



PRODUCT: HEMP ETHYLENE (HD) 25%

Description:

H25CHDPE1 is a 25% hemp filled polyethylene (HDPE). This product is generally used in injection molding, but may be used for other forming methods as developed by individual users. HEMP ETHYLENE is designed to be a drop-in replacement for conventional fossil fuel based polymers.

Natural color is medium brown; pelletized. Refer to molding recommendations below; limiting back pressure and injection speed as much as process will allow is optimal for working with this material.

<u>Property:</u>	<u>Typical Value:</u>	<u>Units:</u>	<u>Test Method:</u>
Specific Gravity	1.005	g/cc	ASTM D 792
Tensile Strength @ Break	460	psi	ASTM D 638
Tensile Elongation @ Break	34%	%	ASTM D 638
Flexural Modulus (2% secant)	115,300	psi	ASTM D 790
Melt Flow Index, 230C/2.16Kg	11.9	g/10 min	ASTM D 1238
Izod Impact	1.85	ft. lbs/in	ASTM D 256
Garner Impact	28	ft*lbs	ASTM D 5420

UNDER REVIEW

General Recommendations:

<u>Temperatures (F)</u>		<u>Pressures</u>		<u>Other</u>
Back	270 - 330	Injection	Moderate	Injection Rate: Moderate
Middle	300 - 340	Hold	Moderate – High	Screw Speed: Moderate-Fast
Front	300 - 340	Back	Moderate	
Nozzle	310 - 370			Pre-drying is recommended before molding to avoid potential for splay
Mold	80 - 100			

Data are obtained from tests performed under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

This information serves only as a guideline for processors, users and manufacturers. Due to the complex nature of design and processing, observation on a "trial and error" basis may be required to achieve desired results.

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