



PRODUCT INFORMATION

**HAIPLEN EP150 C4**

Polypropylene copolymer calcium carbonate filled 20%.very high flow.

**ISO short Form** ISO 1043: PP-MD20 Pellets

**Key Features**

- Very high flow
- Mineral filled

**Availability**

- W: lubricated
- L: UV stabilized
- H: heat stabilized
- All colours

**Process**

- INJECTION MOULDING

**Application**

- General purpose applications

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>	1,06		
Water Absorption (24h / +23°C)	ISO 62	%	0,05		
Mould Shrinkage (Parallel)	Internal method	%	1,1		
Mould Shrinkage (Normal)	Internal method	%	1,1		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	27	230°C - 2160 g	
<b>MECHANICAL</b>					
Tensile Yield Strength	ISO 527-1,2	MPa	30		
Elongation at Break	ISO 527-1,2	%	25		
Flexural Modulus	ISO 178	MPa	1700		
IZOD Notched Impact	ASTM D256	J/m	40	+0°C	
IZOD Notched Impact	ASTM D256	J/m	30	-20°C	



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IZOD Notched Impact	ASTM D256	J/m	50	+23°C
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**THERMAL**

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	152
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	75
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	60
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K <sup>-1</sup>	6X10exp(-5)

**FLAMMABILITY**

Flame Behaviour (1,6 mm)	UL94	Class	HB
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**INJECTION MOULDING**

**Value**

Drying Temperature (Desiccant Dryer)	70 - 80°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Re grind	< 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.