

RheTech Products E204-01 High Density Polyethylene, Black

Category : Polymer , Thermoplastic , Polyethylene (PE) , HDPE , High Density Polyethylene (HDPE), Injection Molded

Material Notes:

Applications: Electrical housings Underhood components Consumer Goods Injection molding conditions reported in table. Information provided by RheTech Products.

Order this product through the following link:

http://www.lookpolymers.com/polymer_RheTech-Products-E204-01-High-Density-Polyethylene-Black.php

Physical Properties	Metric	English	Comments
Specific Gravity	0.959 g/cc	0.959 g/cc	23/23°C; ASTM D792
Linear Mold Shrinkage	0.020 cm/cm	0.020 in/in	ASTM D955
Melt Flow	35 g/10 min @Load 2.16 kg, Temperature 230 °C	35 g/10 min @Load 4.76 lb, Temperature 446 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	58	58	ASTM D2240
Tensile Strength at Break	22.8 MPa	3300 psi	2 in/min; ASTM D638
Flexural Modulus	0.896 GPa	130 ksi	Tangent; ASTM D790
Izod Impact, Notched	0.427 J/cm @Temperature 23.0 °C	0.800 ft-lb/in @Temperature 73.4 °F	ASTM D256
Gardner Impact	22.6 J	16.7 ft-lb	ASTM D5420

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	65.0 °C	149 °F	ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	44.4 °C	112 °F	ASTM D648

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	149 - 160 °C	300 - 320 °F	
Middle Barrel Temperature	154 - 171 °C	310 - 340 °F	
Front Barrel Temperature	160 - 179 °C	320 - 355 °F	
Nozzle Temperature	160 - 171 °C	320 - 340 °F	

Mold Temperature Processing Properties	15.6 - 26.7 °C Metric	60.0 - 80.0 °F English	Comments
Drying Temperature	37.8 - 48.9 °C	100 - 120 °F	
Dry Time	1 - 2 hour	1 - 2 hour	
Moisture Content	<= 0.050 %	<= 0.050 %	Recommended
Injection Pressure	2.76 - 10.3 MPa	400 - 1500 psi	
Hold Pressure	2.07 - 8.27 MPa	300 - 1200 psi	
Back Pressure	0.345 - 1.03 MPa	50.0 - 150 psi	

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