



PRODUCT INFORMATION

HAIPLEN H90 TX2

Polypropylene homopolymer high flow, 10% talcum filled, flame retardant UL94 V2, good mechanical properties.

ISO short Form ISO 1043: PP-MD10 FR(15+17)
Pellets

Key Features

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

Availability

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

Process

- INJECTION MOULDING

Application

- 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	1,02		
Water Absorption (24h / +23°C)	ISO 62	%	0,03		
Mould Shrinkage (Parallel)	Internal method	%	1,2		
Mould Shrinkage (Normal)	Internal method	%	1,2		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	20	230°C - 2,16 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	1800	Speed 1 mm/min	
Tensile Yield Strength	ISO 527-1,2	MPa	30	Speed 50 mm/min	



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Elongation at Break	ISO 527-1,2	%	70	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	1600	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	40	+23°C

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	155
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	95
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	70
Deflection Temperature 0,45 MPa (HDT B)	ISO 75B	°C	120
Ball Pressure Test	IEC 60695-10-2	°C	125

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	V2
Flame Behaviour (3,2 mm)	UL94	Class	V2
Glow Wire Flammability Index-GWFI (1 mm)	IEC 60695-2-12	°C	850
Oxygen index	ASTM D2863	%	26

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
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



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Screw Revolving Speed	50 - 100 rpm
Cushion	3 - 6 mm
Vent Depth	0,05 mm

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.