

POLYFLAM® RIPP 4000 OSD K3014

Polypropylene Copolymer

A. Schulman Europe

Message:

Flame-retardant PP-Copolymer, halogenfree, optimized smoke density

General Information			
Features	Low smoke		
	Copolymer		
	Halogen-free		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.07	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (230°C/2.16 kg)	4.00	cm ³ /10min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2100	MPa	ISO 527-2/1A/1
Tensile Stress			ISO 527-2/1A/50
Yield	20.0	MPa	ISO 527-2/1A/50
Fracture	15.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	3.3	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	50	%	ISO 527-2/1A/50
Flexural Modulus ¹	2100	MPa	ISO 178
Flexural Stress ²			ISO 178
3.5% strain	35.0	MPa	ISO 178
4.0% strain	35.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	20	kJ/m ²	ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	60.0	°C	ISO 75-2/Af
Vicat Softening Temperature	74.0	°C	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flammability Classification			IEC 60695-11-10, -20
0.800 mm	V-0		IEC 60695-11-10, -20
1.60 mm	V-0		IEC 60695-11-10, -20
3.20 mm	V-0		IEC 60695-11-10, -20

Glow Wire Flammability Index			IEC 60695-2-12
0.750 mm	960	°C	IEC 60695-2-12
1.50 mm	960	°C	IEC 60695-2-12
3.00 mm	960	°C	IEC 60695-2-12

Additional Information

- 1.)
Not for use in food contact applications2.)
Not for use in medical or pharmaceutical applications

Injection	Nominal Value	Unit
Drying Temperature	70.0 - 80.0	°C
Drying Time	2.0 - 4.0	hr
Rear Temperature	180	°C
Middle Temperature	200	°C
Front Temperature	210	°C
Nozzle Temperature	220	°C
Processing (Melt) Temp	180 - 220	°C
Mold Temperature	40.0 - 80.0	°C
Injection Pressure	80.0 - 120	MPa
Injection Rate	Slow-Moderate	
Holding Pressure	40.0 - 90.0	MPa
Back Pressure	5.00 - 10.0	MPa
Cushion	< 5.00	mm
Screw Speed		mm/sec

NOTE

1. 2.0 mm/min
2. 2.0 mm/min

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