

Surlyn® 1605

Ionomer

DuPont Packaging & Industrial Polymers

Message:

Surlyn® 1605 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			
Uses	Films		
	cast film		
	Sheet		
	Coating application		
Agency Ratings	FDA 21 CFR 177.1330(a)		
Forms	Particle		
Processing Method	Blow film		
	Co-extrusion molding		
	cast film		
	Sheet extrusion molding		
	Coating		
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)	2.5	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.	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	185 - 285	°C	
Die Temperature	235	°C	

Extrusion instructions

Blown Film Processing Paramters:Feed Temperature: 135°CSecond Zone Temperature: 160°CThird Zone Temperature: 185°CFourth Zone Temperature: 185°C
Fifth Zone Temperature: 185°CAdapter Temperature: 185°CDie Temperature: 185°CExtrusion Coating/Laminating Processing Parameters:Feed Temperature: 160°C
Second Zone Temperature: 210°CThird Zone Temperature: 260°CFourth Zone Temperature: 285°C
Fifth Zone Temperature: 285°CAdapter Temperature: 285°C
Die Temperature: 285°C

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

