

RheTech Polyethylene E204-00

High Density Polyethylene

RheTech, Inc.

Message:

High Density Polyethylene, Natural.

General Information			
Features	High density		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.953	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	35	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	58		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	22.8	MPa	ASTM D638
Flexural Modulus	896	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	43	J/m	ASTM D256
Dart Drop Impact	22.6	J	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	65.0	°C	ASTM D648
1.8 MPa, not annealed	44.4	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	37.8 - 48.9	°C	
Drying Time	1.0 - 2.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	149 - 160	°C	
Middle Temperature	154 - 171	°C	
Front Temperature	160 - 179	°C	
Nozzle Temperature	160 - 171	°C	
Mold Temperature	15.6 - 26.7	°C	
Injection Pressure	2.76 - 10.3	MPa	
Holding Pressure	2.07 - 8.27	MPa	
Back Pressure	0.345 - 1.03	MPa	
Injection instructions			

Injection Speed: Variable - Application DependantScrew RPM: Recovery 3 seconds before mold opensCycle Time: Wall Thickness Dependant

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Recommended distributors for this material

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