

Braskem PE ML3600S

Linear Low Density Polyethylene

Braskem

Message:

The resin ML3600S is a Linear Low Density Polyethylene, 1-hexene copolymer, developed for rotomolding. It presents an adequate balance of processability and mechanical properties, with good resistance to environmental stress cracking.

Applications:
Water tanks, tanks, parts for the automotive and agricultural segments.

Processing Conditions:
This resin is recommended to rotational molding under conditions comparable to polyethylene resins with similar melt index and density range. Oven Temperature Range: 260 to 350 °C. P.I.A.T:210 to 240°C.

Additives: Weathering resistance UV8 and antioxidants.

General Information	
Additive	Antioxidation Long-term UV-8 stabilizer
Features	Low density High ESCR (Stress Cracking Resistance) Good UV resistance Workability, good
Uses	Agricultural application Application in Automobile Field Water tank
Agency Ratings	FDA 21 CFR 177.1520
Forms	Particle
Processing Method	rotomolding Compression molding

Physical	Nominal Value	Unit	Test Method
Density	0.933	g/cm ³	ASTM D1505
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	4.7	g/10 min	ASTM D1238
Environmental Stress-Cracking Resistance ¹			ASTM D1693
50°C, 2.00mm, 10% Igepal, molded, F50	250	hr	ASTM D1693
50°C, 2.00mm, 100% Igepal, molded, F50	> 1000	hr	ASTM D1693
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, molding	19.0	MPa	ASTM D638
Fracture, molding	29.0	MPa	ASTM D638

Tensile Elongation			ASTM D638
Yield, molding	14	%	ASTM D638
Fracture, molding	> 1000	%	ASTM D638
Flexural Modulus - 1% Secant (Compression Molded)			ASTM D790
	770	MPa	
Impact	Nominal Value	Unit	Test Method
Impact Strength			ARM
-40°C, 3.17mm, rotational molding	55	J	ARM
-40°C, 6.34mm, rotational molding	115	J	ARM
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, molded	60.0	°C	ASTM D648
1.8 MPa, unannealed, molded	42.0	°C	ASTM D648
Peak Melting Temperature	127	°C	ASTM D3418
Injection instructions			
Oven Temperature Range: 260 to 350 °C.			
NOTE			

- 0.3mm notched-plaques

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