



Standard Specification for Polyethylene Films Made from Low-Density Polyethylene for General Use and Packaging Applications¹

This standard is issued under the fixed designation D 4635; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers unpigmented, unsupported, tubular, low-density polyethylene films (hereafter referred to as film or films) from resins having densities ranging from 910.0 to 925.0 kg/m³ (0.910 to 0.925 g/cm³), inclusive, as measured on molded plaques.

NOTE 1—The density of a film will not necessarily be equal to the density of a molded plaque from the same resin.

NOTE 2—Blends of ethylene/vinylacetate (EVA) with low-density polyethylene may have densities up to 0.929 g/cm³.

1.2 This specification is applicable to homopolymer polyethylene, but is not restricted to it. It is applicable to films made from copolymer polyethylene commonly referred to in industry as low-pressure or linear low-density polyethylene, and also applicable to films made from blends of homopolymers and copolymers, including ethylene/vinylacetate copolymers.

1.3 The thickness of the films covered by this specification is 100 μ m or less (0.004 in. or less), inclusive. The maximum width of the sheet or layflat is 3.00 m (120 in.).

1.4 This specification does not cover oriented heat-shrinkable films.

1.5 This specification allows for the use of recycled polyethylene film or resin as feedstock, in whole or in part, as long as all of the requirements of this specification are met and as long as any specific requirements as governed by the producer and end user are also met. (See Note 3.)

NOTE 3—Guide D 5033 describes terminology and definitions related to recycled plastics.

1.6 This specification defines the levels of the various physical properties from which specifications for specific films may be described. The levels of physical properties required by a film for a given application are selected from Section 6. However, Sections 2-5 relating to tolerances shall apply without change to all film falling within the scope indicated by the title and 1.1-1.4.

1.7 This specification covers dimensional tolerances, clas-

sifications, intrinsic quality requirements, and test methods. The dimensional tolerances include thickness, width, and length or yield. Classification defines types, classes, surfaces, and finishes. The intrinsic quality requirements include density, workmanship, tensile strength, heat sealability, and odor, as well as the classification properties for impact strength, coefficient of friction, optical properties, and surface treatment. A sampling method is included.

1.8 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

1.9 The following precautionary caveat pertains only to the test methods portion, Section 10, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

NOTE 4—There is no similar or equivalent ISO specification.

2. Referenced Documents

2.1 ASTM Standards:

D 618 Practice for Conditioning Plastics and Electrical Insulating Materials for Testing²

D 882 Test Methods for Tensile Properties of Thin Plastic Sheeting²

D 883 Terminology Relating to Plastics²

D 1003 Test Method for Haze and Luminous Transmittance of Transparent Plastics²

D 1505 Test Method for Density of Plastics by the Density-Gradient Technique²

D 1709 Test Methods for Impact Resistance of Plastic Film by the Free-Falling Dart Method²

D 1894 Test Method for Static and Kinetic Coefficients of Friction of Plastic Film and Sheeting²

D 1898 Practice for Sampling of Plastics²

D 1928 Practice for Preparation of Compression-Molded Polyethylene Test Sheets and Test Specimens²

D 2103 Specification for Polyethylene Film and Sheeting²

D 2457 Test Method for Specular Gloss of Plastic Films and Solid Plastics³

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Current edition refers to resin density, not film density; it also has a revised section for inspection and certification.

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² Annual Book of ASTM Standards, Vol 08.01.

³ Annual Book of ASTM Standards, Vol 08.02.

D 2578 Test Method for Wetting Tension of Polyethylene and Polypropylene Films³

D 4321 Test Method for Package Yield of Plastic Film³

D 5033 Guide for the Development of Standards Relating to the Proper Use of Recycled Plastics⁴

E 462 Test Method for Odor and Taste Transfer from Packaging Film⁵

F 88 Test Methods for Seal Strength of Flexible Barrier Materials⁶

NOTE 5—Relevant government regulations also apply to this specification.

