

Polyethylene - Recyclate

recythen[®] HDPE

General Data

Form: Granulate

Use: Extrusion

Physical Properties

Parameter	Test Standard	Value	Deviation	Unit
MFR: 190 °C ; 5,00 kg	ISO 1133-1	2	± 0,7	g/10min
MFR: / ; /	ISO 1133-1	/	/	g/10min
Density	ISO 1183-1	0,95	± 0,02	g/cm ³
Ash Content	650 °C/15 min	/	/	%
Volatiles	Aqua 130 °C	/	/	ppm
HDT (1,8 MPa)	ISO 75-2	/	/	°C
Vicat (10 N)	ISO 306	/	/	°C
Bulk Density	ISO 60	0,57	± 0,03	g/cm ³
Moisture Content	ASTM D6980-17	< 0,2	/	%
Elemental Analysis (XRF)	DIN 51418-2	< 0,1	/	%

Mechanical Properties

Parameter	Test Standard	Value	Deviation	Unit
Tensile Modulus	ISO 527-2	850	± 150	MPa
Tensile Strength	ISO 527-2	> 21	/	MPa
IZOD Impact Strength				
at 23 ± 2 °C	ISO 180	/	/	kJ/m ²
at -30 ± 2 °C	ISO 180	/	/	kJ/m ²
Charpy Impact Strength				
at 23 ± 2 °C	ISO 179-1	17,5	± 5	kJ/m ²
at -30 ± 2 °C	ISO 179-1	/	/	kJ/m ²

On request the material can be delivered in various color gradations.

All figures shown in the table are representative and should not be used for establishing specifications.

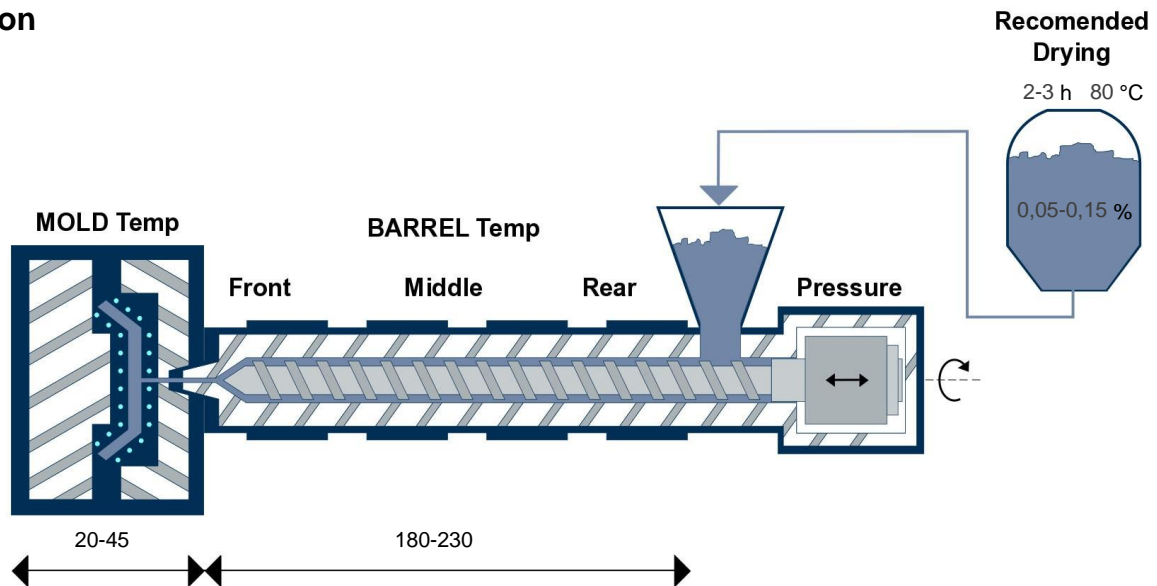
The manufacturing process for this material is EuCertPlast certified. The material complies with the requirements for the 'Blauer Engel' ecolabel.

The information contained in this publication is true and accurate at the time of publication and to the best of our knowledge. The nominal values stated herein are obtained using laboratory test specimens. Before using one of the products mentioned herein, customers and other users should take all care in determining the suitability of such product for the intended use. The companies within Interzero Holding GmbH & Co. KG do not accept any liability whatsoever arising from the use of this information or the use, application or processing of any product describe herein. No information contained in this publication can be considered as suggestion to infringe patents. The companies disclaim any liability that might be claimed for infringement or alleged infringement of patents.

Polyethylene - Recyclate

recythen[®] HDPE

Extrusion



Injection Moulding

Parameter	Recommended Value	Unit
Injection Pressure	800-1500	bar
Hold Pressure	Minimum (70-80% of injection pressure)	
Melt Temperature	180-230	°C
Melt Temperature	190-230	°C
Extrusion		
Max Temperature	245	°C

Note: The listed processing parameters are general guidelines based on our current knowledge and experience. The suitability of the data for a specific processing method can only be ensured with investigations and tests by the end user.

The information contained in this publication is true and accurate at the time of publication and to the best of our knowledge. The nominal values stated herein are obtained using laboratory test specimens. Before using one of the products mentioned herein, customers and other users should take all care in determining the suitability of such product for the intended use. The companies within Interzero Holding GmbH & Co. KG do not accept any liability whatsoever arising from the use of this information or the use, application or processing of any product describe herein. No information contained in this publication can be considered as suggestion to infringe patents. The companies disclaim any liability that might be claimed for infringement or alleged infringement of patents.