

Surlyn® 1652SR

Ionomer

DuPont Packaging & Industrial Polymers

Message:

Surlyn® 1652SR 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			
Additive	Cooling roller release agent slip agent		
Features	smoothness		
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 coating cast film Sheet extrusion molding		

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)	5.4	g/10 min	ASTM D1238, ISO 1133
Ion Type	Zinc		
Freezing Point			
--	81	°C	ISO 3146
--	81	°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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