

Surlyn® 1605SBR

Ionomer

DuPont Packaging & Industrial Polymers

Message:

Surlyn® 1605SBR 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	Anti-caking agent
	Cooling roller release agent
	slip agent
Features	smoothness
	Anti-caking property
	Compliance of Food Exposure
Uses	Films
	cast film
	Sheet
Agency Ratings	FDA 21 CFR 177.1330(a)
Processing Method	Blow film
	Co-extrusion molding
	Extrusion coating
	cast film
	Sheet extrusion molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.950	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	3.0	g/10 min	ASTM D1238, ISO 1133
Ion Type	Sodium		
Freezing Point			
--	67	°C	ISO 3146
--	67	°C	ASTM D3417
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	64.0	°C	ASTM D1525, ISO 306
Peak Melting Temperature	95.0	°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/sheet 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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