

Technical Data Sheet  
**IPETHENE® 323**  
 Low Density Polyethylene



**Product Description**

**IPETHENE® 323** is a low-density polyethylene film grade, produced by high-pressure autoclave technology.

<b>Features:</b>	<ul style="list-style-type: none"> <li>High level slip and anti-block additives</li> <li>Heat stabilized</li> <li>BHT free</li> </ul>	<ul style="list-style-type: none"> <li>Excellent draw-down</li> <li>Good processability</li> <li>Good optical properties</li> </ul>
<b>Uses:</b>	<ul style="list-style-type: none"> <li>Carrier and shopping bags</li> <li>General packaging films</li> </ul>	<ul style="list-style-type: none"> <li>Bubble films</li> </ul>
<b>Processing Methods:</b>	<ul style="list-style-type: none"> <li>Blown film extrusion</li> </ul>	<ul style="list-style-type: none"> <li>Cast film extrusion</li> </ul>

Properties		Method	Typical Value*	Unit
<b>Physical</b>				
<b>Melt Flow Rate</b>	(190°C/2.16 kg)	ISO 1133	2.0	g/10 min
<b>Density</b>		ISO 1183-A	0.920	g/cm <sup>3</sup>
<b>Thermal</b>				
<b>Peak Melting Temperature</b>	By DSC	ISO 11357-3	109	°C
<b>Vicat Softening Temperature</b>	(10 N)	ISO 306	93	°C
<b>Mechanical**</b>				
<b>Dart Drop Impact</b>	(F <sub>50</sub> )	ISO 7765-A	200	g
<b>Tensile Stress at Break</b>	(MD/TD)	ISO 527-3	24/21	MPa
<b>Tensile Strain at Break</b>	(MD/TD)	ISO 527-3	500/750	%
<b>Optical**</b>				
<b>Haze</b>		ASTM D 1003	7	%
<b>Gloss</b>	(45°)	ASTM D 2457	75	%

\*Typical values; not to be construed as specifications.

\*\* Measured on 50 µm blown film, Blow-up ratio 2.5:1, output 10 kg/h, melt temperature ~170°C.

**Processing Recommendations**

IPETHENE® 323 can be easily processed on conventional extruders at melt temperature range 155-175°C. Due to differences in screw and die head designs, processing conditions should be optimized for each production line. With suitable equipment, it can be drawn down to 25 µm films.

**Health, Quality, Regulations and Safety**

This product is not classified as dangerous substance and intended for industrial use, to produce plastic articles. Material safety data sheets, international standards certificates and other regulatory documents are available on our website. Carmel Olefins products have not been tested and therefore not validated for use in pharmaceutical/medical applications, and their suitability for these uses cannot be guaranteed. It is the customer's responsibility to test and approve their technical and regulatory suitability in order to satisfy themselves as to the particular purpose and application(s).

Carmel Olefins Ltd. POB 1468 Haifa 31014 Israel  
 Website: <http://www.Carmel-Olefins.co.il>  
 Email: [techserv@caol.co.il](mailto:techserv@caol.co.il)

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