



# PRIME 5000 LDPE

PRIME 5000 is a low density polyethylene designed for general thermoforming applications requiring a soft and flexible material.

Property	Unit	ISO	Value
<b>PHYSICAL</b>			
Density	g/cc	1183	0.94
Melt Flow (190°C/2.16kg)	g/10min	118	0.2-0.4
<b>MECHANICAL</b>			
Impact strength	kJ/m	23°C	ASTM D4272 42
Strength @ yield	MPa	50mm/min	527/3 11
Stress @ break	MPa		527/3 28
Elongation @ break	MPa		527/3 >500
Modulus of elasticity	MPa		527/3 200
Shore 'D' Hardness			868 49
Tear strength	kN/m		6383/2 30
<b>THERMAL</b>			
VST@10N (VST/A)	°C		306 93
<b>FLAMMABILITY RATING</b>			
Horizontal burn	1.5mm+	UL94	HB

## Finishing

Aluminium tool construction is recommended with a temperature control function to ensure consistent moulding & finished part dimensional tolerances. A constant tool temperature (typically 75°C for PRIME 5000) should be maintained throughout the production run. Cooling using air or water spray will speed up the cooling cycle to provide efficient production output. Once removed from the tool, it is recommended that the component is clamped in a frame for a short period to optimise dimensional stability & reduce the risk of warping. Shrinkage rates are available on application.

## Colour, Textures, Capabilities

PRIME 5000 is available in a full range of colours (subject to minimum order quantities) either colour matched to specific colour references, or to customer sample. A range of more standard colours is available for non-specific requirements. PRIME 5000 is available with a smooth or with a textured finish. Emboss swatches are available on request.

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