

# Appeel® 20D867

Ethylene Acrylate Copolymer  
DuPont Packaging & Industrial Polymers

## Message:

DuPont™ Appeel 20D867 is a modified ethylene acrylate resin designed to function as a sealing layer for lidding applications. It is most often suggested to provide peelable seals over a broad temperature range to a number of container materials including PET, PVC, PS and PP. Appeel 20D867 is available in pellet form for use in conventional extrusion and coextrusion equipment designed to process polyethylene resins.

General Information			
Uses	Cover		
	Seals		
Agency Ratings	FDA 21 CFR 177.1340		
Forms	Particle		
Processing Method	Co-extrusion molding		
	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.941	g/cm <sup>3</sup>	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	9.1	g/10 min	ASTM D1238, ISO 1133
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	47.0	°C	ASTM D1525, ISO 306
Peak Melting Temperature	90.0	°C	ASTM D3418, ISO 3146
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	140	°C	
Cylinder Zone 2 Temp.	150	°C	
Cylinder Zone 3 Temp.	160	°C	
Cylinder Zone 4 Temp.	180	°C	
Cylinder Zone 5 Temp.	180	°C	
Adapter Temperature	180	°C	
Melt Temperature	160 - 185	°C	
Die Temperature	170	°C	
Extrusion instructions			

The above processing values are for blown film.Extrusion coating/lamination parameters:  
Feed Zone: 160°C  
Second Zone: 210°C  
Third Zone: 260°C  
Fourth Zone: 285°C  
Fifth Zone: 285°C  
Adapter Zone: 285°C  
Die Zone: 285°C  
Melt Temperature: 235 to 285°C

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