

# CRYSTALADD® HM-664

High Density Polyethylene

Ravago Manufacturing Americas, LLC

## Message:

### NUCLEATOR MASTERBATCH

HM-664 is an additive concentrate containing Milliken's Hyperform® HPN-210M nucleator. This masterbatch compound is designed to reduce cycle time in injection molded polyethylene parts, improve stiffness and HDT, and reduce or improve warpage challenges during processing.

### Key Features:

Designed to be added to injection molded polyethylene parts

Improved stiffness, HDT and part uniformity

Uniform concentration of additives in concentrate form.

Masterbatch pellet form for ease of addition and feeding into extrusion equipment

### Directions for Use:

HM-664 is added to HDPE or LLDPE at 2.5% to 5% to achieve faster cooling, higher crystallization temperature and a higher crystallization rate. Parts are ejected from the mold with at a higher overall temperature but will have more completed crystal formation, allowing for a reduced overall cycle time.

Note: Effectiveness is significantly reduced in LDPE due to the high long chain branching of the polymer. LDPE with MI > 25 can present some of the above performance improvements.

### FDA Compliance:

This product is not approved for use in food contact applications at this time, but will be updated once regulatory tests are completed.

General Information			
Uses	Masterbatch		
Forms	Pellets		
Processing Method	Blow Molding		
	Extrusion		
	Film Extrusion		
	Injection Molding		

Physical	Nominal Value	Unit	Test Method
Density	0.950	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	8.2	g/10 min	ASTM D1238

Additional Information	Nominal Value	Unit	Test Method
Nucleating Agent - HPN-210M	4.0	%	Internal Method
Polymer Base	HDPE		

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## Recommended distributors for this material

### Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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