

Daplen™ EE168AI

Polypropylene

Borealis AG

Message:

Daplen EE168AI is a 10% mineral filled polypropylene compound intended for injection moulding. This material has an excellent balance between impact strength and stiffness and is easy to process.

General Information			
Filler / Reinforcement	Mineral filler, 10% filler by weight		
Features	Good dimensional stability		
	Rigid, good		
	Gloss, low		
	Impact resistance, good		
	Workability, good		
Uses	Scratch resistance		
	Application in Automobile Field		
	Car interior parts		
	Car interior equipment		
	Car dashboard		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.990	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	14	g/10 min	ISO 1133
Molding Shrinkage	1.1	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (Injection Molded)	1700	MPa	ISO 527-2/1
Tensile Stress (Yield, Injection Molded)	20.0	MPa	ISO 527-2/50
Tensile Strain (Yield, Injection Molded)	4.0	%	ISO 527-2/50
Flexural Modulus ¹ (Injection Molded)	1750	MPa	ISO 178
Flexural Stress (Injection Molded)	30.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-20°C, injection molding	5.0	kJ/m ²	ISO 179/1eA
23°C, injection molding	25	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-20°C, injection molding	110	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	4.0	kJ/m ²	ISO 180/1A
23°C, injection molding	27	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-20°C, injection molding	72	kJ/m ²	ISO 180/1U
23°C, injection molding	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	97.0	°C	ISO 75-2/B
1.8 MPa, not annealed	54.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	140	°C	ISO 306/A50
--	54.0	°C	ISO 306/B50
Melt Energy	64.1	kJ/kg	ISO 11357
Atomization-16 hr (100°C)	2.5E-4	g	DIN 75201
Emission	35.0	µgC/g	VDA 277
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.	2.0 mm/min		

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