

PPR HDPE01

High Density Polyethylene
Premier Plastic Resins, Inc.

Message:

PPR HDPE01 is a high-density polyethylene product. It can be processed by injection molding and is available in North America.

General Information			
Appearance	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.953	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	2.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	21.4	MPa	ASTM D638
Tensile Elongation (Break)	200	%	ASTM D638
Flexural Modulus - Tangent	828	MPa	ASTM D790
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	68.0	°C	ASTM D648
1.8 MPa, not annealed	54.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	77.0 - 82.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	188 - 232	°C	
Middle Temperature	188 - 232	°C	
Front Temperature	182 - 227	°C	
Nozzle Temperature	193 - 232	°C	
Processing (Melt) Temp	193 - 232	°C	
Mold Temperature	16.0 - 49.0	°C	
Injection Pressure	3.00 - 41.0	MPa	
Injection Rate	Moderate-Fast		
Holding Pressure	3.00 - 34.0	MPa	
Back Pressure	0.00 - 1.00	MPa	
Cushion	6.35 - 12.7	mm	
Injection instructions			

Screw Speed: ModerateDecompression: 3.81 to 7.6 mm

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