

RAMOFIN PPC500

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	1.01	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	25	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	1.4 - 2.0	%	ASTM D955
--	1.4 - 2.0	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1100	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	22.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	680	%	ASTM D638, ISO 527-2
Flexural Modulus	950	MPa	ASTM D790, ISO 178
Flexural Strength	25.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	80	J/m	ASTM D256
23°C	7.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	68.0	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	50.0	°C	ASTM D648, ISO 75-2/A
Melting Temperature	165	°C	ISO 11357-3, ASTM D3417
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.800 mm	V-0		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	675	°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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