

RAMOFIN PPC372B73

Polypropylene Copolymer
Polyram Ram-On Industries

Message:
73% MINERAL FILLED POLYPROPYLENE FOR HEAVY DENSITY INJECTION MOULDING APPLICATIONS.

General Information			
Filler / Reinforcement	Mineral,73% Filler by Weight		
Features	High Density		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	2.10	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	20	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	0.80 to 1.2	%	ISO 2577
--	0.80 to 1.2	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1700	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	10.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	> 10	%	ASTM D638, ISO 527-2
Flexural Modulus	2200	MPa	ASTM D790, ISO 178
Flexural Strength	20.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	95	J/m	ASTM D256
23°C	10	kJ/m ²	ISO 180
Injection	Nominal Value	Unit	
Rear Temperature	190 to 220	°C	
Middle Temperature	200 to 225	°C	
Front Temperature	205 to 230	°C	
Mold Temperature	30.0 to 65.0	°C	
Injection Pressure	70.0 to 105	MPa	
Holding Pressure	35.0 to 70.0	MPa	
Back Pressure	0.350 to 0.700	MPa	
Screw Speed	60 to 90	rpm	

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