



PRODUCT INFORMATION

HAIPLEN EP30 G7 BA

Polypropylene copolymer 35% glass fibres reinforced chemically coupled, medium flow.

ISO short Form ISO 1043: PP-GF35 Pellets

Key Features

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

Availability

- LP: laser printable
- L: UV stabilized
- H: heat stabilized
- 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	1,17		
Filler content	ISO 3451	%	35	600°C - 1h	
Water Absorption (24h / +23°C)	ISO 62	%	0,02		
Mould Shrinkage (Parallel)	Internal method	%	0,2 - 0,4	23°C - spess. 3,2 mm	
Mould Shrinkage (Normal)	Internal method	%	0,5 - 0,9	23°C - spess. 3,2 mm	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	6	230°C - 2,16 kg	
MECHANICAL					
Elongation at Break	ISO 527-1,2	%	4,7	Speed 50 mm/min	



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Tensile Break Strength	ISO 527-1,2	MPa	80	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	5600	Speed 1 mm/min
Flexural Break Strength	ISO 178	MPa	100	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	120	+23°C

THERMAL

Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	125	50°C/h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	150	120°C/h

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	HB
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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
Vent Depth	0,05 mm



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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.