

Product Description

EL-Lene H5818J is a general purpose high density polyethylene resin suitable for using in injection molding process. This good flowability grade designed for high productivity requirement.

Typical Application

- General injection parts
- Household product, Office article
- Bottle cap and closure, Toy

Product Characteristics

- Excellent processibility
- Good impact resistance
- Food contact applicable (Complies with U.S FDA 21 CFR 177.1520)

Physical Properties

Property	Test Method	Value	Unit
Melt Flow Rate	ASTM D 1238 @ 190°C, 2.16 kg	18	g/10 min
Density	ASTM D 1505	0.962	g/cm ³
Tensile Strength at Yield	ASTM D 638 @ Crosshead speed 50 mm/min	280	kg/cm ²
Tensile Strength at Break	ASTM D 638 @ Crosshead speed 50 mm/min	160	kg/cm ²
Elongation at Break	ASTM D 638 @ Crosshead speed 50 mm/min	150	%
Flexural Modulus	ASTM D 790	13000	kg/cm ²
Notched Izod Impact	ASTM D 256 @ 23°C	2.5	kg.cm/cm
Hardness	ASTM D 2240	66	Shore D
ESCR	ASTM D 1693 @ 50°C (Condition B, Compression Molded, 25% Igepal)	2	hrs, F ₅₀
Melting Point	ASTM D 2117	131	°C
Vicat Softening Point	ASTM D 1525	122	°C
Heat Deflection Temperature (HDT)	ASTM D 648 @ 4.6 kg/cm ²	75	°C
Brittleness Temperature	ASTM D 746	- 60	°C
% Shrinkage (2mmt) MD	TPE Method	2.02	%
TD	TPE Method	2.46	%

Note : Conversion factor for changing unit from kg/cm² to MPa is divided by 10.20

Processing Techniques

The actual processing conditions depend on each machine type, product size, mold design and environment.

Recommended processing conditions:

Melt temperature: 200-250°C	Mold temperature: 20-60°C	Injection speed: Fast	Screw speed 40-70 rpm
Pressure: Injection 30-70%,	Packing and Holding 30-50%,	Back 10%	of Max. Pressure

Product Available Form

- Pellet

Product Handling

- 25 kg loose bag
- Big Bag with specified weight

Product Technical Assistance

For technical assistance or further information on this product or any other EL-Lene products, please contact EL-Lene representatives.

The information presented in this data sheet is offered in good faith. SCG Plastics Co., Ltd. accepts no responsibility for the accuracy or interpretation of the information presented. The users have to establish for yourself the most suitable formulation, production method and control tests, to ensure the uniformity and quality of your product in compliance with all related laws.