

PRE-ELEC® PE 1250

High Density Polyethylene

Premix Oy

Message:

PRE-ELEC® PE 1250 is a conductive thermoplastic concentrate based on PE-HD. Conductivity is achieved by using special conductive carbon black. PRE-ELEC® PE 1250 contains a high load of carbon black and it can be diluted up to 50% with virgin or recycled PE-HD. The actual amount should always be tested as it also depends on the processing conditions. Typical applications for PRE-ELEC® PE 1250 include extruded pipes, profiles and sheets.

General Information			
Additive	Carbon black		
Features	Conductivity		
Uses	Sheet		
	Profile		
Forms	Particles		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.02	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/21.6 kg)	1.6	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield	24.0	MPa	ASTM D638, ISO 527-2
--	10.0	MPa	ASTM D638
4.00 mm	10.0	MPa	ISO 527-2
Tensile Elongation			
Yield	10	%	ASTM D638, ISO 527-2
Fracture	31	%	ASTM D638
Fracture, 4.00mm	31	%	ISO 527-2
Flexural Modulus (4.00 mm)	1100	MPa	ASTM D790, ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-20°C, 4.00 mm	18.9	kJ/m ²	ASTM D256
23°C, 4.00 mm	46.2	kJ/m ²	ASTM D256
Notched Izod Impact ¹			ISO 180
-20°C	18	kJ/m ²	ISO 180
23°C	46	kJ/m ²	ISO 180
Unnotched Izod Impact			ASTM D256
-20°C, 4.00 mm	No Break		ASTM D256
23°C, 4.00 mm	No Break		ASTM D256

Unnotched Izod Impact Strength ²			ISO 180
-20°C	No Break		ISO 180
23°C	No Break		ISO 180
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	< 1.0E+6	ohms	ESD STM11.11, IEC 61340-2-3
Volume Resistivity	< 1.0E+4	ohms·cm	Internal method
Extrusion	Nominal Value	Unit	
Drying Temperature	60.0 - 80.0	°C	
Drying Time	2.0 - 4.0	hr	
Cylinder Zone 1 Temp.	200	°C	
Cylinder Zone 2 Temp.	210	°C	
Cylinder Zone 3 Temp.	220	°C	
Cylinder Zone 4 Temp.	220	°C	
Cylinder Zone 5 Temp.	230	°C	
Extrusion instructions			
Cylinder Zone 6: 230°C			
NOTE			
1.	4 mm thickness		
2.	4 mm thickness		

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