

AFFINITY™ PL 1850G

Polyolefin Plastomer
The Dow Chemical Company

Message:

AFFINITY* PL 1850G Polyolefin Plastomer (POP) is produced via INSITE* Technology. It is designed to provide blown and cast film products with low temperature sealability, excellent optics and good abuse resistance. It has value as a sealant layer in multilayer film structures for dry and liquid packaging.

High performance sealant layer in flexible packaging

Excellent optics, low temperature seal initiation and abuse resistance

Complies with:

U.S. FDA FCN 424

Canadian HPFB No Objectin

EU, No 10/2011

Consult the regulations for complete details.

General Information			
Agency Ratings	FDA FCN 424		
	HPFB (Canada) No Objection		
	Europe No 10/2011		
Forms	Particle		
Processing Method	cast film		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.902	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	3.0	g/10 min	ASTM D1238
Films	Nominal Value	Unit	Test Method
Film Thickness - Tested	20	µm	
Film Puncture Energy (20 µm)	4.28	J	Internal method
Film Puncture Force (20 µm)	47.6	N	Internal method
Film Puncture Resistance (20 µm)	31.4	J/cm ³	Internal method
secant modulus			ASTM D882
2% secant, MD: 20 µm	108	MPa	ASTM D882
2% secant, TD: 20 µm	115	MPa	ASTM D882
Tensile Strength			ASTM D882
MD: Yield, 20 µm	9.93	MPa	ASTM D882
TD: Yield, 20 µm	5.45	MPa	ASTM D882
MD: Break, 20 µm	44.6	MPa	ASTM D882
TD: Break, 20 µm	29.8	MPa	ASTM D882
Tensile Elongation			ASTM D882
MD: Break, 20 µm	350	%	ASTM D882
TD: Break, 20 µm	570	%	ASTM D882
Dart Drop Impact (20 µm)	> 830	g	ASTM D1709B

Elmendorf Tear Strength ¹			ASTM D1922
MD : 20 μm	120	g	ASTM D1922
TD : 20 μm	410	g	ASTM D1922
Seal Initiation Temperature ² (20 μm)	93.9	°C	Internal method
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	85.0	°C	ASTM D1525
Melting Temperature (DSC)	98.0	°C	Internal method
Optical	Nominal Value	Unit	Test Method
Gloss (20°, 20.3 μm)	144		ASTM D2457
Haze (20.3 μm)	0.70	%	ASTM D1003
Extrusion	Nominal Value	Unit	
Melt Temperature	274	°C	
Extrusion instructions			

铸造薄膜的制造条件:

螺杆尺寸:3.5 英寸 (89 mm);32:1 L/D

螺杆速度:10 rpm

螺杆尺寸:2.5 英寸 (63.5 mm);24:1 L/D

螺杆速度:27 rpm

螺杆尺寸:2.0 英寸 (51 mm);24:1 L/D

螺杆速度:46 rpm

螺杆类型:Sterlex,带 Maddock Mixer 的单跨型和单跨型

模具间隙:20 密尔 (0.5 mm)

冷却辊温度:70°F (21°C)

熔体温度:525°F (274°C)

输出:243 磅/小时

生产线速度:600 fpm(183 米/分)

NOTE

1. Modified rectangular test piece.
2. Achieve a temperature of 1 psig (4.4 N/25.4mm) heat seal strength.

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