

Surlyn® 1650

Ionomer

DuPont Packaging & Industrial Polymers

Message:

Surlyn® 1650 is available for use in conventional blown, cast film, and sheet extrusion equipment. It is also used in coextrusion equipment designed to process polyethylene and ethylene copolymer type resins.

General Information			
Uses	Films		
	cast film		
	Sheet		
Agency Ratings	FDA 21 CFR 177.1330(a)		
Forms	Particle		
Processing Method	Blow film		
	Co-extrusion molding		
	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)	1.8	g/10 min	ASTM D1238, ISO 1133
Ion Type	Zinc		
Freezing Point			
	--	73	°C
	--	73	°C
			ISO 3146
			ASTM D3417
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	73.0	°C	ASTM D1525, ISO 306
Peak Melting Temperature	97.0	°C	ASTM D3417, ISO 3146
Extrusion	Nominal Value	Unit	
Cylinder Zone 1 Temp.	160	°C	
Cylinder Zone 2 Temp.	210	°C	
Cylinder Zone 3 Temp.	235	°C	
Cylinder Zone 4 Temp.	235	°C	
Cylinder Zone 5 Temp.	235	°C	
Adapter Temperature	235	°C	
Melt Temperature	160 - 260	°C	
Die Temperature	235	°C	
Extrusion instructions			

Blown Film Parameters:Feed Zone: 135°CSecond Zone:160°CThird Zone: 185°CFourth Zone: 185°C Fifth Zone: 185°CAdapter Zone: 185°C Die Zone: 185°C

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