



## Low Density Polyethylene ( LDPE ) -- Injection & Coating Grade Data Sheets

Grade Name			Injection		Coating
			6630M	6810M	6520G
Properties	Unit	Method			
Melt Index MI <sub>2.16</sub>	g/10min	ASTM D1238	20	50	8.0
Density	g/cm <sup>3</sup>	ASTM D1505	0.922	0.914	0.916
Vinyl Acetate content	%				
<b>Thermal properties</b>					
Melting point	°C	DSC	108	103	105
Brittleness point	°C	ASTM D746	-60	-60	<-70
Softening point	°C	ASTM D1525	92	80	85
<b>Mechanical properties</b>					
Tensile strength at yield	Kg/cm <sup>2</sup>	ASTM D638	120	90	90
Tensile strength at break	Kg/cm <sup>2</sup>	ASTM D638	90	100	110
Elongation at break	%	ASTM D638	400	500	500
Flexural modulus	Kg/cm <sup>2</sup>	ASTM D790	1800	1100	1100
Hardness	Shore D	ASTM D2240	50	45	52
ESCR	Hr	ASTM D1693			
<b>Mechanical properties of film</b>					
Tensile strength at yield	Kg/cm <sup>2</sup>	ASTM D882B MD/TD			
Tensile strength at break	Kg/cm <sup>2</sup>	ASTM D882B MD/TD			
Elongation at break	%	ASTM D882B MD/TD			
Secant modulus 1%	Kg/cm <sup>2</sup>	ASTM D882B MD/TD			
Tear resistance (elmendorf)	N/mm	ASTM D1922 MD/TD			
Dart drop test	g	ASTM D1709			
Coefficient of friction(COF)		ASTM D1894			
<b>Optical qualities</b>					
Haze	%	ASTM D1003			
Gloss 45°	%	ASTM D2457			
Recommended film thickness	μ				
<b>Additives</b>					
Slip agent	Level				
Anti blocking agent	Level				
<b>Characteristics</b>			Excellent flowability High gloss Medium-rigidity	Excellent flowability High gloss Good flexibility	Excellent processability Good adhesion Small Neck-in
<b>Application</b>			Houseware High gloss toys Low thickness articles	Artificial flowers Low thickness articles	Coating on Aluminium paper substrates Injection-articles Foam material

PS : 1. Processing condition : Injection temperature =150 - 180 °C 、 Coating temperature =270 - 340 °C.  
2. Data shown are average values and should not be examined for specifications.