NOTE 6—If this product is intended for packaging foods, medicines, drugs, and cosmetics, it is subject to applicable regulations of the Food and Drug Administration or the Department of Agriculture and must comply with such regulations. If it is necessary to comply with regulations of other government agencies, such as the Consumer Product Safety Commission, Environmental Protection Agency, Department of Transportation, Federal Trade Commission, or others, such compliance should be arranged between the buyer and the seller prior to placing an order.

3. Terminology

3.1 *Definitions*—Unless otherwise indicated, the terminology used in this specification is in accordance with Terminology D 883.

4. Classification

4.1 The low-density polyethylene film is, by this specification, classified by Types 1, 2, and 3; Surfaces 1, 2, and 3; Classes 1, 2, 3, and 4; and Finishes 1, 2, 3, and 4. These classifications are described in detail in 6.1.

5. Materials

5.1 The film shall be made from an ethylene homopolymer, ethylene copolymers, or blends of homopolymers or copolymers, or homopolymer and copolymer, so that it meets the density and other film requirements listed herein.

5.2 The film shall be made from resins having densities between 910.0 and 925.0 kg/m³ (0.910 and 0.925 g/cm³), inclusive. This is the range of standard densities in the definition of low-density polyethylene (see Terminology D 883). Standard density refers to the density of the material molded to a thickness of 1.9 mm (0.075 in.) using the procedures of Method C of Practice D 1928 (see Note 1).

5.3 The film shall be natural in color (essentially colorless).

6. Physical Requirements

6.1 Classification Properties:

6.1.1 *Type*—The dart drop impact for all thickness of film shall be as specified in Table 1 for Types 1, 2, and 3.

6.1.2 *Surface*—The kinetic coefficient of friction shall be as specified in Table 2 for Surfaces 1, 2, and 3.

6.1.3 *Class*—The optical properties shall be as specified in Table 3 for Classes 1, 2, and 3. The optical properties of gloss and haze do not always correlate. The particular property of most importance for the specific application shall be established, and the value for this property shall then govern in case of any inconsistency.

⁴ Annual Book of ASTM Standards, Vol 08.03.

⁵ Annual Book of ASTM Standards, Vol 15.07.

⁶ Annual Book of ASTM Standards, Vol 15.09.

TABLE 1 Classification for Type

Film Thickness		Drop Dart (g, min) ⁴		
μm	in.	Type 1	Type 2	Type 3
<25	not specified	not specified	not specified	not specified
25	0.001	40	75	105
38	0.0015	65	105	140
50	0.002	85	135	175
75	0.003	125	195	245
100	0.004	165	255	315

⁴ Impact limits for thickness not covered in this table will be determined by linear interpolation between successive values in this table.

TABLE 2 Classification for Surface

Surface	Coefficient of Friction
1	>0.5
2	>0.2 to 0.5
3	0.2 or less

TABLE 3 Classification for Classes

Class	Gloss Units	Haze, %
1	30 or less	>25
2	>30 to 50	>10 to 25
3	>50 to 70	>5 to 10
4	>70	0 to 5

6.1.4 *Finish*—The surface treatment level of the film shall be as specified in Table 4 for Finishes 1, 2, 3, and 4.

6.2 Other Properties:

6.2.1 *Tensile Properties*—The tensile strength and elongation at break for all thicknesses shall be as specified in Table 5.

6.2.2 *Heat Sealability*—The minimum ratio of heat-seal strength to the film strength in the two principal directions shall be as specified in Table 6.

6.2.3 *Odor*—The odor level of the film shall average no more than a 3.5 rating level.

7. Dimensions

7.1 *Size*—The nominal thickness, width, length per roll or roll diameter, and yield of the film shall be established by mutual agreement between the purchaser and the supplier.

7.2 *Thickness Tolerance*—The thickness variation across the film shall be within the tolerances given in Table 7.

7.3 *Width Tolerance*—The width shall be within the tolerances given in Table 8.

7.4 *Yield Tolerance*—The deviation of the actual yield from nominal yield shall be within the tolerances given in Table 9.

7.5 *Flatness*—The flatness of the film shall be within limits as mutually agreed upon between the buyer and the seller.

7.6 Dimension tolerances for “J-Sheeting” lip and gusset depth shall be established by mutual agreement between the purchaser and the supplier.

