

**RamOfin PPH346T4BK11**

PP-T20

Polyram

| Processing/Physical Characteristics  | Value | Unit    | Test Standard   |
|--------------------------------------|-------|---------|-----------------|
| <b>ISO Data</b>                      |       |         |                 |
| Melt flow index, MFI                 | 12    | g/10min | ISO 1133        |
| Temperature                          | 230   | °C      | -               |
| Load                                 | 2.16  | kg      | -               |
| <b>Other Standards<sup>[S]</sup></b> |       |         |                 |
| Molding shrinkage, parallel          | 0.9   | %       | Producer Method |
| Molding shrinkage, normal            | 1.1   | %       | Producer Method |

S: These properties are reported by the producer according standards that are different to our defaults.

| Mechanical properties                 | Value | Unit              | Test Standard |
|---------------------------------------|-------|-------------------|---------------|
| <b>ISO Data</b>                       |       |                   |               |
| Tensile Modulus                       | 2680  | MPa               | ISO 527       |
| Tensile Strength                      | 30    | MPa               | ISO 527       |
| Yield strain                          | 4.1   | %                 | ISO 527       |
| Strain at break                       | 13.4  | %                 | ISO 527       |
| Flexural modulus, 23°C                | 2380  | MPa               | ISO 178       |
| Flexural strength                     | 53    | MPa               | ISO 178       |
| Charpy impact strength, +23°C         | 39    | kJ/m <sup>2</sup> | ISO 179/1eU   |
| Charpy impact strength, -30°C         | 19.5  | kJ/m <sup>2</sup> | ISO 179/1eU   |
| Charpy notched impact strength, +23°C | 2.8   | kJ/m <sup>2</sup> | ISO 179/1eA   |
| Charpy notched impact strength, -30°C | 1.4   | kJ/m <sup>2</sup> | ISO 179/1eA   |
| Izod notched impact strength, +23°C   | 3     | kJ/m <sup>2</sup> | ISO 180/1A    |
| Izod notched impact strength          | 2.2   | kJ/m <sup>2</sup> | ISO 180/1A    |
| Temperature                           | -30   | °C                | -             |

| Thermal properties                  | Value | Unit   | Test Standard        |
|-------------------------------------|-------|--------|----------------------|
| <b>ISO Data</b>                     |       |        |                      |
| Melting temperature, 10°C/min       | 163   | °C     | ISO 11357-1/-3       |
| Burning behav. at thickness h       | HB    | class  | IEC 60695-11-10      |
| Thickness tested                    | 3.0   | mm     | -                    |
| Burning rate, FMVSS, Thickness 1 mm | 100   | mm/min | ISO 3795 (FMVSS 302) |

| Other properties | Value | Unit              | Test Standard |
|------------------|-------|-------------------|---------------|
| Density          | 1070  | kg/m <sup>3</sup> | ISO 1183      |

| Processing Recommendation Injection Molding | Value     | Unit | Test Standard |
|---|-----------|------|---------------|
| Pre-drying - Temperature                    | 80        | °C   | -             |
| Pre-drying - Time                           | 2 - 4     | h    | -             |
| Processing humidity                         | ≤0.1      | %    | -             |
| Mold temperature                            | 30 - 70   | °C   | -             |
| Feed temperature                            | 60 - 70   | °C   | -             |
| Zone 1                                      | 200 - 230 | °C   | -             |
| Zone 2                                      | 200 - 230 | °C   | -             |
| Zone 3                                      | 200 - 250 | °C   | -             |

**Characteristics****Processing**

Injection Molding

**Features**

Homopolymer

**Delivery form**

Black

**Certifications**

RoHS compliant

**Special Characteristics**

U.V. stabilized or stable to weather, Heat stabilized or stable to heat

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America, Near East/Africa