PRODUCT INFORMATION

HAIPLEN EP50 T8

Polypropylene copolymer medium flow 40% talcum filled.

ISO short ISO 1043: PP-MD40
Form Pellets

Key Features

- Designed for injection moulding applications
- Mineral filled

Availability

- LP: laser printable
- L: UV stabilized
- H: heat stabilized
- D: detergent stabilized
- All colours

Process

- INJECTION MOULDING

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	>600		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,24		
Water Absorption (24h / +23°C)	ISO 62	%	0,05		
Mould Shrinkage (Parallel)	Internal method	%	0,9		
Mould Shrinkage (Normal)	Internal method	%	0,9		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	10	230°C - 2,16 kg	
MECHANICAL					
Tensile Yield Strength	ISO 527-1,2	MPa	35	Speed 50 mm/min	
Elongation at Break	ISO 527-1,2	%	25	Speed 50 mm/min	
Flexural Modulus	ISO 178	MPa	2800	Speed 1 mm/min	
IZOD Notched Impact	ASTM D256	J/m	30	-20°C	
IZOD Notched Impact	ASTM D256	J/m	50	+23°C	
IZOD Notched Impact	ASTM D256	J/m	40	+0°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	85
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	70
Deflection Temperature 0,45 MPa (HDT B)	ISO 75B	°C	135
Ball Pressure Test	IEC 60695-10-2	°C	125
Continuous service temperature (20.000 h)	UL746 B	°C	80
Continuous service temperature (short term)	UL746 B	°C	100
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	6X10exp(-5)

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	HB
Glow Wire Flammability Index-GWFI (1,6 mm)	IEC 60695-2-12	°C	650

INJECTION MOULDING	Value
Drying Temperature (Circulating Air Oven)	80 - 90°C
Drying Temperature (Desiccant Dryer)	80 - 90°C
Drying Time (Circulating Air Oven)	3 - 6 hours
Drying Time (Desiccant Dryer)	2 - 4 hours
Melt Temperature	190 - 220°C
Feed Temperature	160°C
Rear Temperature	180°C
Middle Temperature	190°C
Front Temperature	200°C
Nozzle Temperature	210°C
Mould Temperature	30 - 50°C
Injection Rate	Medium to Fast
Injection Pressure	70 - 120 Mpa
Packing Pressure	40 - 100 Mpa
Back Pressure	5 - 10 Mpa
Screw Revolving Speed	< 300 mm/sec
Cushion	< 5 mm

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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.