

HIVAL® 506060 NT

Nexeo Solutions, LLC. - High Density Polyethylene

Monday, November 10, 2014

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Features	• Food Contact Acceptable
Agency Ratings	• FDA 21 CFR 177.1520(c) 3.1 • FDA 21 CFR 177.1520(c) 3.2
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	0.965	g/cm ³	ASTM D1505
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	8.0	g/10 min	ASTM D1238
Environmental Stress-Cracking Resistance 100% Igepal, F50	< 3.00	hr	ASTM D1693
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus - 1% Secant	135000	psi	ASTM D638
Tensile Elongation (Break)	16	%	ASTM D638
Flexural Modulus - 1% Secant	250000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (-40°F)	0.90	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	185	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	120	°F	ASTM D648
Melting Temperature	244	°F	

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	450	°F
Middle Temperature	470	°F
Front Temperature	470	°F
Nozzle Temperature	475	°F
Processing (Melt) Temp	470	°F
Mold Temperature	45.0 to 65.0	°F
Injection Pressure	400 to 1500	psi
Back Pressure	150 to 500	psi

Injection Notes

Screw Speed: Slow
Injection Speed: Slow - Fast

Avoid excessive melt temperatures and long residence times as this could lead to thermal degradation.

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Notes

¹ Typical properties: these are not to be construed as specifications.