TOTAL PETROCHEMICALS

TOTAL PETROCHEMICALS USA, INC.



HDPE 6420

Resin Properties ⁽¹⁾	Typical <u>Value</u>	ASTM Method	<u>Polyet</u>
Melt Flow Index, g/10 min		D 1238	Medium
190°C/2.16 kg	2.0		High De
190°C/21.6 kg (HLMI)	55.0		
Density, g/cm ³	0.962	D 792	Charac
			<u> </u>
Film Properties ⁽¹⁾			• EXC
Monolaver Film ⁽²⁾			barr
Elmendorf Tear. g		D1922	 Low
Machine Direction (MD)	24		 Low
Transverse Direction (TD)	385		- High
Tensile Strength @ Yield, psi		D882, A, 20 in/min	• Tilgi
MD	3800		• Goo
	4000		• Goo
Tensile Strength @ Break, psi	7500	D882, A, 20 in/min	with
MD TD	7500		
ID Elongation @ Break %	3400	D882 A 20 in/min	
MD	700	D002, A, 20 m/mm	
TD	700		Applic
Secant Modulus, kpsi		D882, A, 1 in/min	Cere
1% strain (MD/TD)	125/128		
2% strain (MD/TD)	100/102		• Cla
WVTR ⁽³⁾ @ 100°F, g/100 in ² /day	0.25	E96/66	 Bak
Coextruded Film ⁴			 Spe
WVTR ⁽³⁾ @ 100°F, g/100 in ² /day	0.19	E96/66	films
Elmendorf Tear, g		D1922	
Machine Direction (MD)	70		• 000
Transverse Direction (TD)	500		
<u>Processing</u> Recommendation			

390 to 410°F

2.0 to 3.5

4.0 to 6.0

hylene:

Molecular Weight nsity Film Resin

cteristics

- ellent moisture ier properties
- / gels
- taste and odor
- h stiffness
- od processability
- od compatibility LDPE and)PE

ations

- eal liners
- cker over-wrap
- ery mixes
- cialty monolayer s
- extruded films

HDPE 6420 09/2005

(1) Data developed under laboratory conditions and are not to be used as specification, maxima or minima.

Film was produced at 1.0 mil with a 2.5:1 BUR at 6:1 FLH/D ratio. (2)

(3) Water Vapor Transmission Rate

Extrusion Melt Temperature

A/B/B 25/50/25% layer distribution LDPE/6420/6420, 2.0 mil, 2.5 BUR (4)



BUR FLH/D

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All tests were run under laboratory conditions. ASTM (where applicable) testing procedures. The data are intended as a general guide only and do not necessarily represent results that may be obtained elsewhere. The use of these products must be guided by the user's own methods for selection of proper formulation. TOTAL PETROCHEMICALS USA, INC. disclaims any responsibility for misuse or misapplication of its products. TOTAL PETROCHEMICALS USA, INC. MAKES NO WARRANTY OF MEROCHANTABILITY AND THERE IS NO WARRANTY THAT GOODS SUPPLIED SHALL BE FIT FOR ANY PARTICULAR PURPOSE. TOTAL PETROCHEMICALS USA, INC. Liability and customer's exclusive remedy for any claims arising out of sales of its products are expressly limited at customer option to replacement of non-performing goods or payment not to exceed the purchase price plus transportation charges thereon in respect to any material which damage is claimed.