

Halene H M5025L

High Density Polyethylene
Haldia Petrochemicals Ltd.

Message:

M5025L is an Injection Molding Grade HDPE produced by Spherilene Technology.
This resin is particularly recommended for general-purpose Injection Molded items and Masterbatch application.
M5025L combines excellent processability with good mechanical properties.

General Information			
Features	General Purpose		
	Good Processability		
Uses	General Purpose		
	Masterbatch		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density ¹	0.950	g/cm ³	ASTM D1505
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	30	g/10 min	ASTM D1238
Spiral Flow ²	73.0	cm	Internal Method
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, Injection Molded)	62		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ³ (Yield, Injection Molded)	20.0	MPa	ASTM D638
Tensile Elongation ⁴ (Break, Injection Molded)	250	%	ASTM D638
Flexural Modulus (Injection Molded)	800	MPa	ASTM D790A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, Injection Molded)	28	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed)	77.0	°C	ASTM D648
Vicat Softening Temperature	125	°C	ASTM D1525 ⁵
Peak Melting Temperature	132	°C	ASTM D3418
Injection	Nominal Value	Unit	
Rear Temperature	180 to 235	°C	
Middle Temperature	180 to 235	°C	
Front Temperature	180 to 235	°C	
Nozzle Temperature	235	°C	

NOTE	
1.	23°C
2.	Melt Temperature: 235°C
3.	50 mm/min
4.	50 mm/min
5.	Loading 1 (10 N)

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