Prime PE HDPE 250

High Density Polyethylene

Primex Plastics Corporation

Message:

Is a fractional melt with a density of .950 - .955 and a melt index of .2 -.35. Our Prime HDPE 250 offers characteristics such as good stiffness and stress crack resistance. Along with being light weight and tough, it is an ideal selection for many interior or exterior parts.
Applications:
Prime HDPE 250 is ideal for forming trays, food packaging, small dunnage, or any other parts that requires cold temperature impact. It also works well for small lawn tractor parts, and many other small tool components.
Processing:
This is a crystalline material, therefore it requires more attention than an amorphous material. It is recommend that it be formed on an aluminum tool that is temperature controlled, grit blasted and with a moat on the outside of the trim line. The forming temperature should be 300-350°F. The tool temp. should be 160-190°F.
Finishing:
Prime HDPE 250 may be drilled, routed, punched, sawed, die cut, laser cut, or cut using water jet. Mechanical fasteners and screws may be used. Contact the 3M company for information on bonding. Caution, the CLTE is higher than other thermoplastic materials.
Please contact your Primex Plastics representative for more information on finishing, fabricating, or the thermoforming process.
Colors, Textures and Capabilities:
Prime HDPE 250 can be color matched to meet your specific requirements. Prime HDPE 250 is offered in thicknesses of .015 - .425 and widths of up to 169". Textures include; RM, H/C, Levant I, II, & III and Seville.

General Information			
Features	Crystalline Good Stiffness Good Toughness High ESCR (Stress Crack Resist.) High Tensile Strength Low Temperature Impact Resistance Ultra High Impact Resistance		
Uses	Food Packaging Lawn and Garden Equipment Power/Other Tools Support Trays		
Agency Ratings	FDA 21 CFR 177.1520		
Appearance	Colors Available		
Forms	Sheet		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	0.953	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	0.25	g/10 min	ASTM D1238
Environmental Stress-Cracking Resistance (F50)	45.0	hr	ASTM D1693A
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	27.6	MPa	ASTM D638

Tensile Elongation (Break)	600	%	ASTM D638
Flexural Modulus	1380	MPa	ASTM D790
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (0.45 MPa, Unannealed)	73.9	°C	ASTM D648
Brittleness Temperature	< -75.0	°C	ASTM D746
Vicat Softening Temperature	127	°C	ASTM D1525
CLTE - Flow	1.4E-4	cm/cm/°C	ASTM D696
Flammability	**Nominal Value**		**Test Method**
Flame Rating [1] (0.381 mm)	HB		UL 94
Additional Information	**Nominal Value**	**Unit**	
Forming Temperature	149 to 177	°C	
Tool Temperature	71 to 88	°C	
NOTE			
1.	>0.015 in		

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