



Ravago Compounds PP-6224

Ravago Manufacturing Americas - Polypropylene Impact Copolymer

Tuesday, November 5, 2019

General Information

Product Description

PP-6224 is a 40% Calcium Carbonate reinforced impact copolymer polypropylene. This product is specifically designed for injection-molded applications. PP-6224 offers a good combination of processability and physical properties.

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Calcium Carbonate, 40% Filler by Weight
Features	• Good Processability • Impact Copolymer
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.25		ASTM D792
Melt Mass-Flow Rate (230°C/2.16 kg)	45	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 73°F)	2000	psi	ASTM D638
Flexural Modulus - 1% Secant (73°F)	280000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.2	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 Temperature (if applicable): 420 to 450°F

Notes

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