

Daplen™ EE340AE

Polypropylene

Borealis AG

Message:

Daplen EE340AE is a 30% mineral filled elastomer modified polypropylene compound intended for injection moulding. This material has excellent balanced mechanical properties, gives a good surface quality and is easy to process.

General Information			
Filler / Reinforcement	Mineral filler, 30% filler by weight		
Features	Workability, good		
	Sprayable		
	Excellent appearance		
Uses	Automotive exterior parts		
	Reinforced panel		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	12	g/10 min	ISO 1133
Molding Shrinkage			Internal method
-- ¹	0.50	%	Internal method
90°C, 2 hours	0.10	%	Internal method
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 132/10)	29.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1500	MPa	ISO 527-2/1
Tensile Stress (Yield)	16.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	6.0	%	ISO 527-2/50
Fracture	50	%	ISO 527-2/50
Flexural Modulus ²	1700	MPa	ISO 178
Flexural Stress	24.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C, injection molding	3.2	kJ/m ²	ISO 179/1eA
-20°C, injection molding	4.6	kJ/m ²	ISO 179/1eA
23°C, injection molding	49	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU

-20°C	77	kJ/m ²	ISO 179/1eU
23°C	No Break		ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-20°C	5.0	kJ/m ²	ISO 180/1A
23°C	32	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	101	°C	ISO 75-2/B
1.8 MPa, not annealed	54.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	128	°C	ISO 306/A50
--	39.0	°C	ISO 306/B50
CLTE - Flow (-30 to 80°C)	3.0E-5	cm/cm/°C	Internal method
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Hopper Temperature	40.0 - 80.0	°C	
Processing (Melt) Temp	220 - 260	°C	
Mold Temperature	30.0 - 50.0	°C	
Holding Pressure	30.0 - 60.0	MPa	
Injection instructions			
Back pressure: Low to mediumScrew speed: Low to mediumFlow front speed: 100 - 200 mm/s			
NOTE			
1.	disk		
2.	2.0 mm/min		

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