



PRODUCT INFORMATION

HAIPLLEN H30 G3 BA

Polypropylene homopolymer 15% glass fibres reinforced chemically coupled, medium flow, good mechanical properties.

ISO short Form ISO 1043: PP-GF15 Pellets

Key Features

- Designed for injection moulding applications
- Glass fibres reinforced

Availability

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

Process

- INJECTION MOULDING

Application

- Consumer
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
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PHYSICAL

Density (+23°C)	ISO 1183	g/cm ³	1,00		
Filler content	ISO 3451	%	15	600°C - 1 h	
Water Absorption (24h / +23°C)	ISO 62	%	0,05		
Mould Shrinkage (Parallel)	Internal method	%	0,5 - 0,7		
Mould Shrinkage (Normal)	Internal method	%	0,6 - 0,8		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	6	230°C - 2,16 kg	

MECHANICAL

Elongation at Break	ISO 527-1,2	%	10	Speed 50 mm/min	
Tensile Break Strength	ISO 527-1,2	MPa	40	Speed 1 mm/min	
Flexural Modulus	ISO 178	MPa	3500	Speed 1 mm/min	
IZOD Notched Impact	ASTM D256	J/m	45	+23°C	



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THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	150
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	120
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	< 100 Thickness 2 mm
Oxygen index	ASTM D2863	%	21

INJECTION MOULDING

	Value
Drying Temperature (Desiccant Dryer)	80 - 100°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	0,2%
Melt Temperature	220 - 250°C
Feed Temperature	50°C
Rear Temperature	200°C
Middle Temperature	220°C
Front Temperature	230°C
Nozzle Temperature	240°C
Mould Temperature	40 - 60°C
Injection Rate	50 - 150 mm/sec
Injection Pressure	60 - 120 MPa
Packing Pressure	30 - 80 MPa
Back Pressure	As low as possible (<0,3 MPa)
Screw Revolving Speed	25 - 50 rpm
Screw Revolving Speed	50 rpm @ Diameter 40 mm
Screw Revolving Speed	35 rpm @ Diameter 55 mm
Screw Revolving Speed	25 rpm @ Diameter 75 mm
Cushion	5 - 8 mm
Vent Depth	0,05 mm



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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.
