



PRODUCT INFORMATION

## HAIPLEN EP50 T6

Polypropylene copolymer medium flow 30% talcum filled.

**ISO short Form** ISO 1043: PP/PE-MD30  
Pellets

### Key Features

- Good impact - stiffness balance
- Designed for injection moulding applications
- Good flowability
- Mineral filled
- Good surface aspect

### Availability

- XO: low odour emission
- U: scratch resistant
- E = Low emission grade
- MT: 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

- 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>	1,14		
Filler content	ISO 3451	%	30	600°C - 1 h	
Water Absorption (24h / +23°C)	ISO 62	%	0,05		
Mould Shrinkage (Parallel)	Internal method	%	1,0		
Mould Shrinkage (Normal)	Internal method	%	1,0		



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Melt Flow Rate (MFR)	ISO 1133	g/10 min	10	230°C - 2,16 kg
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**MECHANICAL**

Tensile Modulus	ISO 527-1,2	MPa	3200	Speed 1 mm/min
Elongation at Yield	ISO 527-1,2	%	3	Speed 50 mm/min
Tensile Yield Strength	ISO 527-1,2	MPa	25	Speed 50 mm/min
Elongation at Break	ISO 527-1,2	%	15	Speed 50 mm/min
Tensile Break Strength	ISO 527-1,2	MPa	20	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	2800	Speed 2 mm/min
Flexural Max Strength	ISO 178	MPa	46	Speed 10 mm/min
IZOD Notched Impact (+23°C)	ASTM D256	J/m	50	

**THERMAL**

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	150	
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	85	
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	70	

**FLAMMABILITY**

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

	Value
Drying Temperature (Circulating Air Oven)	70 - 80°C
Drying Temperature (Desiccant Dryer)	70 - 80°C
Drying Time (Circulating Air Oven)	2 - 6 hours
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	< 0,2%
Suggested Max Regrind	< 15%
Melt Temperature	200 - 240°C
Feed Temperature	50°C
Rear Temperature	190°C
Middle Temperature	210°C
Front Temperature	230°C
Nozzle Temperature	220°C



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Mould Temperature	30 - 50°C
Injection Rate	50 - 150 mm/sec
Injection Pressure	60 - 120 Mpa
Packing Pressure	30 - 80 Mpa
Back Pressure	Medium (0,5 - 5 MPa)
Screw Revolving Speed	50 - 150 rpm
Cushion	5 - 8 mm
Vent Depth	0,05 mm

**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 / 105°F 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. 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.