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v1.7

Technical Data Sheet

PCR HDPE Regranulate Natural

Product Code: 000621



Recycled Content: 100 % PCR (post-consumer)

Melt Filtration: 75 µm

Product Description:

000621 PCR HDPE Regranulate Natural comes from post-consumer recycled materials in Asia and is suitable for injection moulding applications. The material is GRS certified. The material is produced by a recycling process approved by the FDA.

Physical Property	Value	Units	Test Standard	Test Condition
Density	0.94	g/cm^3	ISO 1183	
MFI	3.5	g/10 min	ISO 1133	190°C, 2.16kg
Tensile Strength	20	MPa	ISO 527-2	
Tensile Modulus	810	MPa	ISO 527-2	50mm/min
Elongation at Break	>120	%	ISO 527-2	
Flexural Modulus	860	MPa	ISO 178	
Flexural Strength	22	MPa	ISO 178	
Ash Content	<0.1	%	ISO 3451-1	
Melt Point	130	°C	ISO 11357	DSC
Moisture Content	<0.2	%	ISO 15512	
Charpy Impact Strength, notched	7	KJ/m^2	ISO 180	23°C
Charpy Impact Strength, unnotched	96	KJ/m^2	ISO 180	23°C
Heat Deflection Temperature	68	°C	ISO 75-2	0.45MPa

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Physical Property	Value	Units	Test Standard	Test Condition
Black Dots <1mm	0	%		Internal
Black Dots 0.5~1mm	<3	%		Internal
Black Dots 0.2~0.5mm	<5	%		Internal

Typical Processing Conditions				
Processing Parameter	**Condition**	**Optimum**	**Range**	**Unit**
Melt Temperature			160 - 200	°C
Holding Pressure			200 - 500	bar
Mould Pressure			60 - 100	MPa
Mould Temperature			30 - 50	°C
Molding Time			30 - 60	s

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