

Ravago Compounds PP-6152

Polypropylene Impact Copolymer

Ravago Manufacturing Americas, LLC

Message:

Key Features:

Polypropylene Impact Copolymer

20% Calcium Carbonate

Formulated for outstanding resistance to sunlight and weathering

Designed for Injection molded applications

Good balance of processability and physical properties

General Information			
Filler / Reinforcement	Calcium carbonate filler, 22% filler by weight		
Features	Impact copolymer		
	Good UV resistance		
	Workability, good		
	Good weather resistance		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.05	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	27	g/10 min	ASTM D1238
Ash Content	22	%	ASTM D2584
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (23°C)	19.3	MPa	ASTM D638
Tensile Elongation (Yield, 23°C)	10	%	ASTM D638
Flexural Modulus - Tangent ¹ (23°C)	1380	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Dart Drop Impact ² (23°C)	11.3	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	101	°C	ASTM D648
1.8 MPa, not annealed	57.2	°C	ASTM D648
CLTE - Flow	2.3E-5	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	71.1 - 93.3	°C	
Drying Time	0.0 - 8.0	hr	
Rear Temperature	177 - 216	°C	
Middle Temperature	177 - 216	°C	

Front Temperature	171 - 216	°C
Nozzle Temperature	182 - 216	°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): 380 to 450°F

NOTE

1.	0.050 mm/min
2.	Geometry GC

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