



PRODUCT INFORMATION

HAIPLEN H50 X2

Polypropylene homopolymer medium flow, flame retardant UL94 V2, good mechanical properties.

ISO short Form ISO 1043: PP FR(15+17)
Form Pellets
UL file E143048

Key Features

- Designed for injection moulding applications
- Flame retardant
- Good flowability

Availability

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

Compliance

- UL94 V2 approved all colours at 1,5 mm. GWFI and GWIT ratings approved.

Process

- INJECTION MOULDING

Application

- Furniture
- Electronic
- Electrical
- Automotive

Property	Method	Unit	Value	Condition	State
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	0,96		
Water Absorption (24h / +23°C)	ISO 62	%	0,03		
Mould Shrinkage (Parallel)	Internal method	%	1,3		
Mould Shrinkage (Normal)	Internal method	%	1,3		
Melting temperature (DSC)	ISO 11357	°C	163		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	10	230°C - 2,16 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	1700	Speed 1 mm/min	
Tensile Yield Strength	ISO 527-1,2	MPa	25	Speed 50 mm/min	



PRODUCT INFORMATION

HAIPLEN H50 X2

Elongation at Break	ISO 527-1,2	%	80	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	1500	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	35	+23°C
IZOD Notched Impact	ASTM D256	J/m	30	0 °C
IZOD Notched Impact	ASTM D256	J/m	25	-23°C
CHARPY Notched Impact	ISO 179/1eA	kJ/m ²	2,8	-10°C
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	3,2	
CHARPY Notched Impact (0°C)	ISO 179/1eA	kJ/m ²	3	
CHARPY Notched Impact (-25°C)	ISO 179/1eA	kJ/m ²	2,1	

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	65	
Deflection Temperature 0,45 MPa (HDT B)	ISO 75B	°C	120	
Continuous service temperature (20.000 h)	UL746 B	°C	65	

FLAMMABILITY

Flame Behaviour (1,5 mm)	UL94	Class	V2	UL approved
Flame Behaviour (3,2 mm)	UL94	Class	V2	
Glow Wire Flammability Index-GWFI (1 mm)	IEC 60695-2-12	°C	960	UL approved
Glow Wire Ignition Temperature-GWIT (1 mm)	IEC 60695-2-13	°C	775	UL approved
Oxygen index	ASTM D2863	%	26	
Needle flame test (1,6 mm)	IEC 60695-11-5	-	PASSED	
Needle flame test (3,2 mm)	IEC 60695-11-5	-	PASSED	

INJECTION MOULDING

	Value
Drying Temperature (Circulating Air Oven)	70 - 90°C
Drying Temperature (Desiccant Dryer)	70 - 90°C
Drying Time (Circulating Air Oven)	3 - 5 hours



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Drying Time (Desiccant Dryer)	0,5 - 2,5 hours
Suggested Max Moisture	0,2%
Suggested Max Re grind	< 5%
Melt Temperature	190 - 210°C
Feed Temperature	50°C
Rear Temperature	170°C
Middle Temperature	180°C
Front Temperature	190°C
Nozzle Temperature	200°C
Mould Temperature	40 - 60°C
Injection Rate	50 - 150 mm/sec
Screw Revolving Speed	50 - 100 rpm
Cushion	3 - 6 mm
Vent Depth	0,05 mm

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.