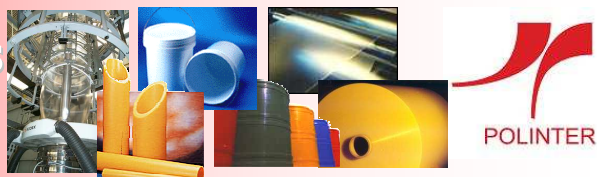


Venelene® Polyethylenes Technical Data Sheet



Venelene® 2707AP HDPE for Injection Moulding

Main Features:

- ◆ Good processability.
- ◆ High flexibility.
- ◆ High ESCR.
- ◆ Good resistance to impact.

Common Applications:

- ◆ Boxes, baskets, pails and industrial parts (high impact, pile up, and chemical resistance requirements).

Processing Conditions:

- ◆ Injection temperature range: 190 – 220 °C .
- ◆ Molding temperature < 20 °C.

Properties	(1)ASTM	Units	Typical value ⁽²⁾
Melt Flow Index (190°C / 2.16 Kg.)	D 1238	g/10 min	5.5
Density	D 792	g/cm ³	0.9490
Designated NORVEN: (Thermoplastic) Covenin (3581)-PE, MH, 48-E045			
General properties ⁽³⁾			
Flexural modulus	D 790	MPa	670
Flexural Strength (5% deformation).	D 790	MPa	19
Tensile Strength at yield	D 638	MPa	22
Tensile Elongation at yield	D 638	%	21
Tensile Strength at break	D 638	MPa	30
Tensile Elongation at break	D 638	%	> 1200
Gardner Impact resistance	D 5420	KJ/m	9
VICAT Temperature	D 1525	°C	125
ESCR ⁽⁴⁾ (F 50 / 10% Igepal)	D 1693	h	4.5
Additives:			
Antioxidants		Standard	
Processing aid Additives		N/A	
UV Stabilizers		N/A	

(1) COVENIN - ASTM standards equivalency: Density Covenin 461-96; Melt Flow Index Covenin 1152-93; Tensile Mechanical Properties Covenin 1357-79. Vicat temperature 479-77.

(2) Reported typical values are obtained from laboratory test. Values should be used as a commercial guide, not as guaranty or specification data.

(3) The proprieties were evaluated under test tube molded by injection under the next conditions: temperature profile 200-210°C; Injection pressure 800 Bar; second phase pressure 600 bar, Molding temperature: 60 °C. Both the mechanical properties and the ESCR depend on the processing conditions.

(4) ESCR: Environmental Stress Cracking Resistance.

User Advice: The information provided, to the best knowledge at the time of the publication, is true and accurate. However, POLIOLEFINAS INTERNACIONALES disclaim any liability for the consequences derived from the information uses.

This product meets Venezuelan Sanitary Ministry and FDA requirements for food contact, including cooking applications.