

DOW™ LDPE 611A

Low Density Polyethylene Resin

The Dow Chemical Company

Message:

A shrink film resin with good optics for packaging applications

Optimum gauge range: 1.0-3.0 mil

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

Complies with U.S. FDA-DMF

Complies with Canadian HPFB No Objections(With Limitations)

Complies with EU, No 10/2011

Consult the regulations for complete details.

General Information			
Additive	Anti-caking agent (1245 ppm)		
Agency Ratings	DMF not rated		
	FDA 21 CFR 177.1520(c) 2.2		
	HPFB (Canada) No Objection 2		
	Europe No 10/2011		
Forms	Particle		
Processing Method	Blow film		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.924	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	0.88	g/10 min	ASTM D1238
Films	Nominal Value	Unit	Test Method
Film strength			ASTM D882
MD : 25 µm	55.1	J/cm ³	ASTM D882
MD : 51 µm	64.5	J/cm ³	ASTM D882
TD : 25 µm	63.7	J/cm ³	ASTM D882
TD : 51 µm	66.9	J/cm ³	ASTM D882
secant modulus			ASTM D882
2% secant, MD: 25 µm	197	MPa	ASTM D882
2% secant, MD: 51 µm	201	MPa	ASTM D882
2% secant, TD: 25 µm	225	MPa	ASTM D882
2% secant, TD: 51 µm	227	MPa	ASTM D882
Tensile Strength			ASTM D882
MD: Yield, 25 µm	11.9	MPa	ASTM D882
MD: Yield, 51 µm	11.8	MPa	ASTM D882
TD: Yield, 25 µm	12.3	MPa	ASTM D882
TD: Yield, 51 µm	12.2	MPa	ASTM D882
MD: Break, 25 µm	25.4	MPa	ASTM D882

MD: Fracture, 51 μm	21.6	MPa	ASTM D882
TD: Break, 25 μm	17.3	MPa	ASTM D882
TD: Fracture, 51 μm	16.9	MPa	ASTM D882
Tensile Elongation			ASTM D882
MD: Break, 25 μm	270	%	ASTM D882
MD: Fracture, 51 μm	370	%	ASTM D882
TD: Break, 25 μm	540	%	ASTM D882
TD: Fracture, 51 μm	560	%	ASTM D882
Dart Drop Impact			ASTM D1709A
25 μm	78	g	ASTM D1709A
51 μm	120	g	ASTM D1709A
Elmendorf Tear Strength			ASTM D1922
MD : 25 μm	190	g	ASTM D1922
MD : 51 μm	400	g	ASTM D1922
TD : 25 μm	180	g	ASTM D1922
TD : 51 μm	450	g	ASTM D1922
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	97.2	°C	ASTM D1525
Melting Temperature (DSC)	112	°C	Internal method
Optical	Nominal Value	Unit	Test Method
Gloss			ASTM D2457
45°, 25.4 μm	71		ASTM D2457
45°, 50.8 μm	76		ASTM D2457
Haze			ASTM D1003
25.4 μm	6.0	%	ASTM D1003
50.8 μm	7.0	%	ASTM D1003
Extrusion	Nominal Value	Unit	
Melt Temperature	213	°C	
Extrusion instructions			

吹塑薄膜的制造条件:
 螺杆类型:单跨
 模具间隙:40 密尔 (1.02 mm)
 熔体温度:416°F (213°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:130 rpm
 冷冻线高度:28 英寸 (711 mm)

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