

ELEVATE™ EF446

Ethylene Vinyl Acetate Copolymer
Westlake Chemical Corporation

Message:

Westlake EF446 resin is a 6.0% EVA copolymer designed for general purpose packaging film. This Kosher compliant resin has excellent clarity, toughness, heat sealing characteristics, low temperature brittleness properties, and machinability.

Application/Uses:

High Clarity Packaging

Foam Applications

General Information			
Features	Kosher certification		
	Copolymer		
	Workability, good		
	Good heat sealability		
	Low temperature resistance		
	Definition, high		
	Good toughness		
Uses	Packaging		
	Films		
	Foam		
Agency Ratings	FDA 21 CFR 177.1520		
Processing Method	Blow film		
Physical	Nominal Value	Unit	Test Method
Density	0.925	g/cm ³	ASTM D1505
Melt Mass-Flow Rate (MFR)	2.0	g/10 min	ASTM D1238
Vinyl Acetate Content	6.0	wt%	
Films	Nominal Value	Unit	Test Method
Film Thickness - Tested	32	µm	
secant modulus ¹			ASTM D882
1% secant, MD: 32 µm, blown film	109	MPa	ASTM D882
1% secant, TD: 32 µm, blown film	127	MPa	ASTM D882
Tensile Strength ²			ASTM D882
MD: Broken, 32 µm, blown film	30.0	MPa	ASTM D882
TD: Broken, 32 µm, blown film	26.0	MPa	ASTM D882
Tensile Elongation ³			ASTM D882
MD: Broken, 32 µm, blown film	440	%	ASTM D882
TD: Broken, 32 µm, blown film	770	%	ASTM D882
Dart Drop Impact ⁴ (32 µm, Blown Film)	180	g	ASTM D1709A

Optical	Nominal Value	Unit	Test Method
Gloss ⁵ (45°, 31.8 µm, Blown Film)	73		ASTM D2457
Haze ⁶ (31.8 µm, Blown Film)	4.3	%	ASTM D1003

Additional Information

Test specimens for blown film: nominal thickness 1.25 mils; blow up ratio 2.5:1, die gap 35 mils.

Extrusion	Nominal Value	Unit
Melt Temperature	182 - 199	°C

Extrusion instructions

Melt temperatures of 360° F - 390° F are recommended for Westlake Chemical EF446 with blow-up ratios of 1.5:1 or higher.

NOTE

1.	Test run at 23°C (73°F) and 50% relative humidity
2.	Test run at 23°C (73°F) and 50% relative humidity
3.	Test run at 23°C (73°F) and 50% relative humidity
4.	Test run at 23°C (73°F) and 50% relative humidity
5.	Base Polymer
6.	Base Polymer

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