

RAMOFIN PPH343T4BK10-1

Polypropylene Homopolymer

Polyram Ram-On Industries

Message:

20% MINERAL FILLED, HEAT RESISTANT POLYPROPYLENE FOR INJECTION MOLDING APPLICATIONS.

General Information			
Filler / Reinforcement	Mineral filler, 20% filler by weight		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.08	g/cm ³	ASTM D792
--	1.06	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	10	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow	1.1 - 1.5	%	ASTM D955
--	1.1 - 1.5	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	30.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	25	%	ASTM D638, ISO 527-2
Flexural Modulus	2200	MPa	ASTM D790, ISO 178
Flexural Strength	55.0	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	2.8	kJ/m ²	ISO 179
Notched Izod Impact (23°C)	30	J/m	ASTM D256
Unnotched Izod Impact Strength (23°C)	40	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	154	°C	ASTM D648, ISO 75-2/B
1.8 MPa, not annealed	82.0	°C	ASTM D648, ISO 75-2/A
Melting Temperature	168	°C	ISO 11357-3, ASTM D3418
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		UL 94
Flammability	22	mm/min	FMVSS 302
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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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