



CRYSTALADD® HM-664

Ravago Manufacturing Americas - High Density Polyethylene

Tuesday, November 5, 2019

General Information

Product Description

NUCLEATOR MASTERBATCH

HM-664 is an additive concentrate containing Milliken's Hyperform® HPN-210M nucleator. This masterbatch compound is designed to reduce cycle time in injection molded polyethylene parts, improve stiffness and HDT, and reduce or improve warpage challenges during processing.

Key Features:

- Designed to be added to injection molded polyethylene parts
- Improved stiffness, HDT and part uniformity
- Uniform concentration of additives in concentrate form.
- Masterbatch pellet form for ease of addition and feeding into extrusion equipment

Directions for Use:

- HM-664 is added to HDPE or LLDPE at 2.5% to 5% to achieve faster cooling, higher crystallization temperature and a higher crystallization rate. Parts are ejected from the mold with at a higher overall temperature but will have more completed crystal formation, allowing for a reduced overall cycle time.
- Note: Effectiveness is significantly reduced in LDPE due to the high long chain branching of the polymer. LDPE with MI > 25 can present some of the above performance improvements.

FDA Compliance:

- This product is not approved for use in food contact applications at this time, but will be updated once regulatory tests are completed.

General

Material Status	• Commercial: Active		
Availability	• North America		
Uses	• Masterbatch		
Forms	• Pellets		
Processing Method	• Blow Molding	• Film Extrusion	
	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	0.950	g/cm ³	ASTM D792
Melt Mass-Flow Rate (190°C/2.16 kg)	8.2	g/10 min	ASTM D1238
Additional Information	Nominal Value	Unit	Test Method
Nucleating Agent - HPN-210M	4.0	%	Internal Method
Polymer Base	HDPE		

Notes

¹ Typical properties: these are not to be construed as specifications.