

DOW™ LDPE 4016

Low Density Polyethylene Resin
The Dow Chemical Company

Message:

A high melt index resin for high speed thin coating applications
Complies with U.S. FDA 21 CFR 177.1520 (c) 2.1.
Complies with Canadian HPFB No Objection (With Limitations)
Consult the regulations for complete details.
Polyethylene 4016 can be used for a variety of applications such as condiment packaging, dry foods packaging, snack foods packaging, moist foods packaging, sugar pouches, lidding stock and medical packaging.

General Information			
Agency Ratings	FDA 21 CFR 177.1520(c) 2.1		
	HPFB (Canada) No Objection		
Forms	Particle		
Processing Method	Extrusion coating		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.918	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	16	g/10 min	ASTM D1238
Extrusion	Nominal Value	Unit	Test Method
Melt Temperature	316 - 327	°C	
Neck-in (321°C, 25.4 µm)	61.0	mm	Internal method
Maximum production line speed	> 7.6	m/sec	Internal method
Minimum coating thickness	7.6	µm	Internal method
Minimum coating weight	6.5	g/m ²	Internal method
Extrusion instructions			

Fabrication Conditions For Extrusion Coating Film:
Screw Size: 3.5 in. (89 mm); 30:1 L/D
Screw Type: Single Flight with Maddock Mixer
Die Gap: 20 mil (0.508 mm)
Melt Temperature: 625°F (329°C)
Output: 250 lb/hr
Screw Speed: 90 rpm
Guage 1.0 mil (25µm)

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

