HALDIA PETROCHEMICALS LTD

Halene – H*

TECHNICAL DATA SHEET HD T6

HD T6 is a HDPE General Purpose Extrusion & Lamination Film Grade produced by Mitsui CX Process

HD T6 combines good processability with high mechanical strength.

HD T6 is recommended for Lamination films, Woven sacks, and Tarpaulin.

BIS Designation Code: IS 7328-3P-FB-GXDA

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	0.50
Melt Flow Index (5 kg, 190°C)		g/10 min	1.8
Melt Flow Index (21.6 kg, 190°C)		g/10 min	30
Density (23°C, Annealed)	ASTM D1505, IS 13360 (Part 3/Sec 11)	g/cm^3	0.960
Density (23°C, Annealed)	JIS MCI HZ-F-109	g/cm^3	0.961
Physical Property			
Tensile Strength at Yield	ASTM D638 (50 mm/min)	MPa	30
Tensile Strength at Break		MPa	38
Elongation at Break		%	800
Notched Izod Impact Strength (23°C)	ASTM D256A	J/m	250
Flexural Modulus	ASTM D790A	MPa	1150
Hardness	ASTM D2240	Shore D	65
Vicat Softening Point (10 N)	ASTM D1525	°C	124
DSC Melting Temperature	ASTM D3418	°C	131
Suggested Processing Conditions			
Barrel Temperature	200 – 240 °C		
Die Temperature	220 – 240 °C		
Quench Temperature	25 °C		

*Halene H is the registered trademark of High-Density Polyethylene of Haldia Petrochemicals Limited

Mechanical Properties are on specimens from Compression Molded sheet prepared in accordance with ASTM D4703

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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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