



Technical Data Sheet

Grade

MWR HDPE 6300

Product Description:

High Density Polyethylene Injection Grade

Physical Properties	Method	English	SI
Specific Gravity	D 792	-	0.950
Melt Flow Rate (190/2.16)	D 1238	-	20 g/10 minutes
Linear Mold Shrinkage (Typical)	D 955	0.020 in/in	0.020 mm/mm

Mechanical Properties	Method	English	SI
Tensile Strength at Yield	D 638	3500 psi	24.14 Mpa
Tensile Elongation at Break	D 638	250 %	250 %
Izod Impact (notched)	D 256	1.0 ft-lb/in	50 J/m
Hardness (Shore)	D 2240	65 D	65 D

Thermal Properties	Method	English	SI
Heat Deflection Temperature at 66 psi	D 648	157 F	69 C

Processing (Injection Molding)	English	SI
Drying Temperature	170 F	77 C
Drying Time	3 hrs	3 hrs
Max Moisture Content	0.20 %	0.20 %
Rear Barrel Temperature	390 F	199 C
Middle Barrel Temperature	400 F	204 C
Front Barrel Temperature	410 F	210 C
Nozzle Temperature	410 F	210 C
Stock Temperature	410 F	210 C
Mold Temperature	90 F	32 C

Comments:

Drying typically not required

Values shown are averages and not to be construed as specifications.

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