# CERTENE™ HWF-852B

### High Density Polyethylene

#### Muehlstein

#### Message:

HWF-852B is a certified prime grade Hexene copolymer HIGH MOLECULAR WEIGHT developed for production of thin gauged high stiffness paper-like Blown films. HWF-852B features BIMODAL-BROAD molecular weight distribution that greatly improves processability in HDPE equipment, outstanding film mechanical properties, and high drawdown film capability. HWF-852B applications include shoppers, grocery bags, merchant and produce bags, refuse sacks, single and multiwall liners, lamination films, meat & cheese wrap films, and as substitute films for grease-proof waxed and acid free papers. Minimum recommended film gauge is 0.4 mil, and processing temperature 210 to 230°C. HWF-852B complies with FDA regulation 21CFR 177.1520 (c) 3.2 (a) and with most international regulations concerning the use of Polyethylene in contact with food articles.

General Information				
Features	Rigidity, high			
	High molecular weight			
	Copolymer			
	hexene comonomer			
	Workability, good			
	Good stripping			
	Compliance of Food Exposure			
	Bimodal molecular weight distributi	on		
Uses	Films			
	Laminate			
	Lining			
	Bags			
	Food packaging			
Agency Ratings	FDA 21 CFR 177.1520(c) 3.2a			
Forms	Particle			
Processing Method	Blow film			
Physical	Nominal Value	Unit	Test Method	
Density	0.952	g/cm³	ASTM D1505	
Melt Mass-Flow Rate (MFR)			ASTM D1238	
190°C/2.16 kg	0.050	g/10 min	ASTM D1238	
190°C/21.6 kg	8.0	g/10 min	ASTM D1238	
Films	Nominal Value	Unit	Test Method	
Film Thickness - Tested	10	μm		
Film Thickness - Recommended / Available	Minimum 10 µm (0.4 mil)			
secant modulus			ASTM D882	
1% secant, MD	790	MPa	ASTM D882	
1% secant, TD	965	MPa	ASTM D882	
Tensile Strength			ASTM D882	

MD: Yield	28.0	MPa	ASTM D882	
TD: Yield	26.0	MPa	ASTM D882	
MD: Fracture	69.0	MPa	ASTM D882	
TD: Fracture	41.0	MPa	ASTM D882	
Tensile Elongation			ASTM D882	
MD: Fracture	330	%	ASTM D882	
TD: Fracture	480	%	ASTM D882	
Dart Drop Impact <sup>1</sup>	280	g	ASTM D1709A	
Elmendorf Tear Strength			ASTM D1922	
MD	20	g	ASTM D1922	
TD	200	g	ASTM D1922	
Thermal	Nominal Value	Unit	Test Method	
Peak Melting Temperature	129	°C	ASTM D3417	
Additional Information				
Film Specimen: 0.4 mil (10 µm) film, melt temperature 410-440°F (210-225°C), blow-up-ratio 4.0:1, frost line height 8 x die ø.				
Extrusion	Nominal Value	Unit		
Melt Temperature	210 - 230	°C		
NOTE				
1.	F50			

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