



Product Description

EL-LENE H5604F is a product of bi-modal process from Mitsui Chemicals, Inc. of Japan.

Typical Applications

- Recommend film thickness at 10-25 micron
- Shopping bag and T-shirt bag
- Garbage bag
- Liner bag

Product Characteristics

- High tensile strength with good dart impact strength
- High stiffness
- Low gel content
- Good moisture barrier
- Food contact applicable (Complies with U.S FDA 21 CFR 177.1520)

Physical properties

Property	Test Method	Value	Unit
Resin Properties			
Melt Flow Rate	ASTM D 1238 @ 190 °C, 2.16 kg	0.04	g/10 min
Density	ASTM D 1505	0.956	g/cm ³
Melting Point	ASTM D 2117	131	°C
Vicat Softening Point	ASTM D 1525	124	°C
Brittleness Temperature	ASTM D 746	< -60	°C
ESCR	ASTM D 1693 @ 50 °C (Condition B, Compression Molded, 25% Igepal)	> 1000	hrs, F ₅₀
Film Properties			
Tensile Strength at Yield	ASTM D 882	MD: -*, TD: 250*	kg/cm ²
Tensile Strength at Break	ASTM D 882	MD: 620*, TD: 310*	kg/cm ²
Tensile Modulus, 2% Secant	ASTM D 882	MD: 8200*, TD: 8000*	kg/cm ²
Elongation at Break	ASTM D 882	MD: 240*, TD: 450*	%
Elmendorf Tear Strength	ASTM D 1922	MD: 3*, TD: 80*	g
Dart Impact Strength	ASTM D 1709	139*	g

(*) Properties obtained from film produced on a pilot line at TPE, 12 micron, BUR 5:1, MD = Machine Direction, TD = Transverse Direction

Note : Conversion factor for changing unit from kg/cm² to MPa is divided by 10.2

Processing Techniques

The actual extrusion condition depends on type of using machine, size and film thickness of product required.

Generally, melt temperature should be 190-210 °C with BUR = 3-5 times and frost line height (FLH) = 8-10 times of die diameter.

Product Available Form

- Pellet

Product Handling

- 25 kg loose bag
- Big bag with specified weight

Product Technical Assistance

For technical assistance or further information on this product or any other EL-Lene products, please contact EL-Lene representatives.

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