



Appeel® 20D855

DuPont Packaging & Industrial Polymers - Ethylene Acrylate Copolymer

Sunday, November 3, 2019

General Information

Product Description

DuPont™ Appeel 20D855 is a modified ethylene acrylate resin designed to function as a sealing layer for lidding applications. It is most often suggested to provide peelable seals over a broad temperature range to a number of container materials including PET, PVC, PS and PP. Appeel 20D855 is available in pellet form for use in conventional extrusion and coextrusion equipment designed to process polyethylene resins.

General

Material Status	• Experimental: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Uses	• Lids	• Seals	
Agency Ratings	• FDA 21 CFR 177.1340		
Forms	• Pellets		
Processing Method	• Coextrusion	• Extrusion	

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.00		ASTM D792
Density	1.00	g/cm ³	ISO 1183
Melt Mass-Flow Rate (190°C/2.16 kg)	8.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	8.0	g/10 min	ISO 1133
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	129	°F	ASTM D1525
Vicat Softening Temperature	129	°F	ISO 306
Peak Melting Temperature	198	°F	ASTM D3418
Melting Temperature (DSC)	198	°F	ISO 3146

Processing Information

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	284	°F
Cylinder Zone 2 Temp.	302	°F
Cylinder Zone 3 Temp.	320	°F
Cylinder Zone 4 Temp.	356	°F
Cylinder Zone 5 Temp.	356	°F
Adapter Temperature	356	°F
Melt Temperature	320 to 365	°F
Die Temperature	338	°F

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Extrusion Notes

The above processing values are for blown film.

Extrusion coating/lamination parameters:

- Feed Zone: 160°C
- Second Zone: 210°C
- Third Zone: 235°C
- Fourth Zone: 260°C
- Fifth Zone: 285°C
- Adapter Zone: 285°C
- Die Zone: 285°C
- Melt Temperature: 235 to 285°C

Notes

¹ Typical properties: these are not to be construed as specifications.