

Technical Data Sheet

LEC 1969

Low Density Polyethylene

LEC 1969 is the first commercially proven tubular LDPE grade for extrusion coating in Iran. This product is developed as general purpose application in extrusion coating segments. LEC 1969 can be used on low and also very high line speed extrusion coating and lamination processes. When processes on suitable hardware, LEC 1969 exhibits excellent draw down ability, good edge stability and low neck-in. Due to its excellent draw down ability and good adhesion, very thin coating layers can be applied on the substrate.

Applications:

Extrusion coating- Laminating- Flexible packaging- Paper coating- Cardboard coating- Aluminum foil coating- Multi-layer packaging.

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Typical Properties	Typical Value ¹	Units	Test Method
Physical			
Melt Flow Index(190°C/2.16 kg)	6.9	dg/ min	ISO 1133
Density ²	919	kg/m ³	ISO 1183
Mechanical³			
Strain at Yield	11	MPa	ISO 527-1,2
Strain at Break	12	MPa	ISO 527-1,2
Strain at Break	>600	%	ISO 527-1,2
Tensile Modulus	160	MPa	ISO 527-1,2
Yield Stress (MD/TD)	11/11	MPa	ISO 527-1,3
Tensile Stress at Break (MD/TD)	17/17	MPa	ISO 527-1,3
Strain at Break (MD/TD)	>700	%	ISO 527-1,3
Extrusion Coating	200	MPa	ISO 527-1,3
Minimum Coating Weight ⁴	5	g/m ²	ASPC Method
Neck-in ⁵	140	mm	ASPC Method
Thermal⁶			
Vicat Softening Temperature (Method A/10N)	85	°C	ISO 306
Melting Temperature	107	°C	ISO 3146
Recommended Process Conditions⁷			
Extruder Temperature profile: 200-320 °C		Melt Temperature at T-Die: 320°C	

1. Typical values: these are not to be construed as specifications
2. The density parameter was determined on compression-molded specimens, which were prepared in accordance with procedure C of ASTM D4703, Annex A1.
3. Properties are based on 25 µm blown film produced at a melt temperature of 160°C and 3 BUR using 100% LEC 1969.
4. Set temperature: 290 Oc
5. Set temperature: 320 oC, Line speed: 310 m/min, Coating: 15 g/m2
6. Properties are based on compression-molded specimens, which were prepared in accordance with procedure B of ASTM D4703, Annex A1, using 100% LEC 1969 resin.
7. Please note that, these processing conditions are recommended by producer only for 100% LEC 1969 resin (not in the case of blending with any other compatible material), but because of the many particular factors which are outside our knowledge and control, and may affect the use of product, no warranty is given.