Technical Data Sheet

Polyflam RIPP 3625 CS1

Polypropylene Copolymer
LyondellBasell Industries
Engineering Plastics

Product Description			
25% mineral filled flame-retardant PP-Copolymer; without PBDE			
General			
Filler / Reinforcement	• Mineral, 25% Filler by Weight		
Features	• Copolymer	• Copper Contact Stabilized	• Flame Retardant
UL File Number	• E86615		
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• PP/PE-MD25 FR(17+61)		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.39 g/cm³	1.39 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (230°c/2.16 Kg)	10 cm³/10min	10 cm³/10min	ISO 1133
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	348000 psi	2400 MPa	ISO 527-1/1A/1
Tensile Stress (Yield)	2470 psi	17.0 MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	2.0 %	2.0 %	ISO 527-2/1A/50
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength (73°f (23°c))	3.6 ft·lb/in²	7.5 kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
73°f (23°c)	38 ft·lb/in²	80 kJ/m²	
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			
66 Psi (0.45 Mpa), Unannealed	192 °F	89.0 °C	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	129 °F	54.0 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	145 °F	63.0 °C	ISO 306/B50
--	279 °F	137 °C	ISO 306/A50
Ball Pressure Test (221°f (105°c))	Pass	Pass	IEC 60695-10-2
RTI Elec			UL 746B
0.06 In (1.5 Mm)	149 °F	65.0 °C	
0.12 In (3.0 Mm)	149 °F	65.0 °C	
RTI Imp			UL 746B
0.06 In (1.5 Mm)	149 °F	65.0 °C	
0.12 In (3.0 Mm)	149 °F	65.0 °C	
RTI Str			UL 746B
0.06 In (1.5 Mm)	149 °F	65.0 °C	
0.12 In (3.0 Mm)	149 °F	65.0 °C	
Electrical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1
Electric Strength [1]			IEC 60243-1
73°f (23°c), 0.0394 In (1.00 Mm), In Oil	1000 V/mil	40 kV/mm	
Comparative Tracking Index	600 V	600 V	IEC 60112

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Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 In (2.00 Mm), Self-extinguishing	0.0 in/min	0.0 mm/min	FMVSS 302
0.0787 In (2.00 Mm), Self-extinguishing	0.0 in/min	0.0 mm/min	ISO 3795
Flame Rating			UL 94
0.06 In (1.5 Mm)	V-0	V-0	IEC 60695-11-10, -20
0.12 In (3.0 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)	1380 °F	750 °C	
0.12 In (3.0 Mm)	1380 °F	750 °C	
Oxygen Index	28 %	28 %	ISO 4589-2

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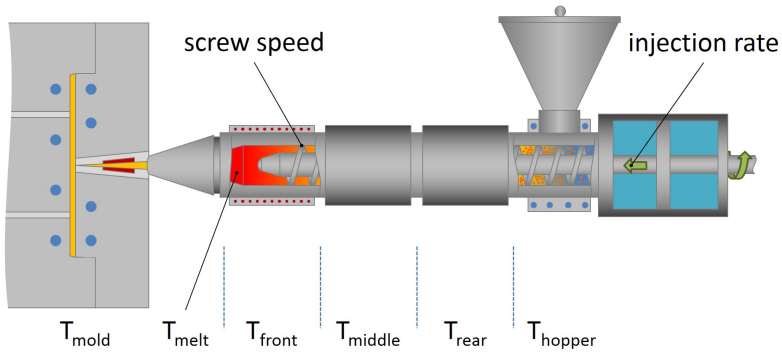

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	158 to 176 °F	70 to 80 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Processing (Melt) Temp	392 to 428 °F	200 to 220 °C
Mold Temperature	104 to 176 °F	40 to 80 °C

Injection Notes

Mould surface contacting melt should
be of non-corrosive steel (content of chrome > 12%)