

PRODUCT INFORMATION

HAIPLEN H50 G6 BA BLU RAL 5010

Polypropylene homopolymer 30% glass fibres reinforced chemically coupled to the resin matrix, medium flow and good mechanical properties.

ISO short Form ISO 1043: PP-GF30 Pellets

Key Features

- Good impact - stiffness balance
- Designed for injection moulding applications
- Glass fibres reinforced
- Good flowability

Process

- INJECTION MOULDING

Application

- Power tools
- Household
- General purpose applications
- Furniture
- Electronic
- Electrical
- Consumer
- Building
- Automotive

Property	Method	Unit	Value	Condition	State
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,12		
Filler content	ISO 3451	%	30	600°C - 1 h	
Water Absorption (24h / +23°C)	ISO 62	%	0,20		
Mould Shrinkage (Parallel)	Internal method	%	0,2 - 0,4		
Mould Shrinkage (Normal)	Internal method	%	0,7 - 0,9		
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. 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.

All information, recommendation or technical advice provided by TARO PLAST S.p.A. are given in good faith but without warranty, to the best of its knowledge and based on current procedures in effect. Our advice does not release you from the obligation to check its validity and to test our products as to their suitability for the intended processes and uses. The application, use and processing methods and conditions of our products and the products manufactured by you on the basis of our technical advice are beyond our control and, therefore, entirely under your own responsibility.

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MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	6200	Speed 1 mm/min
Elongation at Break	ISO 527-1,2	%	3,5	Speed 50 mm/min
Tensile Break Strength	ISO 527-1,2	MPa	85	Speed 50 mm/min
IZOD Notched Impact (+23°C)	ISO 180/1A	kJ/m²	7,5	
IZOD Notched Impact (+23°C)	ASTM D256	J/m	80	

THERMAL

Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	130
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	145

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	HB
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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

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Cushion	5 - 8 mm
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Vent Depth	0,05 mm
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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.

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