



Prime HDPE 250 is a fractional melt with a density of .950 - .962 and a melt index of .2 - .3. Our Prime HDPE 250 offers characteristics such as good stiffness and stress crack resistance. Along with being light weight and tough, it is an ideal selection for many interior or exterior parts.



## PRIME HDPE 250

Prime HDPE 250	Very High	High	Avg.
Impact Strength	*		
Low Temperature Impact Strength	*		
Tensile Strength		*	
Flexural Modulus			*
Heat Deflection Temperature			*

Property	Test Method	Value	Unit
Specific Gravity	D792	.955	
Melt Flow	D-1238	.25	g/10min
Tensile @ Yield	D-638	4,000	psi
Ultimate Elongation	D-638	600	%
Flexural Modulus	D-790	200,000	psi
HDT @ 66 psi	D-648	165	°F
Vicat Softening Point	D-1525	261	°F
ESCR, Cond A, F <sub>50</sub>	D-1693	45	hr.
CLTE	696 Modified	8 x 10 <sup>-5</sup>	in/in/°F
Brittleness Temperature	D-746	<-103	°F

Complies with FDA Regulations 21 CFR 177.1520 Complies with UL 94 HB @ thickness >.015 in. Natural Only!

### Applications:

Prime HDPE 250 is ideal for forming trays, food packaging, small dunnage, or any other parts that requires cold temperature impact. It also works well for small lawn tractor parts, and many other small tool components.

### Finishing:

Prime HDPE 250 may be drilled, routed, punched, sawed, die cut, laser cut, or cut using water jet. Mechanical fasteners and screws may be used. Contact the 3M company for information on bonding. Caution, the CLTE is higher than other thermo-plastic materials.

### Processing:

This is a crystalline material, therefore it requires more attention than an amorphous material. It is recommend that it be formed On an aluminum tool that is temperature controlled, grit blasted and with a moat on the outside of the trim line. The forming temperature should be 300–350°F. The tool temp. should be 160–190°F.

### Colors, Textures and Capabilities:

Prime HDPE 250 can be color matched to meet your specific requirements. Prime HDPE 250 is offered in thicknesses of .015 - .425 and widths of up to 169". Textures include; RM, H/C, Levant II, and Seville.

Please contact your Primex Plastics representative for more information on finishing, fabricating, or the thermoforming process.

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