

EL-Lene™ H5818J

High Density Polyethylene
SCG Chemicals Co., Ltd.

Message:

EL-Lene H5818J is a general purpose high density polyethylene resin suitable for using in injection molding process. This good flowability grade designed for high productivity requirement.

General Information			
Features	Impact resistance, good		
	Workability, good		
	Compliance of Food Exposure		
	General		
Uses	Shield		
	Household goods		
	Business equipment		
	General		
	Shell		
	Toys		
Agency Ratings	FDA 21 CFR 177.1520		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.962	g/cm ³	ASTM D1505
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	18	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow: 2.00mm	2.0	%	ASTM D955
Transverse flow: 2.00mm	2.5	%	ASTM D955
Environmental Stress-Cracking Resistance (50°C, 25% Igepal, Compression Molded, F50)	2.00	hr	ASTM D1693B
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	66		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	27.5	MPa	ASTM D638
Fracture	15.7	MPa	ASTM D638
Tensile Elongation ² (Break)	150	%	ASTM D638
Flexural Modulus	1270	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	25	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed)	75.0	°C	ASTM D648
Brittleness Temperature	-60.0	°C	ASTM D746
Vicat Softening Temperature	122	°C	ASTM D1525
Melting Temperature	131	°C	ASTM D2117
Injection	Nominal Value	Unit	
Processing (Melt) Temp	200 - 250	°C	
Mold Temperature	20.0 - 60.0	°C	
Injection Rate	Fast		
Screw Speed	40 - 70	rpm	
Injection instructions			
Injection Pressure: 30 to 70% of max. pressurePacking and Holding Pressure: 30 to 50% of max. pressureBack Pressure: 10% of max. pressure			
NOTE			
1.	50 mm/min		
2.	50 mm/min		

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