



PRODUCT INFORMATION

HAIPLEN H30 G6 BA Y0

Polypropylene homopolymer, 30% glass fibre reinforced, chemically coupled, flame retardant V0 halogen free, good mechanical properties.

ISO short Form ISO 1043: PP-GF30 FR(40)
Pellets

Key Features

- Designed for injection moulding applications
- Low smoke density and smoke toxicity
- Halogen free
- Glass fibres reinforced
- Flame retardant
- Low density
- Antimony trioxide free

Availability

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

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical

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	1,26		
Water Absorption (24h / +23°C)	ISO 62	%	0,05		
Mould Shrinkage (Parallel)	Internal method	%	0,20 - 0,40		
Mould Shrinkage (Normal)	Internal method	%	0,60 - 0,80		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	6	230°C - 2,16 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	6200		

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.

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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Elongation at Break	ISO 527-1,2	%	2
Tensile Break Strength	ISO 527-1,2	MPa	70
Flexural Modulus	ISO 178	MPa	5900
Flexural Break Strength	ISO 178	MPa	90
IZOD Notched Impact (+23°C)	ASTM D256	J/m	60
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	6,5
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m ²	30

THERMAL

Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	130
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	148
Ball Pressure Test	IEC 60695-10-2	°C	125

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	V0
Flame Behaviour (3,2 mm)	UL94	Class	V0
Glow Wire Flammability Index-GWFI (1,6 mm)	IEC 60695-2-12	°C	960

INJECTION MOULDING	Value
Drying Temperature (Desiccant Dryer)	80 - 100°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	0,2%
Suggested Max Regrind	< 10%
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 - 80°C
Injection Rate	50 - 150 mm/sec
Injection Pressure	60 - 120 Mpa

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Packing Pressure	30 - 80 Mpa
Back Pressure	As low as possible (<0,5 MPa)
Screw Revolving Speed	30 - 80 rpm
Cushion	5 - 8 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.

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