

PRIMACOR™ 1410

Copolymer

The Dow Chemical Company

Message:

PRIMACOR™1410 copolymer is an ethylene acrylic acid copolymer, suitable for single-layer or co-extrusion blown films.

PRIMACOR 1410 copolymer is specially used as heat seal layer or adhesive layer in composite film.

PRIMACOR 1410 copolymer has the following characteristics:

Excellent heat sealing performance and heat adhesion performance

Excellent toughness and strength

excellent cracking resistance

Insensitive to moisture

Good optical performance

Application field:

special packaging and body-fitting packaging

Multilayer composite

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		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.938	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) ¹ (190°C/2.16 kg)	1.5	g/10 min	ASTM D1238, ISO 1133
Comonomer Content ²	9.7	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield, molding ³	8.39	MPa	ASTM D638
Yield, molding	8.39	MPa	ISO 527-2/508
Fracture, molding ⁴	22.5	MPa	ASTM D638
Fracture, molding	22.5	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	11.8	MPa	ASTM D882
TD: Yield, 51 µm	10.9	MPa	ASTM D882
MD: Yield, 51 µm	11.8	MPa	ISO 527-3

TD: Yield, 51 µm	10.9	MPa	ISO 527-3
MD: Fracture, 51 µm	37.9	MPa	ASTM D882, ISO 527-3
TD: Fracture, 51 µm	38.1	MPa	ASTM D882, ISO 527-3
Tensile Elongation			ASTM D882, ISO 527-3
MD: Fracture, 51 µm	400	%	ASTM D882, ISO 527-3
TD: Fracture, 51 µm	470	%	ASTM D882, ISO 527-3
Dart Drop Impact (51 µm)	580	g	ASTM D1709B, ISO 7765-1/B
Elmendorf Tear Strength ⁶			
MD : 51 µm	380	g	ASTM D1922
TD : 51 µm	510	g	ASTM D1922
MD : 51 µm	1700	N	ISO 6383-2
TD : 51 µm	2300	N	ISO 6383-2
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	81.1	°C	ASTM D1525, ISO 306
Melting Temperature (DSC)	97.8	°C	Internal method
Optical	Nominal Value	Unit	Test Method
Gloss (45°, 50.8 µm)	65		ASTM D2457
Haze			
50.8 µm	5.8	%	ISO 14782
50.8 µm	5.8	%	ASTM D1003
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:385°F (196°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 crosshead speed is 20 inches per minute.

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