

PRIMACOR™ 1321

Copolymer

The Dow Chemical Company

Message:

PRIMACOR™1321 copolymer is an ethylene acrylic acid copolymer suitable for extrusion blow molding and cast films.
PRIMACOR 1321 copolymer is specially used as adhesive layer in composite film or sealant layer in soft envelope structure.
PRIMACOR 1321 copolymer has the following characteristics:
has good interlayer adhesion with PE and PA
Good optical performance
Excellent toughness and strength
Excellent environmental stress cracking resistance and packaging content resistance
Good thermal adhesion and heat sealing properties
Insensitive to moisture
Application field:
Multilayer composite
food packaging
Meet the following regulatory requirements:
U.S. Food and Drug Administration U.S. FDA 21 CFR 177.1310(a)(1)
European Union (EU) No 10/2011
please refer to the regulations for detailed information.

General Information			
Agency Ratings		FDA 21 CFR 177.1310 (a) 1 Europe No 10/2011	
Forms		Particle	
Processing Method		Blow film cast film	
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.935	g/cm ³	ASTM D792, ISO 1183/A
Melt Mass-Flow Rate (MFR) ¹ (190°C/2.16 kg)	2.6	g/10 min	ASTM D1238, ISO 1133
Comonomer Content ²	6.5	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield, molding ³	10.0	MPa	ASTM D638
Yield, molding	10.0	MPa	ISO 527-2/508
Fracture, molding ⁴	20.1	MPa	ASTM D638
Fracture, molding	20.1	MPa	ISO 527-2/508
Tensile Elongation			
Fracture, molding ⁵	640	%	ASTM D638
Fracture, molding	640	%	ISO 527-2/508
Films	Nominal Value	Unit	Test Method
Tensile Strength			

MD: Yield, 51 µm	11.3	MPa	ASTM D882
TD: Yield, 51 µm	11.1	MPa	ASTM D882
MD: Yield, 51 µm	11.3	MPa	ISO 527-3
TD: Yield, 51 µm	11.5	MPa	ISO 527-3
MD: Fracture, 51 µm	31.8	MPa	ASTM D882, ISO 527-3
TD: Fracture, 51 µm	31.8	MPa	ASTM D882, ISO 527-3
Tensile Elongation			ASTM D882, ISO 527-3
MD: Fracture, 51 µm	460	%	ASTM D882, ISO 527-3
TD: Fracture, 51 µm	510	%	ASTM D882, ISO 527-3
Dart Drop Impact (51 µm)			
	410	g	ASTM D1709B, ISO 7765-1/B
Elmendorf Tear Strength ⁶			
MD : 51 µm	270	g	ASTM D1922
TD : 51 µm	390	g	ASTM D1922
MD : 51 µm	1200	N	ISO 6383-2
TD : 51 µm	1700	N	ISO 6383-2
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	88.9	°C	ASTM D1525, ISO 306
Melting Temperature (DSC)	103	°C	Internal method
Optical	Nominal Value	Unit	Test Method
Gloss (45°, 50.8 µm)	76		ASTM D2457
Haze			
50.8 µm	3.7	%	ASTM D1003
50.8 µm	3.7	%	ISO 14782
Extrusion instructions			

薄膜的制造条件:用于处理此树脂的设备应由耐腐蚀材料制成.建议模具和适配器采用不锈钢和/或双面镀铬或镀镍.

螺杆尺寸:2.5 英寸 (63.5 mm);30:1 L/D

螺杆类型:带 Maddock Mixer 的单跨型

模具间隙:40 密尔 (1.0 mm)

熔体温度:380°F (193°C)

输出:模具周长的 6 磅/小时/英寸

模具直径:6 英寸

放大比:2.5:1

冷冻线高度:29 英寸 (737 mm)

NOTE	
1.	As measured during production.
2.	The comonomer content measured by Dow attribute method has the same accuracy as ASTM D 4094.
3.	510 mm/min
4.	510 mm/min
5.	510 mm/min
6.	The comonomer content measured by Dow attribute method has the same accuracy as ASTM D 4094.

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