

# H25CHDPEB1 — TECHNICAL DATA SHEET

## PRODUCT: HEMP BIO-ETHYLENE (HD) 25%

**Description:** H25CHDPEB1 is comprised of hemp and polyethylene (HDPE) made from renewable raw material. 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 us medium brown; pelletized. Refer to molding recommendation below: limiting back pressure and injection speed will allow optimal processing conditions.

Property	Typical Value	Units	Test Method:
Specific Gravity	1.0242	g/cc	ASTM D 792
Tensile Strength @ Break	2,349	psi	ASTM D 638
Tensile Elongation @ Break	9.03	%	ASTM D 638
Flexural Modulus (2% secant)	157,900	psi	ASTM D 790
Melt Flow Index, 230C/2.16Kg	13.94	g/10 min	ASTM D 1238
Izod Impact	0.596	ft. lbs/in	ASTM D 256
Gardner Impact	<20	ft*lbs	ASTM D 5420

## GENERAL RECOMMENDATIONS

### TEMPERATURES (F)

Back	270 – 330
Middle	300 – 340
Front	300 – 340
Nozzle	310 – 370
Mold	80 - 100

### PRESSURES

Injection	Moderate
Hold	Moderate – High
Back	Moderate

### OTHER

Injection Rate:	Moderate
Screw Speed:	Moderate – Fast
Pre-drying is recommended before molding to avoid potential for splay	

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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