

DOW™ LDPE 690 HEALTH+™

Low Density Polyethylene Resin

The Dow Chemical Company

Message:

DOW™ LDPE 690 HEALTH+™ is a Low Density Polyethylene barefoot resin designed for extrusion blow molding, injection blow molding, and blow-fill seal applications with good flexibility, moderate rigidity and good chemical resistance. It is also suitable for medical packaging films.

Main Characteristics:

Good flexibility

Good chemical resistance

Good stiffness

Complies with:

U.S. FDA 21CFR 177.1520 (c) 2.1

USP XXIII Class VI

Drug Master File Listing

Canadian HPFB (No Objections)

EU, No 10/2011

Consult the regulations for complete details.

General Information			
Agency Ratings	DMF not rated		
	FDA 21 CFR 177.1520(c) 2.1		
	HPFB (Canada) No Objection		
	USP Class VI		
	Europe No 10/2011		
Forms	Particle		
Processing Method	Extrusion blow molding		
	Injection blowing molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.920	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.0	g/10 min	ASTM D1238
Films	Nominal Value	Unit	Test Method
Film Thickness - Tested	51	µm	
Film Puncture Resistance (51 µm)	2.90	J/cm ³	Internal method
Film strength			ASTM D882
MD : 51 µm	159	J/cm ³	ASTM D882
TD : 51 µm	185	J/cm ³	ASTM D882
secant modulus			ASTM D882
2% secant, MD: 51 µm	181	MPa	ASTM D882
2% secant, TD: 51 µm	207	MPa	ASTM D882
Tensile Strength			ASTM D882
MD: Yield, 51 µm	12.3	MPa	ASTM D882

TD: Yield, 51 μm	12.1	MPa	ASTM D882
MD: Fracture, 51 μm	24.8	MPa	ASTM D882
TD: Fracture, 51 μm	23.0	MPa	ASTM D882
Tensile Elongation			ASTM D882
MD: Fracture, 51 μm	420	%	ASTM D882
TD: Fracture, 51 μm	670	%	ASTM D882
Dart Drop Impact (51 μm)	150	g	ASTM D1709A
Elmendorf Tear Strength ¹			ASTM D1922
MD : 51 μm	500	g	ASTM D1922
TD : 51 μm	280	g	ASTM D1922
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	98.3	°C	ASTM D1525
Melting Temperature (DSC)	112	°C	Internal method
Optical	Nominal Value	Unit	Test Method
Gloss (45°, 50.8 μm)	66		ASTM D2457
Haze (50.8 μm)	7.6	%	ASTM D1003
Extrusion	Nominal Value	Unit	
Melt Temperature	232	°C	
Extrusion instructions			

吹塑薄膜的制造条件:
 螺杆尺寸:2.5 英寸 (63.5mm);30/1 比率 L/D
 螺杆类型:单跨双混合
 模具间隙:40 密尔 (1.6 mm)
 熔体温度:450°F (199°C)
 输出:模具周长的 7 磅/小时/英寸
 模具直径:6 英寸
 放大比:2.5 比 1
 螺杆速度:60 rpm
 冷冻线高度:25 英寸 (635 mm)

NOTE

1. Method B

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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