



PRODUCT INFORMATION

HAIPLLEN H30 G2 BA

Polypropylene homopolymer 10% glass fibres reinforced chemically coupled, medium flow, good mechanical properties.

ISO short Form ISO 1043: PP-GF10 Pellets

Key Features

- Designed for injection moulding applications
- Glass fibres reinforced
- Medium low flow

Availability

- XMT: 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
- Automotive

Property	Method	Unit	Value	Condition	State
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,00		
Filler content	ISO 3451	%	10	600°C - 1h	
Water Absorption (24h / +23°C)	ISO 62	%	0,1		
Mould Shrinkage (Parallel)	Internal method	%	0,5 - 0,8		
Mould Shrinkage (Normal)	Internal method	%	0,9 - 1,1		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	6	230°C - 2,16 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	3500	Speed 1 mm/min	
Elongation at Break	ISO 527-1,2	%	15	Speed 50 mm/min	



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Tensile Break Strength	ISO 527-1,2	MPa	40	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	3400	Speed 2 mm/min
Flexural Break Strength	ISO 178	MPa	70	Speed 10 mm/min
IZOD Notched Impact (+23°C)	ASTM D256	J/m	40	

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	155	
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	115	
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	110	

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	HB	
Burning Rate (US-FMVSS 302)	ISO 3795	mm/min	< 80	Thickness > 1,5 mm
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	40 - 60°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
Vent Depth	< 0,05 mm



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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. 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.