TABLE 4 Classification for Finish

Finish	Wetting Tension, mN/m (dynes/cm)
1	32, 33, 34
2	35, 36, 37
3	38, 39, 40
4	41 and over

TABLE 5 Tensile Properties

Property	Units	Machine Direction	Transverse Direction
Tensile Strength, min	MPa (psi)	11.7 (1700)	8.3 (1200)
Tensile Elongation, min	%	225	350

TABLE 6 Heat Sealability^A

Finish of Contact Surfaces ^B	Heat Sealability, min
2 to 2	0.60
1 to 2	0.60
1 to 1	0.75

^A Heat sealability is the ratio of the tensile strength of the heat-sealed specimen to the tensile strength of the original film specimen.

^B Heat sealability is not applicable to films with finish greater than two; this does not infer that films with finishes greater than two cannot be sealed.

8. Workmanship, Finish, and Appearance

8.1 *Film*—The film shall have workmanship qualities conforming to good commercial practice. The quality of film with regard to gels, streaks, pinholes, particles of foreign matter, scratches, wrinkles, wind chatter, undispersed raw materials, holes, tears, and blisters shall be mutually established by the purchaser and the supplier.

8.2 Roll Formation:

8.2.1 The diameter of cores upon which film is wound shall be established by mutual agreement between the purchaser and the supplier. Cores upon which film is wound must not be recessed at either edge of the roll, but may extend up to 6 mm (¼ in.) beyond either edge of the roll. Rolls with cores that are crushed and are not able to be mounted on the purchaser's equipment are to be considered rejects.

8.2.2 Ridges and soft spots which result in bagginess and looseness of the unwound film are unacceptable and may be rejected by the purchaser on a roll-to-roll basis if the conditions contribute to poor performance of the film in end-use application.

8.2.3 The edges of the roll must be free of nicks and cuts, and the general condition of roll edges must not interfere with the unwinding of the rolls.

8.2.4 The type and number of splices, flaggings of splices, or breaks (if unspliced) in rolls of more than one piece shall be established by mutual agreement between the supplier and the purchaser.

9. Sampling

9.1 Statistically based sampling plans which are appropriate for each particular product or quantity may be used to obtain samples for use in determining compliance with this specification. Refer to Practice D 1898 for guidance.

9.2 For the purposes of developing supplier-purchaser specifications, a lot size generally refers to the number of rolls in a lot. Sampling units are those rolls selected by random numbers from the lot. A unit sample is the sample of film taken from the roll. Care must be exercised in taking unit samples. Unwind and then discard several turns from the roll and then take more than enough sample to run all specified tests. Keep the sample from becoming soiled. Ensure that the sample is not folded or creased excessively.

10. Test Methods

10.1 *Conditioning*—Condition the samples or test specimens, or both, at $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$) before testing. In cases of disagreement, condition the test specimens for not less than 40 h prior to test, in accordance with Procedure A of Practice D 618 for those tests where conditioning is required.

10.2 *Test Conditions*—Conduct tests at the standard laboratory temperature of $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$).

10.3 *Width*—Measure width with a metal rule capable of measuring to an accuracy of ± 1 mm ($1/16$ in.).

10.4 *Thickness*—Measure thickness in accordance with the General Test Methods section of Specification D 2103, with the modification that the specimen shall be taken as a 50-mm (2-in.) strip across the web and measured at intervals of not more than 50 mm.

10.5 *Yield*—See Test Method D 4321.

10.6 *Flatness*—Measure flatness using a method mutually agreed upon between the purchaser and the supplier.

10.7 *Density*—The density of resins from which the film is made shall be measured in accordance with Test Method D 1505.

10.8 *Coefficient of Friction*—The kinetic coefficient of friction shall be measured in accordance with Test Method D 1894. The test shall be conducted film to film, in both the machine direction and transverse direction.

10.9 Optical Properties:

10.9.1 *Clarity*—Measure clarity of the film by visual or instrumented means, as agreed upon between the purchaser and the supplier.

