



Formolene® HF4204

High Density Polyethylene (HDPE) Resin for Film Extrusion Applications

Formolene® HF4204 is a hexene based high density film grade designed for cast film extrusion applications requiring good strength and stiffness. Films exhibit good tensile and puncture resistance properties.

Formolene® HF4204 meets all requirements of the U.S. Food and Drug Administration as specified in 21 CFR 177.1520, covering safe use of polyolefin articles intended for direct food contact.

Suggested Applications:

Agricultural film Diaper Backsheet Overwrap films

Additives:

Antiblock - No Slip - No Processing Aid - No

Nominal Values

PROPERTY*	ASTM TEST METHOD	ENGLISH		SI	
		Unit	Value	Unit	Value
Density	D1505	g/cc	0.942	g/cc	0.942
Base Resin Density (without additives)	D1505	g/cc	0.942	g/cc	0.942
Melt Index, (190°C/2.16)	D1238	g/10 min.	4.3	g/10 min.	4.3
Film Properties					
Tested Film Thickness		mil	0.80	µm	20
Tensile Strength					
Yield, MD	D882	psi.	2400	MPa	16
Yield, TD		psi.	2500	MPa	17
Break, MD		psi.	7300	MPa	50
Break, TD		psi.	5000	MPa	34
Tensile Elongation					
Break, MD	D638	%	590	%	590
Break, TD		%	830	%	830
Dart Drop Impact	D1709A	g	< 50	g	< 50
Elmendorf Tear Strength					
MD	D1922	g	20	g	20
TD		g	170	g	170
Optical Properties					
Gloss (45°)	D2457		82		82
Haze	D1003	%	3.4	%	3.4

Note: Film Properties based on cast film line. Actual film properties may vary depending on operating conditions and additive packages. Film properties are not intended to be used as specifications.

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