

# Halene H F5400

High Density (HMW) Polyethylene  
Haldia Petrochemicals Ltd.

Message:

F5400 is a film grade HM-HDPE manufactured using the Mitsui CX Technology.  
This can be used for general-purpose Films as well as very thin Reinforced bags.  
F5400 grade is characterized by excellent processability and high mechanical strength.

General Information			
Features	High molecular weight		
	High strength		
	Workability, good		
Uses	Films		
	Bags		
Forms	Particle		
Processing Method	Film extrusion		
Physical	Nominal Value	Unit	Test Method
Density <sup>1</sup>	0.954	g/cm <sup>3</sup>	ASTM D1505
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	0.090	g/10 min	ASTM D1238
190°C/21.6 kg	14	g/10 min	ASTM D1238
Environmental Stress-Cracking Resistance (10% Igepal, Compression Molded, F50)	> 500	hr	ASTM D1693B
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, Compression Molded)	62		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup>			ASTM D638
Yield, molding	25.0	MPa	ASTM D638
Fracture, molding	38.0	MPa	ASTM D638
Tensile Elongation <sup>3</sup> (Break, Compression Molded)	1000	%	ASTM D638
Films	Nominal Value	Unit	Test Method
Dart Drop Impact (20 µm, Blown Film)	80	g	ASTM D1709A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, Compression Molded)	180	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Peak Melting Temperature	131	°C	ASTM D3418
Extrusion	Nominal Value	Unit	

Cylinder Zone 1 Temp.	180 - 220	°C
Cylinder Zone 2 Temp.	180 - 220	°C
Cylinder Zone 3 Temp.	180 - 220	°C
Cylinder Zone 4 Temp.	180 - 220	°C
Cylinder Zone 5 Temp.	180 - 220	°C

#### Extrusion instructions

BUR: 3 to 6

#### NOTE

1. 23°C
2. 50 mm/min
3. 50 mm/min

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#### Recommended distributors for this material

### 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

