



PRODUCT INFORMATION

HAIPLEN H120 C6

Polypropylene homopolymer calcium carbonate filled 30%, good surface finish and mechanical properties, high flow.

ISO short Form ISO 1043: PP-MD30 Pellets

Key Features

- Very high flow
- Mineral filled

Availability

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

Process

- INJECTION MOULDING

Application

- General purpose applications
- Electronic
- Electrical

Property	Method	Unit	Value	Condition	State
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ELECTRICAL

Tracking Resistance (CTI - Method A)	IEC 60112	Volt	>600		
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PHYSICAL

Density (+23°C)	ISO 1183	g/cm ³	1,15		
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Filler content	ISO 3451	%	30	550°C - 1 h	
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Granule Humidity	Internal method	%	0,05		
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Mould Shrinkage (Parallel)	Internal method	%	1,1		
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Mould Shrinkage (Normal)	Internal method	%	1,1		
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Melt Flow Rate (MFR)	ISO 1133	g/10 min	25	230°C - 2,16 kg	
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MECHANICAL

Tensile Yield Strength	ISO 527-1,2	MPa	30		
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Elongation at Break	ISO 527-1,2	%	30		
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Flexural Modulus	ISO 178	MPa	2300	
IZOD Notched Impact	ASTM D256	J/m	30	+23°C

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	145
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	90
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	65
Deflection Temperature 0,45 MPa (HDT B)	ISO 75B	°C	120

FLAMMABILITY

Flame Behaviour (3,2 mm)	UL94	Class	HB
Oxygen index	ASTM D2863	%	21

INJECTION MOULDING	Value
Drying Temperature (Desiccant Dryer)	70 - 80°C
Drying Time (Desiccant Dryer)	2 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

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.