

RAMOFIN PPC342M6

Polypropylene Copolymer

Polyram Ram-On Industries

Message:

30% MINERAL FILLED, HEAT RESISRANT POLYPROPYLENE FOR INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Mineral filler, 30% filler by weight		
Features	Heat resistance, high		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	6.5	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.60 - 1.0	%	ASTM D955
--	0.60 - 1.0	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4200	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	30.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	35	%	ASTM D638, ISO 527-2
Flexural Modulus	2800	MPa	ASTM D790, ISO 178
Flexural Strength	45.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	45	J/m	ASTM D256
23°C	4.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	105	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	59.0	°C	ASTM D648, ISO 75-2/A
Maximum operating temperature-Short Peaks Operation	120	°C	
Maximum Continuous Use Temperature	110	°C	
Vicat Softening Temperature	140	°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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