10.9.2 *Gloss*—Measure gloss of the film in accordance with Test Method D 2457, using a 45° gloss head.

10.9.3 *Haze*—Measure haze in accordance with Test Method D 1003.

10.10 *Wetting Tension*—Measure wetting tension in accordance with Test Method D 2578.

10.11 *Impact Resistance*—Measure impact resistance in accordance with Test Methods D 1709, except that Test Method A shall be used for all gages of film.

10.12 *Tensile Properties*—Measure tensile strength and elongation at break in accordance with Test Methods D 882.

10.13 *Heat Sealability*—Measure heat sealability in accordance with Test Methods F 88, Test Method B, Dynamic Load Test.

10.14 *Odor*—Measure odor level in accordance with Test Method E 462, low to moderate scale.

11. Inspection and Certification

11.1 Inspection and certification of the material supplied under this specification shall be for conformance to the requirements specified herein.

11.2 Lot-acceptance inspection shall be the basis on which acceptance or rejection of the lot is made. The lot-acceptance inspection shall consist of those tests that ensure process control during manufacture as well as those necessary to ensure certification in accordance with 11.4.

11.3 Periodic check inspection shall consist of the tests specified for all requirements of the material under this specification. Inspection frequency shall be adequate to ensure

TABLE 7 Tolerance, Percent from Nominal Thickness^A

Film Width		Nominal Thickness		Across Film ^B % Tolerance
mm	in.	µm	in.	
1250 or less	50 or less	25 to 65	0.001 to 0.004	± 20
>1250 to 3000	>50 to 120	25 to 65	0.001 to 0.004	± 25

^A Use Table 9 as the controlling table for average gage in terms of yield. For minimum gage requirements, order film specifying nominal gage greater than the required minimum by at least the percent tolerance set above.

^B No single measurement shall differ from the nominal gage by more than the tolerance listed in this table.

TABLE 8 Width Tolerances^A

Film Widths	Sheeting	Layflat Tubing
375 mm (15 in.) or less	-0, + 5 mm (3/16 in.)	± 5 mm (3/16 in.)
>375 to 750 mm (15 to 30 in.)	-0, + 6 mm (1/4 in.)	± 10 mm (3/8 in.)
>750 to 1.5 m (30 to 60 in.)	-0, + 10 mm (3/8 in.)	± 16 mm (5/8 in.)
>1.5 to 3 m (60 to 120 in.)	-0, + 13 mm (1/2 in.)	± 25 mm (1 in.)

^A Across sheet or layflat tubing.

TABLE 9 Deviation,^A Actual Yield from Nominal Yield

Quantity	Tolerances
Any one roll	± 10 %
500 kg (1000 lb) or less	± 10 %
>500 to 1000 kg (1000 to 2500 lb)	± 5 %
Over 1000 kg (2500 lb)	± 3 %

^A Negative deviation generally infers that the average gage is greater than nominal. Positive deviation generally infers that the average gage is less than nominal.

that the material is certifiable in accordance with 11.4.

11.4 Certification shall be that the material was manufactured, sampled, tested, and inspected in accordance with this specification and that average values meet the requirements at a confidence level of 95 %.

11.5 A report of the test results shall be furnished when requested. The report shall consist of results of the lot-acceptance inspection for the shipment and results of the most recent periodic-check inspection.

12. Packaging and Package Marking

12.1 *Packaging*—The film shall be packaged in standard commercial containers, so constructed as to ensure acceptance by common or other carriers for transportation to the point of

delivery, unless otherwise specified in the contract or order.

12.2 *Labels and Literature*—So that purchasers may know that the film has been manufactured in compliance with this specification, it is suggested that the supplier include an appropriate statement to this effect on labels, invoices, or another place.

12.3 Identification of the film shall include:

12.3.1 *Manufacturer's Name*,

12.3.2 *Type*,

12.3.3 *Surface*,

12.3.4 *Class*,

12.3.5 *Finish* (if treated, the treated side of the film shall be clearly identified), and

12.3.6 Reference to this specification number.

13. Keywords

13.1 film; general use; low-density; packaging; polyethylene; recycled plastics

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