

PRIMACOR™ 3330

Copolymer

The Dow Chemical Company

Message:

PRIMACOR™3330 copolymer is an ethylene acrylic acid copolymer suitable for extrusion coating and extrusion lamination applications.

PRIMACOR 3330 copolymer is specially used as binder resin or sealant layer in extrusion and co-extrusion coating and extrusion lamination. PRIMACOR 3330 copolymer has the following characteristics:

Excellent adhesion with metal, paper and PE substrates

Excellent heat sealing performance and heat adhesion performance

Excellent toughness

excellent grease resistance

Insensitive to moisture

Application field:

Soft packaging composites

plastic pipe composite material

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	Extrusion coating		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.932	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) ¹ (190°C/2.16 kg)	5.8	g/10 min	ASTM D1238, ISO 1133
Comonomer Content ²	6.5	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638, ISO 527-2
Yield, molding	8.34	MPa	ASTM D638, ISO 527-2
Fracture, molding	17.4	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break, Compression Molded)	520	%	ASTM D638, ISO 527-2
Films	Nominal Value	Unit	Test Method
Seal Initiation Temperature ³	92.8	°C	Internal method
Water Vapor Transmission Rate (38°C, 90% RH)	0.40	g·mm/m ² /atm/24 hr	DIN 53122/2
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	85.0	°C	ASTM D1525, ISO 306
Melting Temperature (DSC)	100	°C	Internal method
Extrusion	Nominal Value	Unit	Test Method
Melt Temperature	260 - 290	°C	

Neck-in (288°C, 25.4 µm)	50.8	mm	Internal method
Minimum coating thickness	20	µm	Internal method
Minimum coating weight	20	g/m ²	Internal method

Extrusion instructions

挤出涂层薄膜的制造条件: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:3.5 英寸 (89 mm);30:1 L/D

模具:30 英寸模具切边至 24 英寸

模具间隙:20 密尔 (0.508 mm)

熔体温度:550 °F (288 °C)

输出:250 磅/小时

气隙:6 英寸 (152 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. 25g/m coating at 290°C set temperature.

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