

# RAMOFIN PPC300S4BK10

Polypropylene Copolymer

Polyram Ram-On Industries

Message:

20% GLASS BEADS REINFORCED POLYPROPYLENE COPOLYMER FOR INJECTION MOULDING APPLICATIONS.

| General Information                       |                                   |                   |                      |
|-------------------------------------------|-----------------------------------|-------------------|----------------------|
| Filler / Reinforcement                    | Glass beads, 20% filler by weight |                   |                      |
| Processing Method                         | Injection molding                 |                   |                      |
| Physical                                  | Nominal Value                     | Unit              | Test Method          |
| Specific Gravity                          | 0.990                             | g/cm <sup>3</sup> | ASTM D792, ISO 1183  |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 11                                | g/10 min          | ASTM D1238, ISO 1133 |
| Mechanical                                | Nominal Value                     | Unit              | Test Method          |
| Tensile Modulus                           | 1320                              | MPa               | ASTM D638, ISO 527-2 |
| Tensile Strength (Yield)                  | 18.0                              | MPa               | ASTM D638, ISO 527-2 |
| Tensile Elongation (Break)                | 100                               | %                 | ASTM D638, ISO 527-2 |
| Flexural Modulus                          | 1030                              | MPa               | ASTM D790, ISO 178   |
| Flexural Strength                         | 25.0                              | MPa               | ASTM D790, ISO 178   |
| Impact                                    | Nominal Value                     | Unit              | Test Method          |
| Notched Izod Impact                       |                                   |                   |                      |
| 23°C                                      | 65                                | J/m               | ASTM D256            |
| 23°C                                      | 6.0                               | kJ/m <sup>2</sup> | ISO 180              |
| Thermal                                   | Nominal Value                     | Unit              | Test Method          |
| Melting Temperature                       |                                   |                   |                      |
| --                                        | 167                               | °C                | ISO 11357-3          |
| --                                        | 168                               | °C                | ASTM D3418           |
| Flammability                              | Nominal Value                     | Test Method       |                      |
| Flame Rating (3.00 mm)                    | HB                                | UL 94             |                      |
| 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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