

DOW™ HDPE DMDA-8810 NT 7

High Density Polyethylene Resin

The Dow Chemical Company

Message:

For Extrusion Coating Applications
Complies with U.S. FDA 21 CFR 177.1520 (c) 3.1a
Consult the regulations for complete details

General Information			
Agency Ratings	FDA 21 CFR 177.1520(c) 3.1a		
Forms	Particle		
Processing Method	Extrusion coating		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.950	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	12	g/10 min	ASTM D1238
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	128	°C	ASTM D1525
Melting Temperature (DSC)	132	°C	Internal method
Extrusion	Nominal Value	Unit	Test Method
Melt Temperature	302 - 332	°C	
Melt Temperature (Aim)	316	°C	
Neck-in ¹ (321°C, 25.4 µm)	69.9	mm	Internal method
Maximum production line speed ²	> 7.6	m/sec	Internal method
Minimum coating thickness ³	6.4	µm	Internal method
Minimum coating weight ⁴	6.5	g/m ²	Internal method
Extrusion instructions			

挤出涂层的制造条件:
螺杆尺寸:3.5 英寸 (89 mm);30:1 L/D
螺杆类型:单跨
模具间隙:20 密尔 (0.508 mm)
熔体温度:600°F (300°C)
输出:250 磅/小时
螺杆速度:90 rpm

NOTE	
1.	1.0 Mill (25 µm) coating applied to 50 pounds of kraft paper.
2.	1.0 Mill (25 µm) coating applied to 50 pounds of kraft paper.
3.	1.0 Mill (25 µm) coating applied to 50 pounds of kraft paper.
4.	1.0 Mill (25 µm) coating applied to 50 pounds of kraft paper.

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