HALDIA PETROCHEMICALS LTD

Halene – L*

TECHNICAL DATA SHEET 71602S

71602S is a LLDPE blown film grade produced by the Spherilene Technology

This grade can be used in General Purpose Packaging Film Application

The precise morphological control achieved during polymerization confers excellent processability & mechanical strengths

71602S is additivated with slip & antiblocking agent for good openability & slip properties.

BIS Designation Code: IS 7328-2B-FBH-BDB

Property	Test Method	Unit	Nominal Value
Melt Flow Index (2.16 kg, 190°C)	ASTM D1238, IS 13360 (Part 4/Sec 1)	g/10 min	2.0
Melt Flow Index (5 kg, 190°C)			6.0
Melt Flow Index (21.6 kg, 190°C)	ASTM D1238	g/10 min	60
Density (23°C)	ASTM D1505, IS 13360 (Part 3/Sec 11)	g/cm^3	0.920
DSC Melting Temperature	ASTM D3418	°C	125
Film Property **			
Tensile Strength at Yield MD	ASTM D882 (500 mm/min)	MPa	11
Tensile Strength at Yield TD		MPa	10
Tensile Strength at Break MD		MPa	19
Tensile Strength at Break TD		MPa	14
Elongation at Break MD		%	700
Elongation at Break TD		%	750
Elmendorf Tear Strength MD	ASTM D1922	g/µ	4
Elmendorf Tear Strength TD		g/µ	12
Dart Impact Strength, F_{50} (38 mm Dart, 66 cm Height)	ASTM D1709A	g/µ	3
Suggested Processing Conditions			
Barrel Temperature	170 – 200 °C		
Melt Temperature	190 – 200 °C		
Blow up Ratio	2.0 – 3.0		
Die Gap	2.0 – 2.5 mm		

* Halene L is the registered trademark of Linear Low-Density Polyethylene of Haldia Petrochemicals Limited

** Typical values with 25 µ film made with 2.5 mm die gap & BUR 2.5

This grade meets the requirements of:

IS 7328:2020 Specification for Polyethylene Material for Moulding and Extrusion

IS 16738:2018 Positive List of Constituents for Polypropylene, Polyethylene and their Copolymers for its Safe Use in Contact with Foodstuffs and Pharmaceuticals

IS 10146 for use in contact with foodstuffs, pharmaceuticals and drinking water

This product is not recommended for manufacturing of Single Use Plastic (SUP) items listed under Plastics Waste Management (PWM) Rule 2016 and its latest amendment

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