

DOW™ LDPE 608A

Low Density Polyethylene Resin

The Dow Chemical Company

Message:

A formulated clarity film resin for thin gauge optical packaging

Optimum gauge range: 0.8 - 2.5 mil

Complies with U.S. FDA 21 CFR 177.1520 (c) 2.2.

Complies with EU, No 10/2011

Consult the regulations for complete details.

General Information			
Agency Ratings	FDA 21 CFR 177.1520(c) 2.2		
	Europe No 10/2011		
Forms	Particle		
Processing Method	Blow film		
	cast film		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.923	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	2.6	g/10 min	ASTM D1238
Films	Nominal Value	Unit	Test Method
Film Puncture Resistance			Internal method
25 µm	3.64	J/cm ³	Internal method
51 µm	3.47	J/cm ³	Internal method
Film strength			ASTM D882
MD: 25 µm, cast film	82.5	J/cm ³	ASTM D882
MD: 51 µm, blown film	186	J/cm ³	ASTM D882
TD: 25 µm, cast film	109	J/cm ³	ASTM D882
TD: 51 µm, blown film	207	J/cm ³	ASTM D882
Tensile Strength			ASTM D882
MD: Yield, 25 µm, extruded film	14.1	MPa	ASTM D882
MD: Yield, 51 µm, blown film	12.5	MPa	ASTM D882
TD: Yield, 25 µm, extruded film	10.3	MPa	ASTM D882
TD: Yield, 51 µm, blown film	12.7	MPa	ASTM D882
MD: Broken, 25 µm, extruded film	27.0	MPa	ASTM D882
MD: Broken, 51 µm, blown film	23.4	MPa	ASTM D882
TD: Broken, 25 µm, extruded film	14.5	MPa	ASTM D882
TD: Broken, 51 µm, blown film	20.6	MPa	ASTM D882
Tensile Elongation			ASTM D882

MD: Broken, 25 µm, extruded film	180	%	ASTM D882
MD: Broken, 51 µm, blown film	580	%	ASTM D882
TD: Broken, 25 µm, extruded film	490	%	ASTM D882
TD: Broken, 51 µm, blown film	780	%	ASTM D882
Dart Drop Impact			ASTM D1709A
25 µm, cast film	72	g	ASTM D1709A
51 µm, blown film	87	g	ASTM D1709A
Elmendorf Tear Strength			ASTM D1922
MD: 25 µm, cast film	140	g	ASTM D1922
MD: 51 µm, blown film	450	g	ASTM D1922
TD: 25 µm, cast film	150	g	ASTM D1922
TD: 51 µm, blown film	430	g	ASTM D1922
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	97.2	°C	ASTM D1525
Melting Temperature (DSC)	113	°C	Internal method
Optical	Nominal Value	Unit	Test Method
Gloss			ASTM D2457
45, 50.8 µm, blown film	81		ASTM D2457
45, 25.4 µm, cast film	87		ASTM D2457
Haze			ASTM D1003
50.8 µm, blown film	5.7	%	ASTM D1003
25.4 µm, cast film	2.2	%	ASTM D1003
Extrusion instructions			

吹塑薄膜的制造条件:

螺杆尺寸:2.5 英寸 (64 mm);30:1 L/D

螺杆类型:单跨双混合

模具间隙:40 密尔 (1.0 mm)

熔体温度:413 °F (212 °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:91 rpm

冷冻线高度:30 分钟 (762 mm)

铸造薄膜的制造条件:

螺杆 A,尺寸:2 英寸 (51 mm);30:1 L/D

熔体温度:500°F (260°C)

螺杆速度:49 rpm

螺杆 B,尺寸:2.5 英寸 (63.5 mm); 30:1 L/D

熔体温度:500°F (260°C)

螺杆速度:30 rpm

螺杆 C,尺寸:2.5 英寸 (63.5 mm);30:1 L/D

熔体温度:500°F (260°C)

螺杆速度:34 rpm

螺杆 D,尺寸:2.5 英寸 (63.5 mm);30:1 L/D

熔体温度:501°F (261°C)

螺杆速度:33 rpm

螺杆 E,尺寸:2 英寸 (51 mm);30:1 L/D

熔体温度:500°F (260°C)

螺杆速度:39 rpm

螺杆类型:DSB II

模具间隙:25 密尔 (0.6 mm)

冷却辊温度:70°F (21°C)

生产线速度:400 fpm(123 米/分)

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