

MXSTEN® DA77535

Ethylene-based Plastomer

Westlake Chemical Corporation

Message:

MXSTEN® DA77535 resin is a polyethylene plastomer designed for blown and cast film extrusion that contains no slip and no antiblock additives. Films produced with this resin exhibit a very low seal initiation temperature with a broad hot tack window. Other features of this resin include higher stiffness and higher melting point.

Application/Uses:

Blown film

Cast film

Stretch Film Applications

| General Information | | | |
|---------------------|---------------------|--|--|
| Features | Broad Seal Range | | |
| | Rigidity, high | | |
| Uses | Films | | |
| | cast film | | |
| Agency Ratings | FDA 21 CFR 177.1520 | | |
| Forms | Particle | | |
| Processing Method | Blow film | | |
| | cast film | | |

| Physical | Nominal Value | Unit | Test Method |
|---|---------------|-------------------|-------------|
| Density | 0.914 | g/cm ³ | ASTM D4883 |
| Melt Mass-Flow Rate (MFR) (190°C/2.16 kg) | 2.7 | g/10 min | ASTM D1238 |

| Films | Nominal Value | Unit | Test Method |
|---|---------------|------|-------------|
| Film Thickness - Tested | 25 | µm | |
| secant modulus ¹ | | | ASTM D882 |
| 1% secant, MD: 25 µm, blown film | 152 | MPa | ASTM D882 |
| 1% secant, TD: 25 µm, blown film | 172 | MPa | ASTM D882 |
| Tensile Strength ² | | | ASTM D882 |
| TD: Yield, 25 µm, blown film | 6.69 | MPa | ASTM D882 |
| MD: Broken, 25 µm, blown film | 35.2 | MPa | ASTM D882 |
| TD: Broken, 25 µm, blown film | 40.0 | MPa | ASTM D882 |
| Tensile Elongation ³ | | | ASTM D882 |
| MD: Broken, 25 µm, blown film | 700 | % | ASTM D882 |
| TD: Broken, 25 µm, blown film | 1200 | % | ASTM D882 |
| Dart Drop Impact ⁴ (25 µm, Blown Film) | 400 | g | ASTM D1709A |
| Elmendorf Tear Strength ⁵ | | | ASTM D1922 |

| MD: 25 µm, blown film | 300 | g | ASTM D1922 |
|--|---------------|------|-----------------|
| TD: 25 µm, blown film | 550 | g | ASTM D1922 |
| Optical | Nominal Value | Unit | Test Method |
| Gloss (45°, 25.4 µm, Blown Film) | 55 | | ASTM D2457 |
| Haze (25.4 µm, Blown Film) | 13 | % | ASTM D1003 |
| Additional Information | Nominal Value | Unit | Test Method |
| Sealing Initial Temperature ⁶ | 88 | °C | Internal method |

Extrusion conditions used include a 6" die, 2.5" 24:1 L:D barrier screw, 2.4:1 BUR, 100-mil die gap, 15" frostline height, 400° F melt temperature, and 7.5 lb/hr/inch die output. Density results are on Base Resin.

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. Test run at 23°C (73°F) and 50% relative humidity
6. Seal initiation temperature is the temperature at which 200 g/inch seal strength is achieved.

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