



HYPEL™ HIGH DENSITY POLYETHYLENE TYPICAL PROCESSING CONDITIONS†

INJECTION MOLDING

The following molding conditions are recommended starting points for HypeL™ High Density Polyethylene resins. Some modifications may be required depending on the specific molding equipment and part configuration.

PARAMETER	
Rear Temp (°F)	350-390
Center Temp (°F)	380-440
Front Temp (°F)	400-460
Nozzle Temp (°F)	400-450
Mold Temp (°F)	60-120
Screw Rotation	Medium
Screw Back Pressure (psi)	0-100

†The data listed here fall within the normal range of product properties, but they should not be used to establish specification limits or used alone as a basis for design. This information is not intended as a warranty of any kind. Buyers must make their own representative test and assume all risks of use, whether used alone or in combination with other products. ENTEC POLYMERS, LLC assumes no obligation or liability of any advice furnished by it or results obtained with respect to these products. All warranties expressed or implied including warranties of merchantability for a particular purpose or use are excluded and disclaimed. ENTEC POLYMERS, LLC assumes no liability for use of products in infringement of any patent. The foregoing limitation of remedy and exclusion of liability is reflected in and is part of the consideration for the price at which the products are sold by ENTEC POLYMERS, LLC. All data displayed herein has been obtained via testing of injection-molded specimens of natural color. Pigmentation may affect certain properties to various degrees.



ENTEC ENGINEERED RESINS

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