

**Product Description**

EL-Lene H6430BM is a high density polyethylene resin suitable for producing beverage bottles by using Extrusion blow molding machine.

Typical Application

- Drinking water bottles, Water drums
(Containing volume up to 20 liter)
- Fruit juice bottles
- Milk bottles
- Fish sauce gallons

Product Characteristics

- Excellent stiffness
- Odorless
- Good processability
- Good printability
- 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	0.40	g/10 min
HLMI	ASTM D 1238 @ 190°C, 21.6 kg	30	g/10 min
Density	ASTM D 1505	0.966	g/cm ³
Tensile Strength at Yield	ASTM D 638 @ Crosshead speed 50 mm/min	300	kg/cm ²
Tensile Strength at Break	ASTM D 638 @ Crosshead speed 50 mm/min	370	kg/cm ²
Elongation at Break	ASTM D 638 @ Crosshead speed 50 mm/min	1200	%
Flexural Modulus	ASTM D 790	15000	kg/cm ²
Notched Izod Impact	ASTM D 256 @ 23°C	25	kg.cm/cm
Hardness	ASTM D 2240	70	Shore D
ESCR	ASTM D 1693 @ 50°C (Condition B, Compression Molded, 25% Igepal)	24	hrs, F ₅₀
Melting Point	ASTM D 2117	132	°C
Vicat Softening Point	ASTM D 1525	128	°C
Brittleness Temperature	ASTM D 746	< - 60	°C

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

Processing Techniques

The actual extrusion condition depends on type of using machine, size and wall thickness of product required. Generally, melt temperature should be 180-200°C. 5-8 bar of blowing pressure is recommended. In some cases, enlargement of die and pin diameter (15-30%) may be suggested for increasing parison diameter.

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.

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