



Caltex PE 6060HF

GS Caltex - High Density Polyethylene

General Information

Product Description

6060HF is a polyethylene product suitable for injection molding. This material is polymerized with a Ziegler-Natta catalyst and it is designed for injection molded products that require excellent ESCR and high fluidity. It is especially used for pallet, cartridge.

Features:

- High Fluidity
- Good Stiffness

Typical Customer Applications:

- Pallet
- Tote Box
- Cartridge
- Pail

General

Features	• Good Stiffness	• High ESCR (Stress Crack Resist.)	• High Flow
Uses	• Pails	• Pallets	• Tool/Tote Box
Processing Method	• Injection Molding		

Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density	0.959 g/cm ³	0.959 g/cm ³	ASTM D1505
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	6.5 g/10 min	6.5 g/10 min	ASTM D1238
Environmental Stress-Cracking Resistance (ESCR)			ASTM D1693B
100% Igepal, F50	10.0 hr	10.0 hr	
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength (Yield)	4350 psi	30.0 MPa	ASTM D638
Tensile Elongation (Break, 73°F (23°C))	> 500 %	> 500 %	ASTM D638
Flexural Modulus	210000 psi	1450 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact (73°F (23°C))	1.2 ft·lb/in	65 J/m	ASTM D256
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Vicat Softening Temperature	261 °F	127 °C	ASTM D1525

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Hopper Temperature	104 to 176 °F	40 to 80 °C
Rear Temperature	374 to 410 °F	190 to 210 °C
Middle Temperature	374 to 428 °F	190 to 220 °C

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Injection	Typical Value (English)	Typical Value (SI)
Front Temperature	392 to 464 °F	200 to 240 °C
Nozzle Temperature	410 to 482 °F	210 to 250 °C
Processing (Melt) Temp	374 to 482 °F	190 to 250 °C
Mold Temperature	77 to 122 °F	25 to 50 °C
Injection Pressure	1160 to 2180 psi	8.00 to 15.0 MPa
Holding Pressure	290 to 1160 psi	2.00 to 8.00 MPa
Back Pressure	145 to 290 psi	1.00 to 2.00 MPa