



PRODUCT INFORMATION

## HAIPLEN EP10 G6 BA

Polypropylene copolymer 30% glass fibres reinforced chemically coupled, medium low flow.

**ISO short Form** ISO 1043: PP-GF30 Pellets

### Key Features

- Good impact - stiffness balance
- Designed for injection moulding applications
- Glass fibres reinforced
- Low flow

### Availability

- LP: laser printable
- L: UV stabilized
- H: heat stabilized
- D: detergent stabilized
- All colours

### Process

- INJECTION MOULDING

### Application

- Power tools
- Household
- General purpose applications
- Furniture
- Electronic
- Electrical
- Consumer
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
<b>ELECTRICAL</b>					
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	>600		
<b>PHYSICAL</b>					
Density (+23°C)	ISO 1183	g/cm <sup>3</sup>	1,12		
Filler content	ISO 3451	%	30	600°C - 1h	
Water Absorption (24h / +23°C)	ISO 62	%	0,10		
Mould Shrinkage (Parallel)	Internal method	%	0,2-0,4		



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Mould Shrinkage (Normal)	Internal method	%	0,7-0,9
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Melt Flow Rate (MFR)	ISO 1133	g/10 min	3	230°C - 2,16 kg
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**MECHANICAL**

Tensile Modulus	ISO 527-1,2	MPa	4900	Speed 1 mm/min
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Elongation at Break	ISO 527-1,2	%	5	Speed 50 mm/min
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Tensile Break Strength	ISO 527-1,2	MPa	85	Speed 50 mm/min
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Flexural Modulus	ISO 178	MPa	4700	Speed 1 mm/min
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Flexural Break Strength	ISO 178	MPa	105	Speed 1 mm/min
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IZOD Notched Impact	ASTM D256	J/m	170	+23°C
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**THERMAL**

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	147
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Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	120
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Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	127
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**FLAMMABILITY**

Flame Behaviour (1,6 mm)	UL94	Class	HB
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Oxygen index	ASTM D2863	%	20
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**INJECTION MOULDING**

**Value**

Drying Temperature (Desiccant Dryer)	80 - 100°C
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Drying Time (Desiccant Dryer)	2 - 4 hours
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Suggested Max Moisture	0,2%
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Melt Temperature	220 - 250°C
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Feed Temperature	50°C
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Rear Temperature	200°C
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Middle Temperature	220°C
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Front Temperature	230°C
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Nozzle Temperature	240°C
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Mould Temperature	40 - 60°C
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Injection Rate	50 - 150 mm/sec
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Injection Pressure	60 - 120 MPa
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Packing Pressure	30 - 80 MPa
Back Pressure	As low as possible (<0,3 MPa)
Screw Revolving Speed	25 - 50 rpm
Screw Revolving Speed	50 rpm @ Diameter 40 mm
Screw Revolving Speed	35 rpm @ Diameter 55 mm
Screw Revolving Speed	25 rpm @ Diameter 75 mm
Cushion	5 - 8 mm
Vent Depth	0,05 mm

**Notes** It is normally not necessary to dry HAIPLLEN compounds, however should there be surface moisture (condensate) on the moulding compound as a result of incorrect storage, drying process is required. HAIPLLEN must be stored indoors at a temperature below 40°C avoiding humidity and direct sunlight as well. HAIPLLEN can be processed on a standard injection moulding unit. A general purpose metering screw is recommended with a zone distribution of 40% feed, 40% transition and 20% metering. When the heating cylinder is completely purged of HAIPLLEN material the machine may be shut down.