



# Polypropylene RF365MO

## Polypropylene Random Copolymer for Injection Moulding

### Description

**RF365MO** is a specially modified highly transparent random copolymer with high melt flow intended for injection moulding. **RF365MO** is specially formulated for high speed injection moulding and contains nucleating and antistatic additives allowing high demoulding temperature as well as reduced cooling time.

Products moulded from **RF365MO** have excellent transparency, very good organoleptical properties, good impact strength in ambient temperature, relatively high stiffness, and good demoulding and antistatic properties.

### Applications

**RF365MO** is designed for injection moulded products with long flow length, thin walls, and high transparency. Properties and additive package have been optimised for the production of injection moulded thin wall packaging.

Examples of products successfully injection moulded with **RF365MO** are:

- Thin wall cups, pails and their lids
- Sweet-boxes
- Closures
- Houseware containers
- Appliances requiring good transparency

### Physical Properties\*\*

		Typical Value*	Unit	Test Method
Density		905	kg/m <sup>3</sup>	ISO 1183
Melt Flow Rate	(230°C/2.16kg)	20	g/10 min	ISO 1133
Tensile Stress at Yield	(50 mm/min)	29	MPa	ISO 527-2
Tensile Strain at Yield	(50 mm/min)	11	%	ISO 527-2
Tensile Modulus	(1 mm/min)	1150	MPa	ISO 527-2
Charpy Impact Strength, notched	(+23°C)	5.5	kJ/m <sup>2</sup>	ISO 179/1eA
Hardness, Rockwell		82	R-scale	ISO 2039-2
Heat Deflection Temperature	(0.45 N/mm <sup>2</sup> )	80	°C	ISO 75-2

\* Data should not be used for specification work

\*\* Values determined on injection moulded specimens acc. to ISO 1873-2 (97), based on 7 days conditioning time.

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## Processing Guidelines

The grade can be processed on standard injection moulding machines. Following moulding parameters should be used as guidelines.

Melt temperature	210 – 260°C
Injection speed	High
Holding pressure	Minimum required to avoid sink marks (typical values are 200 - 500 bars)
Mould temperature	30 – 40°C
Shrinkage	1 - 2%, depending on wall thickness and moulding parameters.

## Storage and Handling

The product should be stored in dry conditions at temperatures below 50°C and protected from UV-light.

Improper storage can initiate degradation, which results in odour generation and colour changes and can have negative effects on the physical properties of the product.

## Safety

**RF365MO** is not classified as dangerous preparation.

Dust and fines from the product carry a risk of dust explosion. All equipment should be properly earthed. Inhalation of dust should be avoided as it may cause irritation of the respiratory system. Small amounts of fumes are generated during processing of the product. Proper ventilation is therefore required.

## Recycling

The product is suitable for recycling using modern methods of shredding and cleaning. In-house production waste should be kept clean to facilitate direct recycling.

A Safety Data Sheet is available on request. Please contact your Borealis representative for more details on various aspects of safety, recovery and disposal of the product.





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## Related Documents

The following related documents are available on request, and represent various aspects on the usability, safety, recovery and disposal of the product:

Recovery and disposal of Polyolefins  
Information on Emissions from Processing and Fires  
Safety Data Sheet, SDS  
Environmental Fact Sheet

Liability statements on:

- Compliance to Food Contact Regulations

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