PRODUCT INFORMATION

HAIPLEN H50 T5

Polypropylene homopolymer 25% talcum filled, medium flow, high stiffness.

ISO short ISO 1043: PP-MD25
Form Pellets

Key Features

- Designed for injection moulding applications
- Good flowability
- Mineral filled

Availability

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

Process

- INJECTION MOULDING

Application

- Power tools
- Household
- Garden furniture
- Furniture
- Electronic
- Electrical
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	>600		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,07-1,09		
Filler content	ISO 3451	%	25	600°C - 1h	
Granule Humidity	Internal method	%	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	10	230°C - 2,16 kg	

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MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	2700	Speed 1 mm/min
Tensile Yield Strength	ISO 527-1,2	MPa	45	Speed 50 mm/min
Elongation at Break	ISO 527-1,2	%	30	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	2600	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
Deflection Temperature 0,45 MPa (HDT B)	ISO 75B	°C	125

FLAMMABILITY

Flame Behaviour (3,2 mm)	UL94	Class	HB
Oxigen 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.