

ELITE™ AT 6402

Enhanced Polyethylene Resin

The Dow Chemical Company

Message:

ELITE™ AT 6402 Enhanced Polyethylene Resin is an ethylene/octene-1 copolymer suitable for the production of blown film requiring good sealing and toughness with good stiffness and temperature resistance.

Main Characteristics

Fully Formulated with Slip, Antiblock and Processing Aid

High Hot Tack and Seal Strength

Broad Hot Tack and FFS Packaging Window

Excellent Stiffness and Toughness Properties

High Throughput Resin with Excellent Bubble Stability

Complies with:

U.S. FDA FCN 424

EU, No 10/2011

Canadian HPFB No Objection

Consult the regulations for complete details.

General Information			
Additive	Processing aid		
	Anti-caking agent (1875 ppm)		
	Sliding agent (750 ppm)		
Agency Ratings	FDA FCN 424		
	HPFB (Canada) No Objection		
	Europe 10/1/2011 12:00:00 AM		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.913	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	0.85	g/10 min	ASTM D1238
Films	Nominal Value	Unit	Test Method
Film Thickness - Tested	25	µm	
Film Puncture Energy (25 µm)	3.32	J	Internal method
Film Puncture Force (25 µm)	48.0	N	Internal method
Film Puncture Resistance (25 µm)	16.5	J/cm ³	Internal method
Secant Modulus - 2% Secant, MD (25 µm)	118	MPa	ASTM D882
Dart Drop Impact (25 µm)	570	g	ASTM D1709
Elmendorf Tear Strength - MD ¹ (25 µm)	230	g	ASTM D1922
Thermal	Nominal Value	Unit	Test Method
Melting Temperature (DSC)	107	°C	Internal method
Optical	Nominal Value	Unit	Test Method
Haze (25.4 µm)	7.4	%	ASTM D1003

Extrusion instructions

Fabrication Conditions For Blown Film:

Monolayer Film (1mil)

Screw Size: 2in ; 30:1ratio L/D

Die Gap: 78mil (2 mm)

Output: 11.3 lb/hr/in. of die circumference

Die Diameter: 9.86 in.

Blow-Up Ratio: 2.5 to 1

Frost Line Height: 36 in.

NOTE

1. Method B

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