

AlkateQ™ POLYETHYLENE

ENGINEERING THERMOPLASTIC

AlkateQ™ IS A REGISTERED TRADEMARK OF MARPLEX AUSTRALIA PTY. LTD.

ALKATEQ™ MDA690

ALKATEQ™ MDA690 is a high density polyethylene extrusion grade offering an excellent balance of processability, high impact strength, rigidity and ESCR.

Applications include extruded profiles.

Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ALKATEQ™ MDA690UV]

	<u>CONDITIONS</u>	<u>UNITS</u>	<u>TYPICAL VALUES</u>	<u>TESTING METHODS</u>
<u>1. Physical Properties</u>				
Melt Flow Rate	190°C, 5.0 kg	g/10 min	0.45	ASTM D1238
Specific Gravity		g/cm ³	0.95	ASTM D792
Hardness, Shore D	3.2 mm, 0 sec	D	63	ASTM D2240
<u>2. Mechanical Properties</u>				
Notched Izod Impact (RT)	12.7 mm x 3.2 mm	J/m	500	ASTM D256
Tensile Strength	12.7 mm x 3.2 mm @ 50mm/min	MPa	28	ASTM D638
Tensile Modulus	12.7 mm x 3.2 mm @ 50mm/min	Mpa	1175	ASTM D638
Flexural Strength	12.7 mm x 3.2 mm @ 10.0mm/min	MPa	26	ASTM D790
Flexural Modulus	12.7 mm x 3.2 mm @ 10.0mm/min	MPa	815	ASTM D790

All test results were obtained using pigmented experimental material.

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Material Safety Data Sheet (MSDS): Code 50351

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TYPICAL PROCESSING CONDITIONS

ALKATEQ™ MDA690

The following typical guidelines are offered as initial processing conditions for **ALKATEQ™ MDA690**. In practice, processing parameters may need to be varied to give commercially acceptable performance in conjunction with optimum physical properties. For specific technical advice on part design or processing conditions, contact the Marplex Technical Service Department.

Temperature of pellet bed in dehumidifying drier	60 - 70°C
Minimum drying time at desired pellet bed temp	2 - 3 hours
Required stock temperature	180 - 240°C

Comment(s):

- 1 Cleanliness of the dryer, machine hopper and machine screw/barrel/die head assembly are essential for processing ALKATEQ™ HD176UV and producing contamination free products.
- 2 ALKATEQ™ HD176UV is not compatible during processing with other polymers.
- 3 It is suggested that the pre-drying, die head and material temperatures are manually confirmed using a hand held temperature measuring device.

Conversions:

- 1 MPa = 145 psi
- = 10.2 kg/cm²
- = 10 bar
- °C = 5(F-32)/9
- 1 kN/cm² = 0.65 ton/in²