

CERTENE™ HPB-0354Z

High Density Polyethylene
Muehlstein

Message:

HPB-0354Z is a certified prime Phillips Process BLOW MOLDING copolymer designed for light weight parts needing consistent mold release. HPB-0354Z contains zinc stearate and offers good processability on conventional continuous or intermittent extrusion equipment, good ESCR, Impact strength and Stiffness. Applications include injection blow molded parts and small to medium bottles. Recommended melt temperature for HPB-0354Z is 180 to 190°C (356 - 375°F), with the mold at 15 to 25°C (60 - 80°F). HPB-0354Z complies with FDA regulation 21 CFR 177.1520(c) 3.2a, conditions of use B - H per 21 CFR 176.170 (c).

General Information			
Additive	Zinc stearate lubricant		
Features	Rigidity, high		
	High ESCR (Stress Cracking Resistance)		
	Copolymer		
	Impact resistance, high		
	Workability, good		
	Lubrication		
Uses	Blow molding applications		
	Bottle		
Agency Ratings	FDA 21 CFR 176.170(c) 1		
	FDA 21 CFR 177.1520(c) 3.2a		
Forms	Particle		
Processing Method	Blow molding		
	Injection blowing molding		
Physical	Nominal Value	Unit	Test Method
Density	0.955	g/cm ³	ASTM D1505
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	0.35	g/10 min	ASTM D1238
Environmental Stress-Cracking Resistance (50°C, 100% Igepal, Compression Molded, F50)	35.0	hr	ASTM D1693B
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, Compression Molded)	27.0	MPa	ASTM D638
Tensile Elongation ² (Break, Compression Molded)	600	%	ASTM D638
Flexural Modulus - 1% Secant ³ (Compression Molded)	1380	MPa	ASTM D790

Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	< -80.0	°C	ASTM D746
Additional Information			
Test specimens from compression molded plaque according to ASTM D 1928 Procedure C.			
Injection	Nominal Value	Unit	
Mold Temperature	15.0 - 25.0	°C	
Extrusion	Nominal Value	Unit	
Melt Temperature	180 - 190	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	1.3 mm/min		

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