

PRIMACOR™ 3460

Copolymer

The Dow Chemical Company

Message:

PRIMACOR™3460 copolymer is an ethylene acrylic acid copolymer suitable for extrusion coating and extrusion lamination applications.

PRIMACOR 3460 copolymer is specially used as a sealing layer and adhesive layer in soft packaging and tissue paper coating.

PRIMACOR 3460 copolymer has the following characteristics:

Excellent heat sealing performance and heat adhesion performance

Excellent adhesion with metal, paper and PE substrates

Good stress cracking resistance

Designed for high-speed production lines and low-temperature processing conditions

Insensitive to moisture

Application field:

Soft packaging

tissue coating

Metal substrate 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	Extrusion coating		
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)	20	g/10 min	ASTM D1238, ISO 1133
Comonomer Content ²	9.7	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638, ISO 527-2
Yield, molding	7.24	MPa	ASTM D638, ISO 527-2
Fracture, molding	16.2	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break, Compression Molded)	580	%	ASTM D638, ISO 527-2
Films	Nominal Value	Unit	Test Method
Seal Initiation Temperature ³	85.0	°C	Internal method
Water Vapor Transmission Rate (38°C, 90% RH)	0.44	g·mm/m ² /atm/24 hr	DIN 53122/2
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	72.2	°C	ASTM D1525, ISO 306
Melting Temperature (DSC)	95.0	°C	Internal method
Extrusion	Nominal Value	Unit	Test Method

Melt Temperature	220 - 260	°C	
Neck-in (288°C, 25.4 μm)	71.1	mm	Internal method
Minimum coating thickness	10	μm	Internal method
Minimum coating weight	9.8	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:425°F (218°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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