

# Polyethylene BorPEX<sup>TM</sup> HE2591

High Density Polyethylene for Crosslinked Pipes (PE-X)



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## Description

**BorPEX HE2591** is a high molecular weight, high density polyethylene specially designed for production of crosslinked pipes (PE-X)

## Applications

**BorPEX HE2591** is recommended for the production of crosslinked pipes used in

Plumbing  
Heating  
Domestic gas  
Domestic water

Industrial applications  
Relining  
District heating

## Specifications

**BorPEX HE2591** is intended to fulfill following standards and regulations, in case of appropriate industrial manufacturing standard procedures applied and a continuous quality system is implemented.

DIN 16892  
DIN 16893

EN ISO 15875  
ASTM F 876

## Special features

**BorPEX HE2591** is a free flowing powder for the PE-Xa, peroxide crosslinking process. The material is only stabilized for transporting and storage. Crosslinking agent (e.g. peroxide) and stabilisers have to be added by the pipe manufacturer. Good crosslink response and well-balanced powder size distribution enable effective soaking and a stable pipe production.

Enhanced processability  
Economical pipe production

Cleanliness  
Excellent product consistency

## Physical Properties

Property	Typical Value	Test Method
Data should not be used for specification work		
Density (Base Resin)	944 kg/m <sup>3</sup>	ISO 1183
Melt Flow Rate (190 °C/21,6 kg)	10 g/10min	ISO 1133
Tensile Strain at Break	> 600 %	ISO 527-2

## Processing Techniques

The actual conditions will depend on the type of equipment used.

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## Extrusion

The actual extrusion conditions will depend on the type of equipment used. They will also depend on size and wall thickness of the pipe produced.

BorPEX HE2591 is successfully used in the industry on the older RAM (Engel) process as well as on the newer type of screw extrusion equipment in combination with different PE-Xa crosslinking methods.

## Crosslinking

The product has been tailored for the screw extrusion process in combination with the infrared cross-linking method.

Specific recommendations for processing conditions can be determined only when the application and type of equipment are known. Please contact your local Borealis representative for such particulars.

## Storage

**BorPEX HE2591** should be stored in dry conditions at temperatures below 50°C and protected from UV-light. Improper storage can initiate degradation, which results in odour generation and colour changes and can have negative effects on the physical properties of this product.

## Safety

The product is not classified as a dangerous preparation.

## Recycling

Please see our Safety Data Sheet for details on various aspects of safety, recovery and disposal of the product, for more information contact your Borealis representative.

## Related Documents

The following related documents are available on request, and represent various aspects on the usability, safety, recovery and disposal of the products.

Safety Data Sheet

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## Disclaimer

**The product(s) mentioned herein are not intended to be used for medical, pharmaceutical or healthcare applications and we do not support their use for such applications.**

To the best of our knowledge, the information contained herein is accurate and reliable as of the date of publication, however we do not assume any liability whatsoever for the accuracy and completeness of such information.

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