

**F 7665**
**High Density Polyethylene for Blow Moulding Applications**

Safrene® F 7665 High Density Polyethylene Resin is a medium molecular mass grade with good processing properties. It exhibits a good surface finish with high hardness and rigidity.

Safrene® F 7665 High Density Polyethylene Resin is recommended for milk and fruit juice bottles as well as other general purpose bottle applications up to 5 litre where good stiffness is required but environmental stress-crack resistance is not critical.

**Typical Applications**

- Milk and fruit juice containers
- Toiletry containers
- Household goods containers

PROPERTIES <sup>(1)</sup>	VALUE	UNIT	TEST METHOD
<b>Physical</b>			
Melt Flow Rate, 190 °C/ 5 kg	2.0	g/10min	ISO 1133
Melt Flow Rate, 190 °C/ 2.16 kg	0.45	g/10min	ISO 1133
Density <sup>(2)</sup>	0.956	g/cm <sup>3</sup>	ISO 1183
<b>Mechanical<sup>(3)</sup></b>			
Hardness Shore D	64	Units	ISO 868
Tensile Yield <sup>(4)</sup>	27	MPa	ISO 527
Ultimate Tensile <sup>(4)</sup>	38	MPa	ISO 527
Ultimate Elongation <sup>(4)</sup>	>600	%	ISO 527
Flexural Stress (3.5% Deflection)	22	MPa	ISO 178
<b>Impact<sup>(3)</sup></b>			
Charpy Notched Impact Strength (23 °C)	11	kJ/m <sup>2</sup>	ISO 179
Charpy Notched Impact Strength (-30 °C)	8	kJ/m <sup>2</sup>	ISO 179
<b>Thermal</b>			
Vicat Softening Point, Load 5kg	77	°C	ISO 306
Crystalline Melting Range	130-133	°C	ISO 3146-85

(1) Typical values; not to be construed as specification limits.

(2) Unannealed

(3) Compression moulded samples

(4) Test speed 50 mm/min

Typical processing conditions	Blow Moulding
Feed Zone (°C)	160 - 180
Zone1 (°C)	170 - 190
Zone 2 (°C)	180 - 200
Zone 3 (°C)	180 - 190
Die (°C)	190 - 200
Melt Temp (°C)	190 - 200

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<p><b>Food Contact Compliance</b></p>	<p>Safrene® F 7665 High Density Polyethylene Resin should comply with Commission Regulation (EU) No 10/2011 and with U.S. FDA 21 CFR 177.1520(c)3.1c food contact regulations when used unmodified and processed according to good manufacturing practices for food contact applications. The purchaser remains responsible for determining whether the use complies with all relevant regulations.</p>
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