



Ravago Compounds PP-6062

Ravago Manufacturing Americas - Polypropylene Impact Copolymer

Tuesday, November 5, 2019

General Information

Product Description

Key Features:

- Polypropylene Impact Copolymer
- 20% Calcium Carbonate filled
- General Purpose
- Designed for Injection molded applications
- Good balance of processability and physical properties

General

| | |
|------------------------|---|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Filler / Reinforcement | • Calcium Carbonate, 20% Filler by Weight |
| Features | • Food Contact Acceptable • Good Processability • General Purpose • Impact Copolymer |
| Uses | • General Purpose |
| Agency Ratings | • FDA 21 CFR 177.1520 |
| Forms | • Pellets |
| Processing Method | • Injection Molding |

ASTM & ISO Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|-------------------------------------|---------------|----------|-------------|
| Density / Specific Gravity | 1.05 | | ASTM D792 |
| Melt Mass-Flow Rate (230°C/2.16 kg) | 20 | g/10 min | ASTM D1238 |
| Molding Shrinkage - Flow (73°F) | 0.012 | in/in | ASTM D955 |
| Mechanical | Nominal Value | Unit | Test Method |
| Flexural Modulus - Tangent (73°F) | 250000 | psi | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (73°F) | 2.0 | ft-lb/in | ASTM D256 |

Processing Information

| Injection | Nominal Value | Unit |
|--------------------|---------------|------|
| Drying Temperature | 160 to 200 | °F |
| Drying Time | 0.0 to 8.0 | hr |
| Rear Temperature | 380 to 460 | °F |
| Middle Temperature | 380 to 460 | °F |
| Front Temperature | 380 to 460 | °F |
| Nozzle Temperature | 380 to 460 | °F |
| Mold Temperature | 80 to 140 | °F |
| Back Pressure | 0.00 to 100 | psi |
| Screw Speed | 50 to 150 | rpm |

Injection Notes

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

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Notes

¹ Typical properties: these are not to be construed as specifications.