versalis

Technical Data Sheet

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PHARMALENE®

HDPE

ML 70 PH

High density polyethylene

Pharmalene ML 70 PH is a high density polyethylene (HDPE, C6-comonomers) with antioxidants, obtained by gas phase technology. It is produced in conformity to the good manufacturing practices (GMP) and is mainly used for injection moulding.

Main Application

Pharmalene ML 70 PH is intended for the use within pharmaceutical sector and is characterized by high impact and creep resistance as well as a good ESCR.
Pharmalene ML 70 PH is suitable for the production of caps & closures.

Main Properties

Resin Properties	Value	Unit	Test Method
Melt Flow Rate (190 °C/2,16 kg)	2,8	g/10min	ISO 1133
Melt Flow Rate (190 °C/5 kg)	8	g/10min	ISO 1133
Melt Flow Rate (190 °C/21,6 kg)	-	g/10min	ISO 1133
Density	0,951	g/cm3	ISO 1183
Melting point	131	°C	Metodo interno
Brittleness temperature	< -60	°C	ASTM D 746
Vicat softening point (1 kg)	125	°C	ISO 306/A

Mechanical Properties *	Value	Unit	Test Method
Tensile stress at yield	25	MPa	ISO 527
Tensile stress at break	20	MPa	ISO 527
Elongation at break	800	%	ISO 527
Flexural modulus	1100	MPa	ISO 178
Hardness Shore D	64	-	ISO 868 A
Falling Weight	-	J/mm	ISO 6603-2
Izod impact strength, notched	200	J/m	ISO 180/A
ESCR **	-	h	ASTM 1693/B

(*) Values are referred to compression moulded specimens. Actual properties are typical and may vary depending upon operating conditions.

Pharmalene® is a registered trademark of Versalis

Processing notes

Pharmalene ML 70 PH is readily processable by conventional injection moulding equipment.

Typical processing conditions (*):
Temperature profile of the barrel (°C) 220 - 275
Temperature of the mould (°C) 10 - 40

(*) Processing conditions depend on several parameters: the shape of the part to be manufactured, the localisation of the injection point, the injection moulding machine and the cooling of the mould.

Storage and Handling

Pharmalene ML 70 PH is supplied in pellet form. This material may readily be conveyed and bulk fed through equipment designed for conventional pelletised polyethylene resin, provided the equipment is designed to prevent accumulation of fines and dust particles that are contained in all polyethylene resins. These fines and dust particles can, under certain conditions, pose an explosion hazard. We recommend that the conveying system used, is equipped with filters of adequate size, operated and maintained in such a manner to ensure that no leaks develop and earthed adequately. We further recommend, that good housekeeping should be practised throughout your facility.
Shelf Life: Polyethylene can be stored over a long period of time, as long as it is stored protected from solar irradiation, in a ventilated, dry and cool place, with a temperature kept below 50°C. Any exposure of the material to solar irradiation, reinforced by higher temperatures, has a detrimental impact on the product quality and can induce a degradation, which goes on subsequently.
We guarantee that Versalis Pharmalene® products keep complying with Versalis sales specification for 2 years after date of delivery under the recommended storage conditions. This statement does not prevent user performing MFR and density tests on the incoming material and every year for quality evaluation.
Ensuring a consistent material quality, we strongly recommend to follow the above mentioned handling and storage conditions for all Pharmalene® products. In case of non-respect of these storage precautions, Versalis cannot be held liable to any quality problem related to inappropriate handling and storage of the material and shelf-life can be altered.
Before using this product it is recommended to refer to the relevant Safety Data Sheet (SDS) for more detailed information.

Availability

Contact the Versalis sales office nearest to you regarding availability and your specific application requirements.

Food Contact and Pharmacopoeia Status

Pharmalene ML 70 PH complies with the European Union (Reg. 10/2011) and the USA (FDA) rules, related to the use of plastic materials intended for contact with foodstuffs. The composition of our product is compliant to the relevant sections of the European Pharmacopoeia (10th ed.) and those of the U.S. Pharmacopoeia (USP 42). Certificates of compliance are available upon request.

Technical Management Polyethylene Pharmalene

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DISCLAIMER: It is the responsibility of the user to verify the technical suitability and the safe and regulatory compliant usage of this product in all medical and pharmaceutical applications. If a usage of this product in applications of the pharmaceutical and medical sector, such as Class I, IIa, IIb or III Medical Devices (U.S. FDA, Health Canada and/or EU Directive 2007/47/EC) and in applications involving permanent implantation into the human body, is intended, user must consult Versalis to receive prior written approval for each specific product and applications.

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