

Daplen™ EH104AE

Polypropylene

Borealis AG

Message:

Daplen EH104AE is a 12% mineral filled elastomer modified polypropylene compound intended for injection moulding. This material has an excellent balance between impact strength and stiffness, high melt flow rate and gives a good surface quality. Daplen EH104AE has been developed especially for the car industry to be used in automotive exterior parts.

General Information			
Filler / Reinforcement	Mineral filler, 12% filler by weight		
Additive	UV stabilizer		
Features	Rigid, good		
	High scratch resistance		
	Impact resistance, good		
	High liquidity		
	Excellent appearance		
Uses	Car anti-collision bar		
	Application in Automobile Field		
	Automotive exterior parts		
	Car exterior decoration		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.980	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	40	g/10 min	ISO 1133
Molding Shrinkage	0.80	%	Internal method
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness	28.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (Injection Molded)	1150	MPa	ISO 527-2/1
Tensile Stress (Yield, Injection Molded)	16.0	MPa	ISO 527-2/50
Tensile Strain (Yield, Injection Molded)	5.2	%	ISO 527-2/50
Flexural Modulus ¹ (Injection Molded)	1150	MPa	ISO 178
Flexural Stress (Injection Molded)	21.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C, injection molding	4.0	kJ/m ²	ISO 179/1eA
-20°C, injection molding	5.5	kJ/m ²	ISO 179/1eA
23°C, injection molding	31	kJ/m ²	ISO 179/1eA

Charpy Unnotched Impact Strength			ISO 179/1eU
-20°C, injection molding	30	kJ/m ²	ISO 179/1eU
23°C, injection molding	No Break		ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-20°C, injection molding	5.5	kJ/m ²	ISO 180/1A
23°C, injection molding	33	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	80.0	°C	ISO 75-2/B
1.8 MPa, not annealed	47.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	122	°C	ISO 306/A
--	40.0	°C	ISO 306/B
CLTE - Flow (-30 to 80°C)	6.8E-5	cm/cm/°C	Internal method
Melt Energy	65.0	kJ/kg	ISO 11357
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Processing (Melt) Temp	220 - 260	°C	
Mold Temperature	30.0 - 50.0	°C	
Holding Pressure	3.00 - 6.00	MPa	
Injection instructions			
Feeding Temperature: 40 to 80°C Back Pressure: Low to Medium Screw Speed: Low to Medium Flow Front Speed: 100 to 200 m/min			
NOTE			
1.	2.0 mm/min		

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