PRODUCT INFORMATION

HAIPLEN H10 T4

Polypropylene homopolymer 20% talcum filled, low flow, high stiffness.

ISO short ISO 1043: PP-MD20
Form Pellets

Key Features

- Suitable for injection moulding and extrusion applications

Availability

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

Process

- INJECTION MOULDING
- EXTRUSION

Application

- General purpose applications
- Furniture
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,05		
Water Absorption (24h / +23°C)	ISO 62	%	0,05		
Mould Shrinkage (Parallel)	Internal method	%	1,1		
Mould Shrinkage (Normal)	Internal method	%	1,1		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	3	230°C - 2,16 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	2700	Speed 1 mm/min	
Tensile Yield Strength	ISO 527-1,2	MPa	34	Speed 50 mm/min	
Elongation at Break	ISO 527-1,2	%	20	Speed 50 mm/min	

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Flexural Modulus	ISO 178	MPa	2600	Speed 1 mm/min
Flexural Max Strength	ISO 178	MPa	50	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	30	+23°C

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	155	
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	90	
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	75	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	6X10exp(-5)	

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	HB	
Burning Rate (US-FMVSS 302)	ISO 3795	mm/min	<100	Thickness 2 mm

EXTRUSION	Value
Drying Time (Circulating Air Oven)	80 - 90°C
Drying Temperature (Circulating Air Oven)	3 h
Melt Temperature	190 - 210°C
Feed Temperature	160°C
Rear Temperature	170°C
Middle Temperature	180°C
Front Temperature	190°C
Die Temperature	200°C

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.

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INJECTION MOULDING	Value
Drying Temperature (Circulating Air Oven)	80 - 90°C
Drying Time (Circulating Air Oven)	2 h
Melt Temperature	200 - 210°C
Feed Temperature	160°C
Rear Temperature	170°C
Middle Temperature	190°C
Front Temperature	200°C
Nozzle Temperature	210°C
Mould Temperature	40 - 60°C
Injection Rate	MEDIUM

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