

HiFill® HDPE MD BL517415

 Techmer Polymer Modifiers - *Polyethylene*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Features	<ul style="list-style-type: none"> Metal Detectable
Appearance	<ul style="list-style-type: none"> Blue
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.19		ASTM D792
Molding Shrinkage - Flow (0.125 in)	17 to 19	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	2800	psi	ASTM D638
Tensile Elongation (Break)	8.0	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.66	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	1.0 to 2.0	hr
Rear Temperature	340 to 370	°F
Middle Temperature	350 to 380	°F
Front Temperature	360 to 390	°F
Nozzle Temperature	370 to 400	°F
Processing (Melt) Temp	350 to 405	°F
Mold Temperature	75 to 125	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

