



PRODUCT INFORMATION

HAIPLEN EP30 G4 BA

PP copolymer 20% glass fibres reinforced chemically coupled to the resin matrix.

ISO short Form ISO 1043: PP-GF20 Pellets

Key Features

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

Availability

- XMT: long-term service stability for contact with copper
- LP: laser printable
- L: UV stabilized
- HT: high resistance to heat
- H: heat stabilized
- FA: food approval
- D: detergent stabilized
- All colours

Process

- INJECTION MOULDING

Application

- Power tools
- Household
- Furniture
- Consumer
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,05		
Water Absorption (24h / +23°C)	ISO 62	%	0,10		
Mould Shrinkage (Parallel)	Internal method	%	0,40 - 0,55		
Mould Shrinkage (Normal)	Internal method	%	0,55 - 0,75		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	5	230°C - 2,16 kg	



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MECHANICAL

Elongation at Break	ISO 527-1,2	%	5	+23°C / Speed 50 mm/min
Tensile Break Strength	ISO 527-1,2	MPa	55	+23°C / Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	3500	+23°C / Speed 2 mm/min
IZOD Notched Impact	ASTM D256	J/m	120	

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	150	
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	100	
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	120	

FLAMMABILITY

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

INJECTION MOULDING

	Value
Drying Temperature (Desiccant Dryer)	80 - 100°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	0,2%
Suggested Max Re grind	< 10%
Melt Temperature	210 - 240°C
Feed Temperature	50°C
Rear Temperature	190°C
Middle Temperature	210°C
Front Temperature	220°C
Nozzle Temperature	230°C
Mould Temperature	40 - 60°C
Injection Rate	50 - 150 mm/sec
Injection Pressure	60 - 120 Mpa
Packing Pressure	30 - 80 Mpa
Back Pressure	As low as possible (<0,5 MPa)
Screw Revolving Speed	30 - 80 rpm
Cushion	5 - 8 mm



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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 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.