



DOWLEX™ GM 8480F

The Dow Chemical Company - Linear Low Density Polyethylene Resin

Tuesday, November 5, 2019

General Information

Product Description

DOWLEX™ GM 8480F Polyethylene Resins suitable for cast stretch film applications with superior extensibility while maintaining good puncture and load retention.

Main Characteristics

- Superior extensibility
- Good puncture and load retention

Complies with:

- U.S. FDA FCN 741
- Canadian HPFB No Objection
- EU, No, 10/2011

Consult the regulations for complete details

General

Material Status	• Commercial: Active		
Availability	• Europe	• Latin America	• North America
Additive	• Antiblock: No	• Processing Aid: No	• Slip: No
Agency Ratings	• EU No 10/2011	• FDA FCN 741	• HPFB (Canada) No Objection
Forms	• Pellets		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.919		ASTM D792
Melt Mass-Flow Rate (190°C/2.16 kg)	3.0	g/10 min	ASTM D1238
Films	Nominal Value	Unit	Test Method
Film Thickness - Tested	1	mil	
Film Puncture Resistance	277	ft-lb/in ³	Internal Method
Tensile Strength - MD (Yield)	1450	psi	ASTM D882
Tensile Strength - TD (Yield)	1230	psi	ASTM D882
Tensile Strength - MD (Break)	4680	psi	ASTM D882
Tensile Strength - TD (Break)	2750	psi	ASTM D882
Tensile Elongation - MD (Break)	320	%	ASTM D882
Tensile Elongation - TD (Break)	360	%	ASTM D882
Dart Drop Impact	340	g	ASTM D1709A
Elmendorf Tear Strength - MD	210	g	ASTM D1922
Elmendorf Tear Strength - TD	360	g	ASTM D1922
Thermal	Nominal Value	Unit	Test Method
Melting Temperature (DSC)	250	°F	Internal Method

DOWLEX™ GM 8480F

The Dow Chemical Company - Linear Low Density Polyethylene Resin

Processing Information

Extrusion Notes

Fabrication Conditions for Cast Film:

- Machine: 5 layer cast film extrusion line
- Monolayer Film (0.8mil)
- Screw Size: 2 inch - 30:1 L/D
- Screw Size: 2.5 inch - 30:1 L/D
- Screw Size: 2.5 inch - 30:1 L/D
- Screw Size: 2.5 inch - 30:1 L/D
- Screw Size: 2 inch - 30:1 L/D
- Die Gap: 20 mil
- Melt Temperature: 270 °C
- Output: 400 lbs/hr
- Line Speed: 600 ft/min

Notes

¹ Typical properties: these are not to be construed as specifications.