

**Hival High Density Polyethylene**

nexeo™ solutions -HDPE 500354 NT

**General Information**

**General**

Product Code	* 2650401
Material Status	* Commercial: Active
Availability	* North America
Test Standards Available	* ASTM
Recycled Content	* No
Features	* RoHS compliant, BPA Free
Forms	* Pellets
Processing Method	* Blow Molding

**Properties**

	Nominal Value	Unit	Test Method
Melt Flow Rate (200°C/5.0 kg-G)	0.38	g <sup>3</sup> /10min	ASTM D1238
Melt Volume-Flow Rate	*	cm <sup>3</sup> /10min	ISO 1133
Density	0.953	g/cm <sup>3</sup>	ASTM D1505
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	*	psi	ASTM D638
Tensile Strength @ Yield	3,900	psi	ASTM D638
Flexural Modulus	180,000	psi	ASTM D790
Tensile Elongation @ Break	>500	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Impact	120	ft-lb/in	ASTM D1822
Charpy Impact Strength	*	kJ/m <sup>2</sup>	ISO 179
<b>Hardness</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Durometer	66	D	ASTM D785
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Vicat Softening Point	262	°F	ASTM D1525
Deflection Temperature of Plastic @ 66 psi	165	°F	ASTM D648
Low Temp Brittleness. F50	<-76	°F	ASTM D746
<b>Optical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
	*		
<b>UL information</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flammability Rating @ 0.031	*	---	UL 94
Flammability Rating @ 0.059	*	---	UL 94
Flammability Rating @ 0.118	*	---	UL 94

**Suggested Applications**

Pails Buckets

**Other Properties**

ESCR F50	25 Hrs	ASTM D1693
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**Compliance**

**Hival High Density Polyethylene**

Compliant with U.S. Food and Drug Administration as specified in 21CFR177.1520 covering safe use of polyolefin articles intended for direct food contact.

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Processing Method	* Blow Molding

**General Processing Information Blow Molding**

General Drying	Time	Temperature
	*	* °F

**Processing Temperatures**

Blow Molding		Unit
Rear Zone	330	°F
Transition	350	°F
Metering	360	°F
Head	375	°F
Mold	60	°F

**Air Pressure**

Blow Air	90	psi
Pre Blow	10	psi

**Processing Precautions**

Higher Temperature settings may be necessary for parts or cycles requiring more plasticizing capacity. Typical values not to be construed as specifications. Fabrication conditions will affect shrinkage

For Technical Assistance please call the nexeo solutions™ Plastics Technical Service Desk

Telephone: 866-430-9666 or Email: [techconnect@nexeosolutions.com](mailto:techconnect@nexeosolutions.com)

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Features	* *
Forms	* Pellets
Processing Method	* Extrusion

**General Processing Information Extrusion**

<b>General Drying</b>	<b>Time</b>	<b>Temperature</b>	
	2 hours	170-175 °F	

**Processing Temperatures**

<b>Extrusion</b>	<b>Temperature</b>	<b>Unit</b>	
Feed Zone	380-440	°F	
Transition Zone	390-450	°F	
Metering Zone	400-470	°F	
Die	410-450	°F	
Screw L/D	20:01		
Compression Ratio	2:1-3:1		

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