

Safrene® F 7660

High Density Polyethylene

Safripol (PTY) LTD

Message:

Safrene® F 7660 High Density Polyethylene Resin is a medium molecular mass grade with good processing properties. It exhibits a good surface finish with high hardness and rigidity.

Safrene® F 7660 High Density Polyethylene Resin is recommended for milk and fruit juice bottles as well as other general purpose bottle applications up to 5 liter where good stiffness is required but environmental stress-crack resistance is not critical.

General Information			
Features	Rigidity, high		
	Rigid, good		
	Workability, good		
	Fast molding cycle		
	Compliance of Food Exposure		
	High hardness		
	Excellent appearance		
	Medium molecular weight		
Uses	Juice bottle		
	Household goods		
	Bottle		
	Container		
	Food container		
Agency Ratings	FDA 21 CFR 177.1520(c) 3.1c		
	Europe 10/1/2011 12:00:00 AM		
Processing Method	Blow molding		
Physical	Nominal Value	Unit	Test Method
Density ¹	0.956	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			ISO 1133
190°C/2.16 kg	0.45	g/10 min	ISO 1133
190°C/5.0 kg	2.0	g/10 min	ISO 1133
Spiral Flow	33.0	cm	Internal method
Viscosity Number (Reduced Viscosity)	280.0	ml/g	ISO 1628
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, Compression Molded)	64		ISO 868
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			ISO 527-2/50

Yield, molding	27.0	MPa	ISO 527-2/50
Fracture, molding	38.0	MPa	ISO 527-2/50
Tensile Strain (Break, Compression Molded)	> 600	%	ISO 527-2/50
Flexural Stress (3.5% Strain, Compression Molded)	22.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C, molded	8.0	kJ/m ²	ISO 179
23°C, molded	11	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	77.0	°C	ISO 306/B
Peak Crystallization Temperature (DSC)	130 - 133	°C	ISO 3146

Additional Information

Blow Molding conditions:

Feed Zone: 160 to 180°C

Zone 1: 170 to 190°C

Zone 2: 180 to 200°C

Zone 3: 180 to 190°C

Die: 190 to 200°C

Melt Temperature: 180 to 190°C

NOTE

1. Unannealed

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