

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	1.7	± 0,7	g/10min
MFR: / ; /	ISO 1133	/	/	g/10min
Density	ISO 1183	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	0,58	± 0,03	g/cm ³
Moisture Content	ISO 585	< 0,2	/	%

RoHS: max. 1000 ppm (except Cd max. 100 ppm).

Mechanical Properties

Parameter	Test Standard	Value	Deviation	Unit
Tensile Modulus	ISO 527	800	± 150	MPa
Tensile Strength	ISO 527	> 21	/	MPa
IZOD Impact Strength				
at 23 ± 2 °C	ISO 180/1A	/	/	kJ/m ²
at -30 ± 2 °C	ISO 180/1A	/	/	kJ/m ²
Charpy Impact Strength				
at 23 ± 2 °C	ISO 179/1eA	20	± 5	kJ/m ²
at -30 ± 2 °C	ISO 179/1eA	/	/	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.

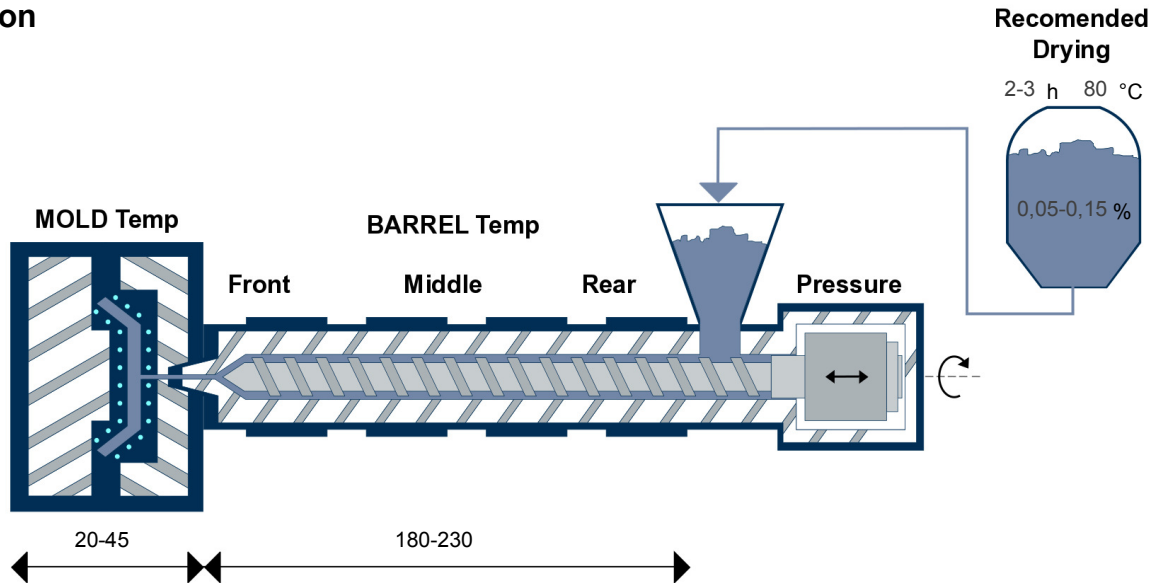
The material may contain foreign particles up to size ≤3mm. Which may also be seen on the surface of the final product.*

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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.

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