PRODUCT INFORMATION

HAIPLEN EP100 MF6

Polypropylene copolymer high flow 33% mineral filled, high impact resistance and good mechanical properties.

ISO short ISO 1043: PP-MD30
Form Pellets

Key Features

- Good impact - stiffness balance
- Designed for injection moulding applications
- High flow
- Mineral filled
- Designed for automotive applications

Availability

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

Process

- INJECTION MOULDING

Application

- Automotive

Property	Method	Unit	Value	Condition	State
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,15		
Filler content	ISO 3451	%	33	600°C 1 h	
Water Absorption (24h / +23°C)	ISO 62	%	0,05		
Mould Shrinkage (Parallel)	Internal method	%	0,4 - 0,6		
Mould Shrinkage (Normal)	Internal method	%	0,7 - 0,9		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	22	230°C - 2,16 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	1900		
Tensile Yield Strength	ISO 527-1,2	MPa	27	Speed 50 mm/min	
Elongation at Break	ISO 527-1,2	%	25	Speed 50 mm/min	
Flexural Modulus	ISO 178	MPa	1800	Speed 1 mm/min	
Flexural Max Strength	ISO 178	MPa	30		
IZOD Notched Impact	ASTM D256	J/m	180	+23°C	

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IZOD Notched Impact	ASTM D256	J/m	110	0°C
IZOD Notched Impact	ASTM D256	J/m	80	-20°C

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	135	50°C / h
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	60	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	80	120°C / h
Continuous service temperature (20.000 h)	UL746 B	°C	80	

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	HB

INJECTION MOULDING	Value
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 HAIPLEN compounds, however should there be surface moisture (condensate) on the moulding compound as a result of incorrect storage, drying process is required. HAIPLEN must be stored indoors at a temperature below 40°C avoiding humidity and direct sunlight as well. HAIPLEN 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 HAIPLEN material the machine may be shut down.