PRODUCT INFORMATION

HAIPLEN EP30 Z1 G6 BA

Polypropylene copolymer 30% glass fibres reinforced chemically coupled, medium flow very high impact strength also at low temperature.

ISO short	ISO 1043: PP-GF30
Form	Pellets

Key Features

- Good impact - stiffness balance
- Improved impact resistance
- 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	1,12		
Water Absorption (24h / +23°C)	ISO 62	%	0,10		
Mould Shrinkage (Parallel)	Internal method	%	0,35 - 0,50		
Mould Shrinkage (Normal)	Internal method	%	0,60 - 0,75		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	7	230°C - 2,16 kg	
MECHANICAL					
Elongation at Break	ISO 527-1,2	%	5	Speed 50 mm/min	
Tensile Break Strength	ISO 527-1,2	MPa	70	Speed 50 mm/min	

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Flexural Modulus	ISO 178	MPa	4000	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	> 150	+23°C
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	140	
FLAMMABILITY				
Flame Behaviour (1,6 mm)	UL94	Class	HB	
Oxigen 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 Regrind	< 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 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.