

CONTENTS

Introduction	4
PART 1. Plastics and Polyolefins	6
PART 2. How Basic Molecular Properties Affect Resin and End-Products Properties	12
PART 3. Properties of Polyethylene Resins and Products, and Test Methods	16
Resin Appearance (Color, Size, Freedom from Foreign Matter, Fines, etc.)	17
Moisture Content	18
Density	18
Melt Index	19
Melting Point	20
Heat Softening Point	20
Yield Strength, Tensile Strength at Rupture, and Elongation	20
Resistance to Creep	21
Stiffness (Torsional, Flexural, 2% Secant Modulus of Elasticity)	21
Hardness	22
Shrinkage	23
Warpage	23
Impact Strength (Toughness)	24
Film Brittleness	25
Film Tear Strength (Elmendorf)	26
Low-Temperature Brittleness	26
Chemical Resistance	27
Resistance to Environmental Stress Cracking	30
Impermeability to Liquid and Gases, Greases and Oils	31
Film Appearance	31
Film Clarity and Freedom from Haze	32
Gloss	32
Film Draw-Down Rate	33
Blocking Resistance and Good Slip	34
Electrical Properties	35

PART 4. Uniformity, Compounding, Blending, Processability	36
Resin Uniformity	36
Stabilizing Additives	37
Slip and Antiblock Agents	39
Antistatic Agents	40
Color Compounds	40
When and When Not to Blend	40
Processability	42
PART 5. Processing Techniques	43
Extrusion (general)	43
Film Extrusion (general)	47
Blown-Film Extrusion	50
Flat-Film Extrusion (general)	61
Chill-Roll or Cast-Film Extrusion	63
Quench-Tank Film Extrusion	68
Sheeting Extrusion	69
Profile, Especially Pipe, Extrusion	71
Extrusion Coating	75
Wire and Cable Coating	87
Blow Molding	93
Injection Molding	111
Miscellaneous Processing Techniques	130
Calendering	130
Thermoforming	130
Compression Molding	135
Casting	136
Polyethylene Powder Processing Techniques	137
PART 6. Packaging, Shipping, and Handling of Polyolefin Resins	139