

Material	Experimental Run [Resin in %-weight ratio]													
	1	2	3	4	5	6	7	8	9	10	11	12	13	14
LDPE	100													
DOW® INFUSE™ 9010		100						60	60	90	90	90	90	90
DOW® INFUSE™ 9010 masterbatch								30	30					
DOW® ENGAGE™ 8842			100		50					10	10	10		
DOW® ENGAGE™ 8842 masterbatch				100	50	30	50							
DOW® INFUSE™ 9107						70	50	10	10				10	10
Thickness (mm)	62	75	280	47	125	64	170	104	70	280	100	70	102	60
Tensile Strength (MD), Mpa	15.3	8.6	4.7	6.1	4.7	5.7	2.3	8.9	9.7	7.4	9.6	8.6	10.5	9.2
Tensile Strength (TD), Mpa	-	-	-	-	-	-	-	6.2	7.3	-	8.4	5.5	6.8	8.0
Tensile Elongation at break (MD), %	380	570	1200	870	1200	780	780	925	660	700	630	570	640	800
Tensile Elongation at break (TD), %	-	-	-	-	-	-	-	650	540	-	630	520	560	750

Fig. 1

Material	Experimental Run [Resin in %-weight ratio]													
	1	2	3	4	5	6	7	8	9	10	11	12	13	14
LDPE	100													
DOW® INFUSE™ 9010		100						60	60	90	90	90	90	90
DOW® INFUSE™ 9010 masterbatch								30	30					
DOW® ENGAGE™ 8842			100		50					10	10	10		
DOW® ENGAGE™ 8842 masterbatch				100	50	30	50							
DOW® INFUSE™ 9107						70	50	10	10			10	10	10
Thickness (mm)	62	75	280	47	125	64	170	104	70	280	100	70	102	60
Die lip gap, mm		100	200	75	100	100	150	100	75	100	100	100	100	75
Barrel Temperature, °C		250	195	195	195	195	195	235	235	235	235	235	235	235
Melt Temperature, °C		250	200	200	200	200	200	250	250	250	250	250	250	250
Die Temperature, °C		265	190	190	190	190	190	265	265	265	265	265	265	265
Rewinding speed, m/min		1	1	1.5	1	1.5	1	1.5	1.5	1	1.5	2.0	1.5	1.5

Fig. 2

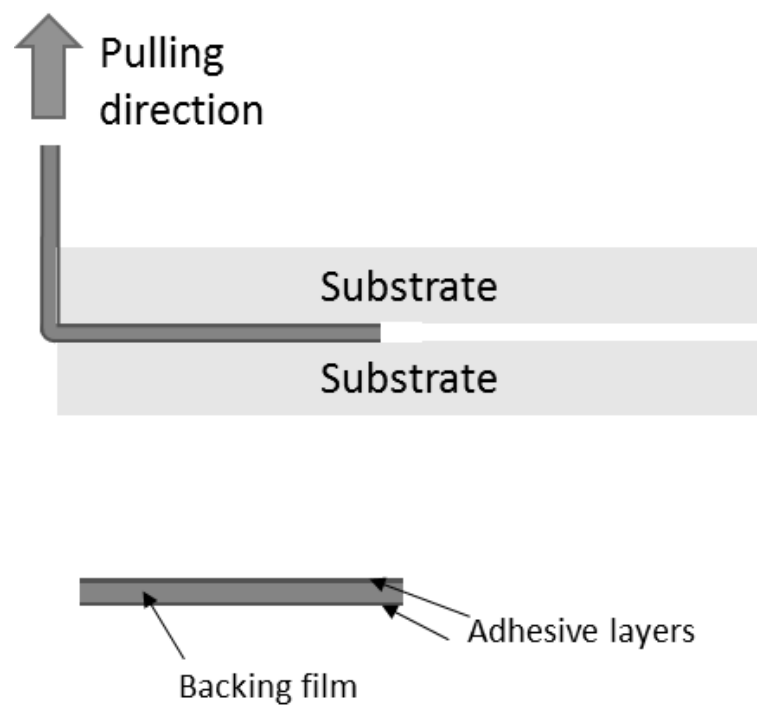


Fig 3A

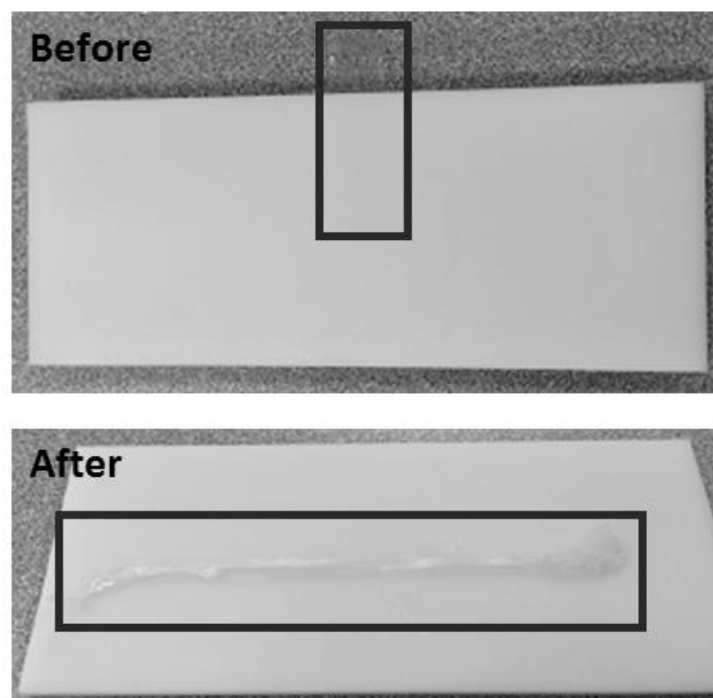


FIG. 3B