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Technical data sheet

ERACLENE ®

FA 506

HDPE

High density polyethylene

Eraclene FA 506 is a high density polyethylene resin (HDPE), hexene copolymer, with antioxidants, suitable for blown film extrusion.
Its broad molecular weight distribution and density successfully combine excellent performance at high extrusion rates with high film strength and sealability.

Main Applications

Eraclene FA 506 can be processed either in blend and in coextrusion. It is possible to use it pure for high rigidity grocery sacks and shopping bags. Usage in blend and/or in coextrusion with LDPE and LLDPE is also recommended for high strength thermo-shrinkable film, as well as for hygienic packaging. The excellent balance between drawability and bubble stability makes Eraclene FA 506 the optimum choice for manufacturing of high quality thin film characterized by outstanding mechanical properties.

Main Properties

Resin Properties	Value	Unit	Test Method
Melt Flow Rate (190 °C/2,16 kg)	0,15	g/10min	ISO 1133
Melt Flow Rate (190 °C/5 kg)	0,6	g/10min	ISO 1133
Melt Flow Rate (190 °C/21,6 kg)	15	g/10min	ISO 1133
Density	0,939	g/cm3	ISO 1183
Melting point	127	°C	Internal method
Brittleness temperature	< -60	°C	ASTM D 746
Vicat softening point (1 kg)	119	°C	ISO 306/A

Film Properties *	Value	Unit	Test Method
Tensile stress at yield MD	-	MPa	ISO 527-3
Tensile stress at yield TD	-	MPa	ISO 527-3
Tensile stress at break MD	55	MPa	ISO 527-3
Tensile stress at break TD	50	MPa	ISO 527-3
Elongation at break MD	550	%	ISO 527-3
Elongation at break TD	750	%	ISO 527-3
1% Secant modulus MD	400	MPa	ISO 527-3
1% Secant modulus TD	500	MPa	ISO 527-3
Elmendorf tear resistance MD	25	N/mm	ISO 6383-2
Elmendorf tear resistance TD	250	N/mm	ISO 6383-2
Impact resistance F50 (Dart Drop Test)	150	g	ISO 7765-1/A
Dynamic coefficient of friction (COF)	-	-	ISO 8295
Haze	-	%	ISO 14782
Gloss, 45°	-	%	ASTM D 2457
Recommended film thickness	10 ÷ 50	micron	-

(*) Film properties are typical of blown film extruded at 1:4,5 blow up ratio, 210 °C melt temperature, die gap 1,1 mm and thickness 25 µm. Actual properties are typical and may vary depending upon operating conditions and additive package.

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Processing notes

Eraclene FA 506 can be processed by using conventional blown film equipment. A mixing screw and a flat or slightly increasing temperature profile, from 190 °C to 210 °C, are recommended. The best balance between processability and mechanical properties is achieved by using a die gap between 1 mm and 1,3 mm.

Storage and Handling

Eraclene FA 506 is supplied in pellet form. This material may readily be conveyed and bulk fed through equipment designed for conventional pelletised polyethylene resin, provided the equipment is designed to prevent accumulation of the fines and dust particles that are contained in all polyethylene resins. These fines and dust particles can, under certain conditions, pose an explosion hazard. We recommend that the conveying system used be equipped with filters of adequate size, operated and maintained in such a manner to ensure that no leaks develop and earthed adequately. We further recommend that good housekeeping should be practised throughout your facility.
The product should be stored in dry conditions at temperatures below 50 °C and protected from sunlight.
Improper storage can initiate degradation which results in odour generation, colour changes and can have negative effects on the physical properties of the product.
Before using this product it is recommended to read and understand the relevant Safety Data Sheet.

Availability

Contact the Versalis sales office nearest to you regarding availability and your specific application requirements.

Food Contact Status

Eraclene FA 506 complies with the rules and regulations of the European Union, as well as other countries, regarding the use of plastic materials in food contact applications. Certificates of compliance are available upon request.

Technical Management Polyethylene

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IMPORTANT: please consult the relevant safety data sheet for more detailed information. The information and data presented herein are to the best of our knowledge true and accurate but no warranty or guarantee, expressed or implied, is made nor is any liability accepted with respect to the use of such information and data. Versalis is available to provide the guaranteed values for each product on demand.
DISCLAIMER: it is the sole responsibility of the end-user to determine the safety, the regulatory compliance as well as the technical suitability of the product for the intended application. The product is not intended for use in medical devices and pharmaceutical applications; Versalis declines all responsibility and cannot be held liable in case of use in the above mentioned applications.

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