

ATTANE™ 4404G

Ultra Low Density Polyethylene Resin
The Dow Chemical Company

Message:

Provides improved cling in one-sided cling applications
It has improved toughness and optical properties
Complies with:
Canadian HPFB No Objection (with limitations)
EU, No 10/2011
U.S. FDA CFR 176.170(c)
U.S. FDA FCN 424
Consult the regulations for complete details.

General Information			
Agency Ratings	FDA 21 CFR 176.170(c), Table 2.2		
	FDA FCN 424		
	HPFB (Canada) No Objection 3		
	Europe No 10/2011		
Forms	Particle		
Processing Method	cast film		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.904	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Films	Nominal Value	Unit	Test Method
Film Puncture Resistance			Internal method
20 µm	18.9	J/cm ³	Internal method
51 µm	17.5	J/cm ³	Internal method
secant modulus			ASTM D882
2% secant, MD: 20 µm	58.8	MPa	ASTM D882
2% secant, MD: 51 µm	62.6	MPa	ASTM D882
2% secant, TD: 20 µm	64.7	MPa	ASTM D882
2% secant, TD: 51 µm	63.0	MPa	ASTM D882
Tensile Strength			ASTM D882
MD: Yield, 20 µm	7.00	MPa	ASTM D882
MD: Yield, 51 µm	6.76	MPa	ASTM D882
TD: Yield, 20 µm	4.92	MPa	ASTM D882
TD: Yield, 51 µm	6.34	MPa	ASTM D882
MD: Break, 20 µm	36.9	MPa	ASTM D882
MD: Fracture, 51 µm	32.6	MPa	ASTM D882
TD: Break, 20 µm	29.1	MPa	ASTM D882

TD: Fracture, 51 μm	32.4	MPa	ASTM D882
Tensile Elongation			ASTM D882
MD: Break, 20 μm	500	%	ASTM D882
MD: Fracture, 51 μm	660	%	ASTM D882
TD: Break, 20 μm	710	%	ASTM D882
TD: Fracture, 51 μm	710	%	ASTM D882
Dart Drop Impact			ASTM D1709B
20 μm	> 850	g	ASTM D1709B
51 μm	> 850	g	ASTM D1709B
Elmendorf Tear Strength			ASTM D1922
MD : 20 μm	330	g	ASTM D1922
MD : 51 μm	960	g	ASTM D1922
TD : 20 μm	500	g	ASTM D1922
TD : 51 μm	1100	g	ASTM D1922
Oxygen Permeability (23°C, 51 μm)	450	cm ³ ·mm/m ² /atm/24 hr	ASTM D3985
Water Vapor Transmission Rate (51 μm)	0.85	g·mm/m ² /atm/24 hr	ASTM F1249
Carbon Dioxide Transmission Rate (23°C, 50.8 μm)	2000	cm ³ ·mm/m ² /atm/24 hr	Internal method
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	71.1	°C	ASTM D1525
Melting Temperature (DSC)	124	°C	Internal method
Optical	Nominal Value	Unit	Test Method
Gloss			ASTM D2457
45°, 20.3 μm	92		ASTM D2457
45°, 50.8 μm	90		ASTM D2457
Clarity			ASTM D1746
20.3 μm	99.0		ASTM D1746
50.8 μm	99.0		ASTM D1746
Haze			ASTM D1003
20.3 μm	0.60	%	ASTM D1003
50.8 μm	1.8	%	ASTM D1003
Extrusion instructions			

铸造薄膜的制造条件:
 模具间隙:25 密尔 (2 mm)
 冷却辊温度:70°F (21°C)
 生产线速度:200 fpm(61 米/分)

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