

Technical Data Sheet
POLYFLAM® RPP 3225
GW



Polypropylene Homopolymer
 Engineering Plastics

Product Description

25% glass fibre reinforced flame-retardant PP-Homopolymer; without PBDE

General

Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Features	• Copper Contact Stabilized • High Strength • Flame Retardant • Homopolymer
Processing Method	• 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)	20 cm ³ /10min	20 cm ³ /10min	ISO 1133
Molding Shrinkage	0.20 to 1.0 %	0.20 to 1.0 %	ISO 294-4

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/in ²	10 kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength 73°F (23°C)	17 ft·lb/in ²	35 kJ/m ²	ISO 179/1eU

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
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
Comparative Tracking Index	600 V	600 V	IEC 60112

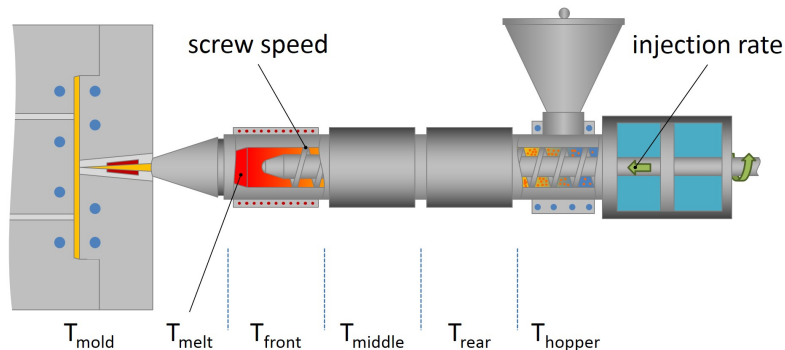
Flammability

	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	ISO 3795
0.0787 in (2.00 mm), Self-Extinguishing	0.0 in/min	0.0 mm/min	FMVSS 302
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)	1560 °F	850 °C	
0.12 in (3.0 mm)	1560 °F	850 °C	



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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
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	392 to 428 °F	200 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/min

Notes

These are typical property values not to be construed as specification limits.