

TDS Polyflam[™] RPP 3225 GW Polypropylene Homopolymer

| 25% glass fibre reinforced flam | ne-retardant PP-Homopolymer; without I | PBDE | |
|---------------------------------|--|-------------------------------|-------------|
| | | | |
| General | | | |
| Material Status | Experimental: Active | | |
| Availability | Africa & Middle East Latin America | Asia Pacific North America | Europe |
| Filler / Reinforcement | Glass Fiber, 25% Filler by Weight | | |
| Features | Copper Contact Stabilized | High Strength | Homopolymer |

Flame Retardant Injection Molding

| Physical | Nominal Value (English) | Nominal Value (SI) | Test Method |
|--|-----------------------------|-----------------------------|-------------|
| Density | 1.39 g/cm ³ | 1.39 g/cm ³ | ISO 1183/A |
| Melt Volume-Flow Rate (MVR) (230°C/5.0 kg) | 1.22 in ³ /10min | 1.22 cm ³ /10min | ISO 1133 |

| Mechanical | Nominal Value (English) | Nominal Value (SI) | Test Method |
|------------------------|-------------------------|--------------------|----------------|
| Tensile Modulus | 1.11E+6 psi | 7650 MPa | ISO 527-2/1A/1 |
| Tensile Stress (Break) | 10000 psi | 69.0 MPa | ISO 527-2/1A/5 |
| Tensile Strain (Break) | 2.3 % | 2.3 % | ISO 527-2/1A/5 |

| Impact | Nominal Value (English) | Nominal Value (SI) | Test Method |
|--|-------------------------|----------------------|-------------|
| Charpy Notched Impact Strength (73°F (23°C)) | 4.8 ft·lb/in² | 10 kJ/m ² | ISO 179/1eA |
| Charpy Unnotched Impact Strength 73°F (23°C) | 17 ft·lb/in² | 35 kJ/m² | ISO 179/1eU |

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Product

Processing Method

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| Thermal | Nominal Value (English) | Nominal Value (SI) | Test Method |
|--------------------------------|-------------------------|--------------------|--------------------------------|
| Heat Deflection Temperature | | | |
| 264 psi (1.8 MPa), Unannealed | 275°F | 135°C | ISO 75-2/A |
| | | | |
| Electrical | Nominal Value (English) | Nominal Value (SI) | Test Method |
| Comparative Tracking Index | 600 V | 600 V | IEC 60112 |
| | | | |
| Flammability | Nominal Value (English) | Nominal Value (SI) | Test Method |
| Flame Rating | | | UL 94 IEC 60695-11- 10, -20 |
| 0.06 in (1.6 mm) | V-0 | V-0 | |
| 0.13 in (3.2 mm) | V-0 | V-0 | |
| Glow Wire Flammability Index | | | IEC 60695-2-12 |
| 0.06 in (1.5 mm) | 1760°F | 960°C | |
| 0.12 in (3.0 mm) | 1760°F | 960°C | |
| Glow Wire Ignition Temperature | | | IEC 60695-2-13 |
| 0.06 in (1.5 mm) | 1560°F | 850°C | |
| 0.12 in (3 mm) | 1560°F | 850°C | |

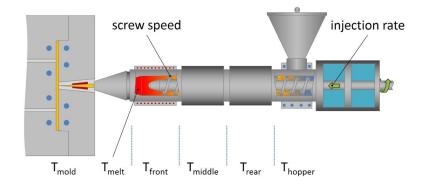
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TDS Polyflam[™] RIPP 510 D Polypropylene Copolymer



| Injection | Nominal Value (English) | Nominal Value (SI) |
|------------------------|-------------------------|--------------------|
| Drying Temperature | 158 to 176°F | 70 to 80°C |
| Drying Time | 2.0 to 4.0 hr | 2.0 to 4.0 hr |
| Rear Temperature | 356°F | 180°C |
| Middle Temperature | 392°F | 200°C |
| Front Temperature | 410°F | 210°C |
| Nozzle Temperature | 428°F | 220°C |
| Processing (Melt) Temp | 356 to 428°F | 180 to 220°C |
| Mold Temperature | 104 to 176°F | 40 to 80°C |
| Injection Pressure | 11600 to 17400 psi | 80.0 to 120 MPa |
| Injection Rate | Slow-Moderate | Slow-Moderate |
| Holding Pressure | 5800 to 13100 psi | 40.0 to 90.0 MPa |
| Back Pressure | 725 to 1450 psi | 5.00 to 10.0 MPa |
| Cushion | < 0.197 in | < 5.00 mm |
| Screw Speed | < 709 in/min | < 18 m/mi |
| | | |

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