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Standard Specification for Polyethylene Plastics Molding and Extrusion Materials¹

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INTRODUCTION

This specification is not intended for the selection of materials, but only as a means to call out plastic materials to be used for the manufacture of parts. The selection of these materials is to be made by personnel with expertise in the plastics field where the environment, inherent properties of the materials, performance of the parts, part design, manufacturing process, and economics are considered. This specification does not specify the source of the resin to be used for the fabrication of any given article.

1. Scope*

1.1 This specification provides for the identification of polyethylene plastics molding and extrusion materials in such a manner that the supplier and the user can agree on the acceptability of different commercial lots or shipments. The tests involved in this specification are intended to provide information for identifying materials in accordance with the groups, classes, and grades covered. It is not the function of this specification to provide specific engineering data for design purposes.

1.2 Other requirements may be necessary to identify particular characteristics important to specialized applications. These shall be agreed upon between the user and the supplier, by using the suffixes given in Section 1.3.

1.3 Ethylene plastic materials, being thermoplastic, are reprocessable and recyclable (see **Note 1**). This specification allows for the use of those ethylene plastic materials, provided that any specific requirements as governed by the producer and the end user are met.

NOTE 1—See Guide **D 5033** for information and definitions related to recycled plastics.

1.4 The values stated in SI units are regarded as the standard.

1.5 The following precautionary caveat pertains to the test method portion only, Section 12, of this specification. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user*

of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

1.6 For information regarding plastic pipe materials see Specification **D 3350**. For information regarding wire and cable materials, see Specification **D 1248**. For information on polyethylenes with densities below 0.910 g/cm^3 , see Classification **D 5593**.

NOTE 2—There is no similar or equivalent ISO standard.

2. Referenced Documents

2.1 ASTM Standards:²

- D 257 Test Methods for D-C Resistance or Conductance of Insulating Materials
- D 568 Test Method for Rate of Burning and/or Extent and Time of Burning of Flexible Plastics in a Vertical Position³
- D 618 Practice for Conditioning Plastics for Testing
- D 635 Test Method for Rate of Burning and/or Extent and Time of Burning of Self-Supporting Plastics in a Horizontal Position
- D 638 Test Method for Tensile Properties of Plastics
- D 790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials
- D 792 Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement
- D 883 Terminology Relating to Plastics
- D 1238 Test Method for Flow Rates of Thermoplastics by

¹ This specification is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.15 on Thermoplastic Materials.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ Withdrawn.

*A Summary of Changes section appears at the end of this standard.

- Extrusion Plastometer
 D 1248 Specification for Polyethylene Plastics Molding and Extrusion Materials
 D 1505 Test Method for Density of Plastics by the Density-Gradient Technique
 D 1531 Test Methods for Relative Permittivity (Dielectric Constant) and Dissipation Factor by Fluid Displacement Procedures
 D 1600 Terminology for Abbreviated Terms Relating to Plastics
 D 1693 Test Method for Environmental Stress-Cracking of Ethylene Plastics
 D 1898 Practice for Sampling of Plastics³
 D 2565 Practice for Xenon Arc Exposure of Plastics Intended for Outdoor Applications
 D 2951 Test Method for Resistance of Types III and IV Polyethylene Plastics to Thermal Stress-Cracking
 D 3350 Specification for Polyethylene Plastics Pipe and Fitting Materials
 D 3892 Practice for Packaging/Packing of Plastics
 D 4000 Classification System for Specifying Plastic Materials
 D 4329 Practice for Fluorescent UV Exposure of Plastics
 D 4703 Practice for Compression Molding Thermoplastic Materials into Test Specimens, Plaques, or Sheets
 D 4883 Test Method for Density of Polyethylene by the Ultrasound Technique
 D 5033 Guide for the Development of Standards Relating to the Proper Use of Recycled Plastics
 D 5593 Classification for Thermoplastic Elastomers—Olefinic (TEO)
 D 6360 Practice for Enclosed Carbon Arc Exposures of Plastics
 E 29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications
 F 1473 Test Method for Notch Tensile Test to Measure the Resistance to Slow Crack Growth on Polyethylene Pipes and Resins
- 2.2 *Military Standard:*
 MIL-STD-105 Sampling Procedures and Tables for Inspection by Attributes⁴
- 2.3 *DOT Standard:*

Federal Motor Vehicle Safety Standard 302, Flammability of Interior Materials⁵

3. Terminology

3.1 *Definitions*—For definitions of technical terms pertaining to plastics used in this specification, see Terminology **D 883** and Terminology **D 1600**.

3.2 Historical usage and user group conventions have resulted in inconsistent terminology used to categorize and describe polyethylene resins and compounds. The following terminology is in use in ASTM specifications pertaining to polyethylene:

3.2.1 *Specification D 1248:*

3.2.1.1 Type (I, II, III, IV) = density ranges (same, respectively, as Classes 1, 2, 3, and 4 in Specification **D 4976**).

