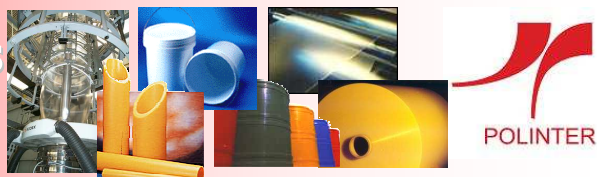


Venelene® Polyethylenes Technical Data Sheet



Venelene® 7700M HDPE for Pipe Extrusion

Main Features:

- ◆ Good processability, rigidity, Impact resistance.
- ◆ Good ESCR
- ◆ Classification PE 100 according to ISO 9080
- ◆ Classification 345546A according to ASTM D3350

Common Applications:

- ◆ Water transportation pipes (Main and service water distribution pipes, gas and drain).

Processing Conditions:

- ◆ Extrusion Melt temperature: 160 -210°C

Properties	(1) ASTM	Units	Typical value (2)
Melt Flow Index (190°C / 2.16 - 21.6 Kg.)	D 1238	g/10 min	0.045 - 13
Density	D 792	g/cm ³	0.9495
Designated NORVEN: (Thermoplastic) Covenin (3581)-PE, EBH, 53-E000			
General properties (3)			
Flexural modulus	D 790	MPa	950
Flexural Strength (5% deformation)	D 790	MPa	15
Tensile Strength at yield	D 638	MPa	26
Tensile Strength at break	D 638	MPa	30
Elongation at break	D 638	%	> 1500
Toughness	D 638	MPa	300
Impact resistance Gardner	D 5420	KJ/m	9
VICAT Temperature	D 1525	°C	128
ESCR ⁽⁴⁾ (F 50 / 10% Igepal)	D 1693	h	> 1000
PENT	F 1473	h	> 150
Oxidative Induction Time (OIT)	D 3895	min	> 100
Additives:			
Antioxidants		Standard	
Processing aid Additives		N/A	
UV Stabilizers		Standard	

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

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

(3) Las propiedades fueron evaluadas sobre probetas moldeadas por compresión bajo las siguientes condiciones: Temperatura de moldeo 190°C; Presión de moldeo 180 KN; Tiempo de moldeo 11 min; Tiempo de enfriamiento 7 min. 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.