

# PRIMACOR™ 3540

Copolymer

The Dow Chemical Company

## Message:

PRIMACOR™ 3540 is an extrusion coating polymer.

Main Characteristics:

Extrusion coating adhesive polymer

Coextrusion coating adhesive in combination with select INSITE™ Technology based polyethylene resins

Enhanced adhesion retention

Complies with the requirements for use in contact with food of the EU-Directive 2002/72/EC. Contact a Dow Sales Office to obtain a detailed food contact compliance letter for this product. Such a letter covers the food contact status of this product in the various European countries and in addition gives info about imposed migration requirements.

Complies with U.S. FDA 21 CFR 177.1310(b). Consult the regulations for complete details.

## General Information

Agency Ratings	FDA 21 CFR 177.1310 (b) European 2002/72/EC
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Forms	Particle
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Physical	Nominal Value	Unit	Test Method
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Specific Gravity	0.936	g/cm <sup>3</sup>	ASTM D792
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Melt Mass-Flow Rate (MFR) <sup>1</sup> (190°C/2.16 kg)	7.0	g/10 min	ASTM D1238
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Comonomer Content <sup>2</sup>	8.5	%	Internal method
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Thermal	Nominal Value	Unit	Test Method
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Vicat Softening Temperature	29.4	°C	ASTM D1525
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Melting Temperature (DSC)	36.7	°C	Internal method
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Extrusion	Nominal Value	Unit	Test Method
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Melt Temperature	260 - 300	°C	
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Shrinkage-25 g/m <sup>2</sup> (290°C)	81.0	mm	Internal method
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Drop-down-Acceleration from 15 g/m <sup>2</sup> at 100 m/min (290°C)	70	m/min	Internal method
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## Extrusion instructions

Fabrication Conditions For Extrusion Coating Film: Equipment used to process this resin should be constructed of corrosion resistant materials. Dies and adapters are recommended to be stainless steels and/or duplex chrome or nickel plated.

Extruder: A

Screw Size: 3.5 in.; 30:1 L/D

Screw Type: 3.5

Die Gap: 0.6 mm

Chill Roll Finish: matte

Chill Roll Temperature: 15 to 20°C

Melt Temperature: set 290°C

Air Gap: 250 mm

Haul Off Speed: 100 m/min

## NOTE

1.	As measured during production.
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2.

Comonomer content measured by  
direct titration procedure.

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