PRODUCT INFORMATION

HAIPLEN H50 C6

Polypropylene homopolymer 30% calcium carbonate filled, medium flow.

ISO short ISO 1043: PP-MD30
Form Pellets

Key Features

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

Availability

- XO: low odour emission
- W: lubricated
- LP: laser printable
- L: UV stabilized
- H: heat stabilized
- D: detergent stabilized
- All colours

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical
- Consumer
- 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	1,14		
Filler content	ISO 3451	%	30	550°C - 1 h	
Granule Humidity	Internal method	%	0,05		
Mould Shrinkage (Parallel)	Internal method	%	1,0 - 1,3		
Mould Shrinkage (Normal)	Internal method	%	1,0 - 1,3		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	10	230°C - 2,16 kg	

The listed data are in the normal range of product properties, they should not be used to establish specification nor as the basis of design. Values are valid for natural coloured version only.

Unless specified to the contrary, the given values have been established on standardized test specimens at room temperature. These values are for natural colour only. The figures should be regarded as guide values only and not as binding minimum values. Please note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mold/die, the processing conditions, pigments and any other additives.

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MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	2000	Speed 1 mm/min
Tensile Yield Strength	ISO 527-1,2	MPa	28	Speed 50 mm/min
Elongation at Break	ISO 527-1,2	%	30	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	1900	Speed 2 mm/min
IZOD Notched Impact (+23°C)	ASTM D256	J/m	35	
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m^2	3,5	
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m^2	45	

THERMAL

Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	90
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	60

FLAMMABILITY

Flame Behaviour (3,2 mm)	UL94	Class	HB

INJECTION MOULDING	Value
Drying Temperature (Desiccant Dryer)	80 - 90°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	0,08%
Suggested Max Regrind	< 10%
Melt Temperature	190 - 230°C
Feed Temperature	160 - 190°C
Rear Temperature	180 - 210°C
Middle Temperature	190 - 220°C
Front Temperature	200 - 230°C
Nozzle Temperature	210 - 230°C
Mould Temperature	30 - 50°C
Injection Rate	50 - 150 mm/sec
Injection Pressure	60 - 120 Mpa
Packing Pressure	30 - 80 Mpa
Back Pressure	As low as possible (<0,5 MPa)
Screw Revolving Speed	30 - 80 rpm

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Cushion	5 - 8 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 / 105°F 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.