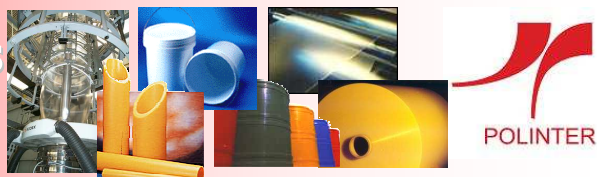


# Venelene® Polyethylenes Technical Data Sheet



## Venelene® 2815 HDPE for Injection Moulding

### Main Features:

- ◆ Good processability.
- ◆ Good rigidity.

### Common Applications:

- ◆ Thin wall containers, lids, caps, closures, and house ware products.

### Processing Conditions:

- ◆ Injection temperature range: 150 – 190 °C .
- ◆ Molding temperature < 20 °C.

Properties	ASTM <sup>(1)</sup>	Units	Typical value <sup>(2)</sup>
Melt Flow Index (190°C / 2.16 Kg.)	D 1238	g/10 min	55.00
Density	D 792	g/cm <sup>3</sup>	0.9530
Designated NORVEN: (Thermoplastic)Covenin (3581)-PE, MH, 53-E700			
General properties <sup>(3)</sup>			
Flexural modulus	D 790	MPa	650
Flexural Strength (5% deformation).	D 790	MPa	19
Tensile Strength at yield	D 638	MPa	21
Tensile Elongation at yield	D 638	%	19
Tensile Strength at break	D 638	MPa	12
Tensile Elongation at break	D 638	%	> 200
Gardner Impact resistance	D 5420	KJ/m	4
VICAT Temperature	D 1525	°C	125
ESCR <sup>(4)</sup> ( F 50 / 10% Igepal)	D 1693	h	< 1.0
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 160-180°C; Injection pressure 70 Bar; second phase pressure 500 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.