

Daplen™ EF267AI

Polypropylene

Borealis AG

Message:

Daplen EF267AI is a 20 % 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, 20% filler by weight		
Features	High scratch resistance		
	Recyclable materials		
Uses	Car interior parts		
	Car dashboard		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.04	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	16	g/10 min	ISO 1133
Molding Shrinkage ¹	1.1	%	Internal method
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness (H 358/30)	61.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2450	MPa	ISO 527-2/1
Tensile Stress			
Yield	27.0	MPa	ISO 527-2/50
Fracture	10.0	MPa	ISO 527-2
Tensile Strain			
Yield	4.0	%	ISO 527-2/50
Fracture	15	%	ISO 527-2
Flexural Modulus ²	2500	MPa	ISO 178
Flexural Stress			ISO 178
3.5% strain	36.0	MPa	ISO 178
--	38.0	MPa	ISO 178
Flexural Strain	5.3	%	ISO 178
Atomization-16 h (100°C)		mg	DIN 75201
Emission		µgC/g	VDA 277
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-20°C	2.8	kJ/m ²	ISO 179/1eA

23°C	6.5	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-20°C	40	kJ/m ²	ISO 179/1eU
23°C	120	kJ/m ²	ISO 179/1eU
Notched Izod Impact			ISO 180/1A
-20°C	2.6	kJ/m ²	ISO 180/1A
23°C	6.4	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-20°C	27	kJ/m ²	ISO 180/1U
23°C	93	kJ/m ²	ISO 180/1U

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	105	°C	ISO 75-2/B
1.8 MPa, not annealed	56.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	141	°C	ISO 306/A50
--	67.0	°C	ISO 306/B50
CLTE - Flow ³	5.5E-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 m/min	
NOTE	
1.	disk
2.	2.0 mm/min
3.	-30°C/80°C

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