

DOWLEX™ 2070G

Polyethylene Resin

The Dow Chemical Company

Message:

Linear Low Density Polyethylene

High strength in food packaging applications

Good processability at narrow die gaps

Complies with:

U.S. FDA 21 CFR 177.1520 (c) 3.2a

Canadian HPFB No Objection (With Limitations)

EU, No 10/2011

Consult the regulations for complete details.

General Information			
Additive	Processing aid		
	Anti-caking agent (2500 ppm)		
	Sliding agent (1000 ppm)		
Agency Ratings	DMF not rated		
	FDA 21 CFR 177.1520(c) 3.2a		
	HPFB (Canada) No Objection 2		
	Europe No 10/2011		
Forms	Particle		
Processing Method	Blow film		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.922	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	1.0	g/10 min	ASTM D1238
Films	Nominal Value	Unit	Test Method
Film Puncture Resistance			Internal method
20 µm	8.69	J/cm ³	Internal method
51 µm	5.79	J/cm ³	Internal method
Film strength			ASTM D882
MD : 20 µm	76.4	J/cm ³	ASTM D882
MD : 51 µm	99.0	J/cm ³	ASTM D882
TD : 20 µm	89.9	J/cm ³	ASTM D882
TD : 51 µm	97.1	J/cm ³	ASTM D882
secant modulus			ASTM D882
2% secant, MD: 20 µm	183	MPa	ASTM D882
2% secant, MD: 51 µm	192	MPa	ASTM D882
2% secant, TD: 20 µm	211	MPa	ASTM D882

2% secant, TD: 51 µm	228	MPa	ASTM D882
Tensile Strength			ASTM D882
MD: Yield, 20 µm	10.7	MPa	ASTM D882
MD: Yield, 51 µm	10.5	MPa	ASTM D882
TD: Yield, 20 µm	11.4	MPa	ASTM D882
TD: Yield, 51 µm	11.6	MPa	ASTM D882
MD: Break, 20 µm	38.0	MPa	ASTM D882
MD: Fracture, 51 µm	35.6	MPa	ASTM D882
TD: Break, 20 µm	28.0	MPa	ASTM D882
TD: Fracture, 51 µm	29.1	MPa	ASTM D882
Tensile Elongation			ASTM D882
MD: Break, 20 µm	440	%	ASTM D882
MD: Fracture, 51 µm	620	%	ASTM D882
TD: Break, 20 µm	650	%	ASTM D882
TD: Fracture, 51 µm	680	%	ASTM D882
Dart Drop Impact			ASTM D1709A
20 µm	150	g	ASTM D1709A
51 µm	310	g	ASTM D1709A
Elmendorf Tear Strength			ASTM D1922
MD : 20 µm	250	g	ASTM D1922
MD : 51 µm	810	g	ASTM D1922
TD : 20 µm	690	g	ASTM D1922
TD : 51 µm	1200	g	ASTM D1922
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	104	°C	ASTM D1525
Melting Temperature (DSC)	123	°C	Internal method
Optical	Nominal Value	Unit	Test Method
Gloss			ASTM D2457
45°, 20.3 µm	56		ASTM D2457
45°, 50.8 µm	65		ASTM D2457
Haze			ASTM D1003
20.3 µm	11	%	ASTM D1003
50.8 µm	12	%	ASTM D1003
Extrusion	Nominal Value	Unit	
Melt Temperature	218	°C	
Extrusion instructions			

吹塑薄膜的制造条件:

螺杆尺寸:2.5 英寸 (63.5 mm);24:1 L/D

螺杆类型:MC-4 阻隔

模具间隙:40 密尔 (1 mm)

熔体温度:425°F (218°C)

输出:模具周长的 10 磅/小时/英寸

模具直径:6 英寸

放大比:2.5:1

螺杆速度:85 rpm

冷冻线高度:20 英寸 (508 mm)

脱离速度:0.8 密尔为 190 fpm,2.0 密尔为 80 fpm

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