		UL 94
Glow Wire Flammability Index	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature	750	°C	IEC 60695-2-13
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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