

Braskem PE ES6004

High Density Polyethylene

Braskem

Message:

ES6004 is a high density polyethylene, homopolymer designed for the blow-molding segment. ES6004 shows high stiffness properties, good impact resistance and good surface quality.

Application:

Blow Molded Small Volume: Bottles for lubricant and edible oils, milk, juice and yogurt; Toys.

Process:

Blow Molding.

General Information			
Features	Rigidity, high		
	High density		
	Homopolymer		
	Impact resistance, high		
Uses	Cosmetics		
	Toys		
Agency Ratings	FDA 21 CFR 177.1520		
Forms	Particle		
Processing Method	Blow molding		
	Compression molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.960	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	0.35	g/10 min	ASTM D1238
190°C/21.6 kg	30	g/10 min	ASTM D1238
Environmental Stress-Cracking Resistance (2.00 mm, 100% Igepal, Compression Molded, F50)	20.0	hr	ASTM D1693
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, Compression Molded)	30.0	MPa	ASTM D638
Flexural Modulus - 1% Secant (Compression Molded)	1400	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Unnotched Izod Impact (Compression Molded)	150	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, Compression Molded)	70.0	°C	ASTM D648

Injection instructions

Recommended Blow Molding Conditions:

Feeding Zone: 185°C

Barrel: 190°C

Die: 195°C

Parison: 200°C

Mold Temperature: 5°C to 25°C

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