



# Interfacial Solutions

Power Through Technology™

## Product Data Sheet & General Processing Conditions for Expanded Micronized Ash and HDPE

### PROPERTIES AND AVERAGE VALUES FOR INJECTION MOLDED SPECIMENS

Property	% Micronized Ash				Units
	0	10	20	30	
Specific Gravity	0.94	1.01	1.06	1.10	g/cm <sup>3</sup>
Tensile Strength	NA	3.15	3.04	2.93	kpsi
Tensile Modulus	NA	147	168	189	kpsi
Elongation at Break	NA	17.2	15.6	15.3	%
Flexural Strength	5.35	4.29	5.13	5.30	kpsi
Flexural Modulus	168	163	202	233	kpsi
Izod Impact Strength (notched)	10.52	2.00	0.93	1.02	ft-lb/in
Izod Impact Strength (unnotched)	>30	27.34	26.65	25.61	ft-lb/in

### GENERAL PROCESSING FOR INJECTION MOLDING

Injection Pressure	500 psi
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Barrel Temperature	380 – 410 °F
Mold Temperature	90-150 °F
Drying	2 hr @ 200 °F

This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a “trial and error” basis may be required to achieve desired results.

Data are obtained from specimens molded 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.

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<b>% Expanded Micronized Ash</b>	<b>Total Price of Compound (\$/lb)</b>
0	0.87
10	0.94
20	1.01
30	1.08
40	1.15
50	1.22
60	1.29
70	1.36
80	1.52
90	1.43
100	1.50