



PRODUCT INFORMATION

**HAIPLEN EP50 Z3**

Polypropylene copolymer medium flow, impact modified.

**ISO short Form** ISO 1043: PP-EPDM Pellets

**Key Features**

- Good impact - stiffness balance
- Designed for injection moulding applications
- Good flowability
- Designed for automotive applications
- 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
- D: detergent stabilized
- All colours

**Process**

- INJECTION MOULDING

**Application**

- General purpose applications
- Furniture
- Electronic
- Building
- Automotive

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>	0,90		
Mould Shrinkage (Parallel)	Internal method	%	1,5		



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Mould Shrinkage (Normal)	Internal method	%	1,5	
Melt Flow Rate (MFR)	ISO 1133	g/10 min	10	230°C - 2,16 kg

**MECHANICAL**

Hardness SHORE D	ISO 868	-	63	
Tensile Yield Strength	ISO 527-1,2	MPa	20	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	850	Speed 2 mm/min
IZOD Notched Impact (+23°C)	ASTM D256	J/m	500	
IZOD Notched Impact (-25°C)	ASTM D256	J/m	80	

**THERMAL**

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	150	
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	55	
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	50	

**FLAMMABILITY**

Flame Behaviour (1,6 mm)	UL94	Class	HB	
Burning Rate (US-FMVSS 302)	ISO 3795	mm/min	< 100	Thickness 1 mm

**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
Mould Temperature	30 - 50°C



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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 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.