



Appeel® 72D811

DuPont Packaging & Industrial Polymers - Ionomer

Sunday, November 3, 2019

General Information

Product Description

DuPont™ Appeel® 72D811 is a blown or cast film resin designed to be a sealing layer to film or sheet lidding applications. It provides a peelable seal to a number of materials including HDPE, LLDPE, LDPE, EVA, and Ionomer.

Appeel® 72D811 is a modified ionomer polymer 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
Features	• Food Contact Acceptable		
Uses	• Lids	• Sealants	
Agency Ratings	• FDA 21 CFR 177.1330		
Forms	• Pellets		
Processing Method	• Blown Film • Cast Film	• Coextrusion • Extrusion	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.932		ASTM D792
Density	0.930	g/cm ³	ISO 1183
Melt Mass-Flow Rate (190°C/2.16 kg)	6.9	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	6.9	g/10 min	ISO 1133
Thermal	Nominal Value	Unit	Test Method
Peak Melting Temperature	201	°F	ASTM D3418
Melting Temperature (DSC)	201	°F	ISO 3146

Processing Information

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	275	°F
Cylinder Zone 2 Temp.	320	°F
Cylinder Zone 3 Temp.	365	°F
Cylinder Zone 4 Temp.	365	°F
Cylinder Zone 5 Temp.	365	°F
Adapter Temperature	365	°F
Melt Temperature	320 to 365	°F
Die Temperature	343	°F

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Extrusion Notes

Cast Film Processing:

Processing Max Temperature: 185 - 235°C

Feed Zone: 135°C (275°F)

Second Zone: 160°C (320°F)

Third Zone: 185°C (365°F)

Fourth Zone: 210°C (410°F)

Fifth Zone: 210°C (410°F)

Adapter Zone: 210°C (410°F)

Die Zone: 210°C (410°F)

Notes

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