

RAMOFIN PPH106

Polypropylene Homopolymer
Polyram Ram-On Industries

Message:
POLYPROPYLENE WITH MOLIBDENIUM FOR INJECTION MOULDING APPLICATIONS.

General Information			
Additive	Molybdenum disulfide lubricant		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.930	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			
230°C/2.16 kg	6.0	g/10 min	ASTM D1238
230°C/2.16 kg	12	g/10 min	ISO 1133
Molding Shrinkage			
Flow	1.4 - 1.6	%	ASTM D955
--	1.4 - 1.6	%	ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	95		ASTM D785
R scale	95		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield	35.0	MPa	ASTM D638
Yield	40.0	MPa	ISO 527-2
Tensile Elongation (Break)	80	%	ASTM D638, ISO 527-2
Flexural Modulus	1500	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	50	J/m	ASTM D256
23°C	2.5	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	68.0	°C	ASTM D648, ISO 75-2/A
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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