

RAMOFIN PPC350M6

Polypropylene Copolymer
Polyram Ram-On Industries

Message:
30% MINERAL FILLED, HEAT STABILIZED POLYPROPYLENE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Mineral filler, 30% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.80	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	9.0	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	1.1	%	ASTM D955
--	1.1	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3000	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	20.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	25	%	ASTM D638, ISO 527-2
Flexural Modulus	2300	MPa	ASTM D790, ISO 178
Flexural Strength	40.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	55	J/m	ASTM D256
23°C	5.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	120	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	65.0	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	120	°C	
Maximum Continuous Use Temperature	110	°C	
Vicat Softening Temperature	80.0	°C	ASTM D1525, ISO 306
Melting Temperature	165	°C	ISO 11357-3, ASTM D3418
Flammability	Nominal Value	Test Method	
Flame Rating (3.00 mm)	HB	UL 94	
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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