

Braskem PE SPB681

Low Density Polyethylene

Braskem America Inc.

Message:

Description: SPB681 is a low density polyethylene produced under high pressure technology. Films obtained with this product show excellent 'draw down', good sealability, and low gel content. Additives free. The minimum biobased content of this grade is 95%, determined according to ASTM D6866.

Applications: LLDPE and HDPE blends.

Process: Blown and Cast Film Extrusion. Injection molding.

General Information			
Features	Low speed solidification crystal point		
	Updatable resources		
	Good stripping		
	BPA-free		
	No additive		
Uses	Mixing		
Agency Ratings	FDA 21 CFR 177.1520		
Processing Method	Film extrusion		
	Blow film		
	cast film		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	0.922	g/cm ³	ASTM D1505
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	3.8	g/10 min	ASTM D1238
Films	Nominal Value	Unit	Test Method
Film Thickness - Tested	38	µm	
Tensile Strength			ASTM D882
MD: Broken, 38 µm, blown film	30.0	MPa	ASTM D882
TD: Broken, 38 µm, blown film	20.0	MPa	ASTM D882
Tensile Elongation			ASTM D882
MD: Broken, 38 µm, blown film	370	%	ASTM D882
TD: Broken, 38 µm, blown film	1100	%	ASTM D882
Dart Drop Impact ¹ (38 µm, Blown Film)	60	g	ASTM D1709
Elmendorf Tear Strength - TD (38 µm, Blown Film)	100	g	ASTM D1922
Optical	Nominal Value	Unit	Test Method
Gloss (60 °, blown film)	120		ASTM D2457
Haze (Blown Film)	4.0	%	ASTM D1003
Additional Information	Nominal Value	Unit	Test Method

Biobased Content	> 95	%	ASTM D6866
Blown Film Properties: Obtained in 75mm extruder, blow up ratio 2:1, die gap 1.0mm and 38μm thickness. Recommended processing conditions: Blown Film Extrusion Equipment: Screw - relation L/D.....16 to 30:1 Compression Ratio.....3 to 4:1 Screw Package (Mesh)...40/60/40 Temperature Profile: 1st zone.....110°C From the screw to the die.....140°C Die.....150°C Blow up ratio.....from 2 to 3:1 Frostline Height.....at most equivalent to the bubble diameter Cast Film Extrusion Equipment type: Screw - L/D relation.....at least 20:1 Screw.....from 180 to 250°C Die.....from 250 to 290°C Chill Roll.....40°C Injection Molding Temperature profile.....180 to 220°C Mold temperature.....5 to 25°C			
NOTE			

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