

Surlyn® 1652

Ionomer

DuPont Packaging & Industrial Polymers

Message:

Surlyn® 1652 is available for use in conventional blown, cast film, sheet extrusion and coextrusion equipment. It is also used in extrusion coating and coextrusion coating equipment designed to process polyethylene and ethylene copolymer type resins.

General Information			
Uses	Films		
	cast film		
	Sheet		
	Coating application		
Agency Ratings	FDA 21 CFR 177.1330(a)		
Forms	Particle		
Processing Method	Blow film		
	Co-extrusion molding		
	Extrusion		
	Extrusion coating		
	cast film		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.940	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	5.2	g/10 min	ASTM D1238, ISO 1133
Ion Type	Zinc		
Freezing Point			
--	80	°C	ISO 3146
--	80	°C	ASTM D3417
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	79.0	°C	ASTM D1525, ISO 306
Peak Melting Temperature	100	°C	ASTM D3417, ISO 3146
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	135	°C	
Cylinder Zone 2 Temp.	160	°C	
Cylinder Zone 3 Temp.	185	°C	
Cylinder Zone 4 Temp.	185	°C	
Cylinder Zone 5 Temp.	185	°C	
Adapter Temperature	185	°C	
Melt Temperature	185 - 285	°C	
Die Temperature	185	°C	

Extrusion instructions

The above processing values are for blown film.Cast film parameters:

Feed Zone: 160°C

Second Zone: 210°C

Third Zone: 235°C

Fourth Zone: 235°C

Fifth Zone: 235°C

Adapter Zone: 235°C

Die Zone: 235°C

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

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