



-- Film & Injection & Foaming Grade Data Sheets

Grade Name			Film			Injection & Foaming			
			7130F	7140F	7350F	7310M	7320M	7620M	7660M
Properties	Unit	Method							
Melt Index MI _{2,16}	g/10min	ASTM D1238	0.9	0.7	1.8	2.5	4.0	9.0	20
Density	g/cm ³	ASTM D1505	0.930	0.934	0.938	0.928	0.930	0.930	0.940
Vinyl Acetate content	%		9	14	18	6	9	9	20
Thermal properties									
Melting point	°C	DSC	93	90	84	102	96	95	83
Brittleness point	°C	ASTM D746	<-70	<-70	<-70	<-70	<-70	<-70	<-70
Softening point	°C	ASTM D1525	80	75	60	90	74	73	60
Mechanical properties									
Tensile strength at yield	Kg/cm ²	ASTM D638	60	70	45	80	60	40	30
Tensile strength at break	Kg/cm ²	ASTM D638	180	200	150	150	140	130	110
Elongation at break	%	ASTM D638	650	750	800	700	700	700	800
Flexural modulus	Kg/cm ²	ASTM D790	250	230	400	360	250	240	130
Hardness	Shore A	ASTM D2240	95	92	88	98	96	96	83
Hardness	Shore D	ASTM D2240	45	40	38	47	46	46	32
Mechanical properties of film									
Tensile strength at yield	Kg/cm ²	ASTM D882B MD/TD	50/40	50/40	40/30				
Tensile strength at break	Kg/cm ²	ASTM D882B MD/TD	300/280	310/280	280/250				
Elongation at break	%	ASTM D882B MD/TD	400/550	450/600	500/600				
Secant modulus 1%	Kg/cm ²	ASTM D882B MD/TD	350/400	370/420	350/380				
Tear resistance (elmendorf)	N/mm	ASTM D1922 MD/TD	10/24	10/24	10/24				
Dart drop test	g	ASTM D1709	550	620	650				
Coefficient of friction(COF)		ASTM D1894	>0.5	>0.5	>0.5				
Optical qualities									
Haze	%	ASTM D1003	5	3	3				
Gloss 45°	%	ASTM D2457	80	90	90				
Recommended film thickness	μ		30-150	30-150	30-150				
Additives									
Slip agent	Level								
Anti blocking agent	Level								
Characteristics			Good processability Good toughness Non-BHT content	Good processability Good toughness High optical Non-BHT content	Good processability Good toughness High optical Non-BHT content	Good chemical resistance Good processability	Good chemical resistance Good-elasticity	Good processability Heat sealing	Good processability Heat sealing High optical foaming
Application			Greenhouse film General purpose film	Greenhouse film General packaging sanitary applications	Greenhouse film General packaging sanitary applications	Flexible items X-linked Foam	Flexible items X-linked Foam	Injection Lamination Extrusion-coating X-linked Foam	Injection Lamination Extrusion-coating X-linked Foam Hot melt

PS : 1. film extrusion parameters : screw $\phi = 60\text{mm}$ · L/D=30 · blow-up ratio(BUR)=2.5

Temperature =160 - 200 °C thickness 30 μ (MI >1.2) / 50 μ (MI <1.2)

2. Data shown are average values and should not be examined for specifications.