

# Ravago Compounds PP-6224

Polypropylene Impact Copolymer

Ravago Manufacturing Americas, LLC

Message:

PP-6224 is a 40% Calcium Carbonate reinforced impact copolymer polypropylene. This product is specifically designed for injection-molded applications. PP-6224 offers a good combination of processability and physical properties.

| General Information                       |  |          |             |
|---|--|----------|-------------|
| Filler / Reinforcement                    | Calcium carbonate filler, 40% filler by weight |          |             |
| Features                                  | Impact copolymer                               |          |             |
|   | Workability, good                              |          |             |
| Forms                                     | Particle                                       |          |             |
| Processing Method                         | Injection molding                              |          |             |
| Physical                                  | Nominal Value                                  | Unit     | Test Method |
| Specific Gravity                          | 1.25   | g/cm³    | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 45   | g/10 min | ASTM D1238  |
| Mechanical                                | Nominal Value                                  | Unit     | Test Method |
| Tensile Strength (Yield, 23°C)            | 13.8   | MPa      | ASTM D638   |
| Flexural Modulus - 1% Secant (23°C)       | 1930   | MPa      | ASTM D790   |
| Impact                                    | Nominal Value                                  | Unit     | Test Method |
| Notched Izod Impact (23°C)                | 64   | J/m      | ASTM D256   |
| Injection                                 | Nominal Value                                  | Unit     |             |
| Drying Temperature                        | 71.1 - 93.3                                    | °C       |             |
| Drying Time                               | 0.0 - 8.0                                      | hr       |             |
| Rear Temperature                          | 193 - 238                                      | °C       |             |
| Middle Temperature                        | 193 - 238                                      | °C       |             |
| Front Temperature                         | 193 - 238                                      | °C       |             |
| Nozzle Temperature                        | 193 - 238                                      | °C       |             |
| Mold Temperature                          | 26.7 - 60.0                                    | °C       |             |
| Back Pressure                             | 0.00 - 0.689                                   | MPa      |             |
| Screw Speed                               | 50 - 150                                       | rpm      |             |
| Injection instructions                    |  |          |             |

Hot Runner Temperature (if applicable): 420 to 450°F

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