



聯塑烯 LH606

UNITHENE LH606

High Density Polyethylene Resin

高密度

PE 塑膠

技術資料

臺灣聚合化學品股份有限公司

密度 : 0.962 g/cm³
熔融指數 : 6.0 g/10min

加工方法：射出成型、抽絲

特性及用途

聯塑烯 LH606 是一種高密度聚乙烯，適合於射出成型及抽絲之用。在射出成型方面，常見的用途是水果箱、食品容器、工業用箱、家庭用具、棧板及玩具等。在抽絲加工方面，常用於製造蚊帳、農業用網等細圓絲及複絲。

聯塑烯 LH606 具高抗龜裂性及耐衝擊強度，挺性好，硬度高，光澤好，成型物的變形少，收縮率低，加工性好，延伸性甚佳。

聯塑烯 LH606 染色及印刷十分容易。通常可用乾式混合或熔融混練的方法，輕易染成各種顏色；如製品經過簡單的火燄、化學或電子表面處理後，就可輕易地印刷。

聯塑烯 LH606 符合美國食品藥物管理局 (FDA) 規定，可安全地使用於食品應用方面。

Technical Data Sheet

USI CORPORATION

Density : 0.962 g/cm³
Melt Index : 6.0 g/10min

Processing Method : Injection Molding, Filament Extrusion

Characteristics and Applications

UNITHENE LH606 is a high density polyethylene suitably used for injection molding and filament applications. Typical applications are the injection molding of fruit crates, food containers, industrial items such as pallets, transportation crates, housewares, toys and the fine filament extrusion of mosquito nets, agricultural nets and multifilament applications.

UNITHENE LH606 possesses high impact strength and good resistance to stress cracking, good stiffness, high hardness, good surface gloss, less warpage, low shrinkage, good processability and excellent stretchability.

UNITHENE LH606 can be easily pigmented to any color by either dry blending or melt blending of the pigment into the resin. Printing on items molded from UNITHENE LH606 can be easily accomplished after a simple flame, chemical or electronic surface treatment.

UNITHENE LH606 meets the requirement of the U.S. Food and Drug Administration regulation. It can be safely used for food applications.

物理性質 (Physical Properties) :

項 目 Properties	試 驗 方 法 Test Method	數 值 Typical Value
熔融指數 (g/10min) Melt Index	ASTM D1238	6.0
密度 (g/cm ³) Density	ASTM D1505	0.962
降伏點抗張強度* (kg/cm ²) Tensile Strength (Yield)	ASTM D638	310
斷裂點抗張強度* (kg/cm ²) Tensile Strength (Break)	ASTM D638	220
斷裂點伸長率* (%) Ultimate Elongation	ASTM D638	600
艾氏衝擊強度**(kg-cm/cm 刻溝) Izod Impact Strength (notched)	ASTM D256	7.0
低溫脆性 (/F50) Low Temperature Brittleness	ASTM D747	<-76
衛氏軟化溫度 () Vicat Softening Point	ASTM D1525	127
熔點 () Melting Point	DSC	131
硬度 (Shore D) Hardness	ASTM D2240	69

* : 壓縮成型試片(Compression molded)

** : 射出成型試片,厚度 3.18mm (Injection molded specimen with 3.18mm thickness)

加工條件

單絲加工(摻 20%低密度聚乙烯)

擠壓機：螺桿直徑 40mm

長徑比 19 倍

過濾網 40×100×100×100×40 目

模孔直徑 0.8mm

模頭與冷卻水面距離 30mm

延伸水槽長度 240cm

溫度：擠筒 140、180、265，模頭 260，熔料 260，

冷卻水槽 30，延伸水槽 90

延伸比：8 倍

捲繞速度：90M/min

Processing Condition

Monofilament(Blended with 20% low density PE)

Extruder : Screw diameter 40mm

L/D ratio 19

Screen packs 40×100×100×100×40mesh

Die orifice diameter 0.8mm

Air gap 30mm

Length of stretching bath 240cm

Temperature : Cylinder 140, 180, 265, Die 260, Melt 260

, Cooling water bath 30, Stretching water bath 90

Stretching ratio : 8 times

Rolling speed : 90M/min

成品性質 (85 丹尼)

Product Properties (85 Denier)

項 目 Properties	試 驗 方 法 Test Method	數 值 Typical Value
韌度 Tenacity (g/denier)	ASTM D882	3
伸長率 Elongation (%)	ASTM D882	50
打結強度 Knot Tenacity (g/denier)	ASTM D882	3

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