3.2.1.2 Class (A, B, C, D) = composition and use.

3.2.1.3 Category (1, 2, 3, 4, 5) = melt index ranges (same as Grade in Specification **D 4976**).

3.2.1.4 Grade (E, J, D, or W followed by one or two digits) = specific requirements from tables.

3.2.2 *Specification D 3350:*

3.2.2.1 Type (I, II, III) = density ranges (same as Types I, II, and III in Specification **D 1248** and Classes 1, 2, and 3 in Specification **D 4976**).

3.2.2.2 Class = a line callout system consisting of “PE” followed by six cell numbers from Table 1 plus a letter (A, B, C, D, E) denoting color and UV stabilizer.

3.2.2.3 Grade = simplified line callout system using “PE” followed by density and slow crack growth cell numbers from Table 1.

3.2.3 *Specification D 4976:*

3.2.3.1 Group (1, 2) = branched or linear polyethylene.

3.2.3.2 Class (1, 2, 3, 4) = density ranges (same, respectively, as Types I, II, III, and IV in Specification **D 1248**).

3.2.3.3 Grade (1, 2, 3, 4, 5) = melt index ranges (same as Category in Specification **D 1248**).

4. Classification

4.1 Unreinforced polyethylene plastic materials are classified into groups in accordance with molecular structure. These groups are subdivided into classes and grades as shown in Table PE (Basic Property Table).

⁴ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

⁵ Available from United States Department of Transportation, National Highway Traffic Safety Administration, Office of Public Affairs and Consumer Participation, 400 7th St., SW, Washington, DC 20590.

TABLE PE Basic Requirement of Polyethylene Plastics

Group	Description	Class	Description	Grade	Flow Rate, D 1238, g/10 min	Tensile Stress at Yield, D 638, min, MPa	Nominal Strain at Break, D 638, min, %	Flexural Modulus at 2 % Strain, D 790, min, MPa		
1	Branched	1	low density	1	>25	8	70	100		
				2	>10 to 25	8	90	125		
				3	>1 to 10	8.5	100	125		
				4	>0.4 to 1	9.5	300	125		
				5	to 0.4	9.5	400	150		
				0		
		2	medium density	1	>25	8	40	200		
				2	>10 to 25	11	50	200		
				3	>1 to 10	11	70	200		
				4	>0.4 to 1	11	200	250		
				5	to 0.4	12	400	300		
				0		
		2	Linear	1	low density	1	>25	10	300	300
						2	>10 to 25	10	300	325
						3	>1 to 10	10	300	350
						4	>0.4 to 1	10	400	350
5	to 0.4					12	500	400		
0		
2	medium density			1	>25	14	90	500		
				2	>10 to 25	14	100	500		
				3	>1 to 10	14	100	550		
				4	>0.4 to 1	15	200	600		
				5	to 0.4	19	400	600		
				0		
3	high density			1	>25	17	10	400		
				2	>10 to 25	17	50	400		
				3	>1 to 10	18	200	450		
				4	>0.4 to 1	19	400	500		
				5	to 0.4	20	600	600		
				0		
4	high density			1	>25	24	10	500		
				2	>10 to 25	24	10	600		
				3	>1 to 10	25	30	800		
				4	>0.4 to 1	28	300	900		
				5	to 0.4	28	400	1000		
				0		
0		0		0		
				0		

Cell Table A Detail Requirements for Polyethylene Plastics

Designation Order Number	Property	Cell Limits									
		0	1	2	3	4	5	6	7	8	9
1	Tensile Stress at Yield, Test Method D 638, MPa, min	unspecified	4	8	12	16	21	30	35	...	specify value
2	Nominal Strain at Break, Test Method D 638, %, min	unspecified	25	50	200	400	600	800	1000	...	specify value
3	Secant Flexural Modulus at 2 % Strain, D 790, MPa, min	unspecified	50	100	200	400	600	800	1000	...	specify value
4	Thermal stress-crack resistance, D 2951, hours without cracking, min	unspecified	24	48	96	168	specify value
5	Environmental stress-crack resistance, D 1693, min F ₅₀ , h	unspecified	24	48	96	168	336	672	1008	...	specify value

Cell Table B Detail Requirements for Polyethylene Plastics

Designation Order Number	Property	Cell Limits									
		0	1	2	3	4	5	6	7	8	9
1	Tensile Stress at Yield, D 638, MPa, min	unspecified	4	8	12	16	21	30	35	...	specify value
2	Nominal Strain at Break, D 638, %, min	unspecified	25	50	200	400	600	800	1000	...	specify value
3	Secant Flexural Modulus at 2 % Strain, D 790, MPa, min	unspecified	50	100	200	400	600	800	1000	...	specify value
4	Thermal stress-crack resistance, D 2951, hours without cracking, min	unspecified	24	48	96	168	specify value
5	Slow Crack Growth Resistance, PENT-Test Method F 1473, h, min	unspecified	0.3	1	3	10	30	100	300	...	specify value