



PRODUCT INFORMATION

## HAIPLLEN EP100 CM5

Polypropylene copolymer, high flow 25% mineral filled, good appearance behaviour, good scratch resistance, suitable for automotive interior applications.

**ISO short Form** ISO 1043: PP-MD25 Pellets

### Key Features

- Mineral filled

### Availability

- U: scratch resistant
- L: UV stabilized
- H: heat stabilized
- All colours

### Process

- INJECTION MOULDING

### Application

- General purpose applications
- Automotive interior

Property	Method	Unit	Value	Condition	State
<b>PHYSICAL</b>					
Density (+23°C)	ISO 1183	g/cm <sup>3</sup>	1,09		
Filler content	ISO 3451	%	25	600°C - 1h	
Mould Shrinkage (Parallel)	Internal method	%	1,1	+23°C - 3,2 mm	
Mould Shrinkage (Normal)	Internal method	%	1,1	+23°C - 3,2 mm	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	20	230°C - 2,16 kg	
<b>MECHANICAL</b>					
Flexural Modulus	ISO 178	MPa	1560	Speed 1 mm/min	
Flexural Max Strength	ISO 178	MPa	37	Speed 1 mm/min	
IZOD Notched Impact	ASTM D256	J/m	65	+23°C	
IZOD Notched Impact (+23°C)	ASTM D256	kJ/m <sup>2</sup>	7		
<b>THERMAL</b>					
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	86		



PRODUCT INFORMATION

**HAIPLN EP100 CM5**

<b>INJECTION MOULDING</b>	<b>Value</b>
Drying Temperature (Desiccant Dryer)	70 - 80°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Regrind	< 10%
Melt Temperature	190 - 230°C
Feed Temperature	150°C
Rear Temperature	175°C
Middle Temperature	200°C
Front Temperature	210°C
Nozzle Temperature	215°C
Mould Temperature	30 - 70°C
Injection Rate	Slow to Medium
Injection Pressure	50 - 120 Mpa
Packing Pressure	30 - 100 Mpa
Back Pressure	5 - 10 Mpa
Screw Revolving Speed	< 300 mm/sec
Cushion	< 5 mm
Vent Depth	0,05 mm

**Notes** It is normally not necessary to dry HAIPLN compounds, however should there be surface moisture (condensate) on the moulding compound as a result of incorrect storage, drying process is required. HAIPLN must be stored indoors at a temperature below 40°C / 105°F avoiding humidity and direct sunlight as well. HAIPLN 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 HAIPLN material the machine may be shut down. The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine or extruder size, part geometry and design.