

RMPP394 GREY 387

RMPP394 Grey 387 is a Polypropylene (PP) Compound specifically developed for rotational molding, available as powder, mini pellets or pellets.

It has excellent moldability and its enhanced properties allow it to be used in demanding applications.

FEATURES:

- **An excellent balance of high stiffness & high impact**
- **Good Temperature Resistance (dry & wet)**
- **High FNCT / ESCR and good chemical resistance**
- **Rated > UV12**
- **Excellent long term creep performance**
- **Improved surface hardness and scratch resistance**

PROCESSING GUIDELINES:

- Oven temperature ~ 570⁰F to achieve mold surface temperature > 475⁰F
- PIAT 435⁰F – 455⁰F
- Rotation similar to LMDPE
- Smartvents will increase pressure inside mold and assist with reducing warpage and minimising pinholes
- PP can stress whiten so minimize impact when demolding

OBSERVATIONS:

- Lubricity of PP means little or no mold release needed
- Lower shrinkage than PE
- Less warpage for large surfaces due to stiffness and crystallization
- Complete crystallization may take up to 72 hours to obtain optimal physical properties
- Heat is critical for sintering PP, so minimize heat sinks in mold

Properties	Conditions	Units	Nominal Values	Testing Methods
Physical				
Melt Flow Rate	445 ⁰ F/2.16kgs	g/10 min	14 +/- 10%	ASTM D1238
Density ²		g/cm ³	0.900	ASTM D1505
Mechanical & Thermal				
Tensile stress ¹	At yield	PSI	3100	ASTM D638
Tensile strain ¹	At yield	%	5	ASTM D638
Tensile Modulus ¹		PSI	160,000	ASTM D638
Flexural Modulus ¹		PSI	170,000	ASTM D790
FNCT ² 2% Ige *	5MPa @ 122 ⁰ F	Hours	>300	ISO16770
	6MPa @ 122 ⁰ F	Hours	170	10x10mm x 1.6mm notch
ESCR ¹	2% Igepal *	Hours	> 1000	ASTM D1693
Shore D Hardness ¹			61	ASTM D2240
HDT ¹	66 PSI	Deg F	230	ISO 75-2 4mm Edgewise
HDT ¹	264 PSI	Deg F	138	
ARM Impact ¹	73 ⁰ F ¼" thick	Ft lb	80	ARM Method
Poisson Ratio			0.41	ASTM D638

Notes: ¹ Roto molded ² Compression molded * Or equivalent

Important: *The information contained in this document is of a general nature only and is intended to provide an indication of the potential properties and benefits of a particular polypropylene compound. The statistical and other information provided in this document has been determined in laboratory test conditions. Accordingly, there may be differences in performance in a production environment including having regard to the materials used. The information contained in this document should not be used as a sole basis for production or manufacturing purposes. Independent testing verification and independent professional advice should be obtained before making a decision to use any product or to apply any method or process. To the full extent permitted by law, PSD Rotoworx Pty Limited (ACN 166 016 244) ("PSD Rotoworx"), its related entities, their directors and employees: (i) give no warranty or representation that the information contained in this document is accurate and complete in every particular, and (ii) disclaim all liability for reliance on the information contained in this document.*