



PRIMACOR™ 3330

SK Global Chemical - Ethylene Acrylic Acid Copolymer

Sunday, November 3, 2019

General Information

Product Description

PRIMACOR™ 3330 Copolymer is an ethylene acrylic acid copolymer suitable for extrusion coating and extrusion lamination applications.

PRIMACOR 3330 Copolymer has been specifically designed for use as an adhesive resin for extrusion and coextrusion coating and extrusion lamination or sealant layer. PRIMACOR 3330 Copolymer exhibits:

- Excellent adhesion to metallic, paper and PE substrates.
- Excellent heat sealability and hot tack.
- Excellent toughness.
- Excellent oil and grease resistance.
- Insensitive to moisture.

Applications:

- Flexible packaging laminates
- Plastic tube laminates

Complies with:

- U.S. FDA 21 CFR 177.1310(a)(1)
- EU, No 10/2011

Consult the regulations for complete details.

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Latin America	
	• Europe	• North America	
Additive	• Antiblock: No	• Processing Aid: No	• Slip: No
Agency Ratings	• EU No 10/2011	• FDA 21 CFR 177.1310 (a) 1	
Forms	• Pellets		
Processing Method	• Extrusion Coating		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.934		ASTM D792
Density	0.932	g/cm ³	ISO 1183
Melt Mass-Flow Rate (190°C/2.16 kg)	5.8	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	5.8	g/10 min	ISO 1133
Comonomer Content ²	6.5	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, Compression Molded)	1210	psi	ASTM D638
Tensile Stress (Yield, Compression Molded)	1210	psi	ISO 527-2
Tensile Strength (Break, Compression Molded)	2530	psi	ASTM D638
Tensile Stress (Break, Compression Molded)	2530	psi	ISO 527-2
Tensile Elongation (Break, Compression Molded)	520	%	ASTM D638
Tensile Strain (Break, Compression Molded)	520	%	ISO 527-2
Films	Nominal Value	Unit	Test Method
Seal Initiation Temperature ³	199	°F	Internal Method

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Films	Nominal Value	Unit	Test Method
Water Vapor Transmission Rate (100°F, 90% RH)	1.0	g·mil/100in ² /atm/24 hr	DIN 53122/2

Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	185	°F	ASTM D1525
Vicat Softening Temperature	185	°F	ISO 306
Melting Temperature (DSC)	212	°F	Internal Method

Processing Information

Extrusion	Nominal Value	Unit	Test Method
Melt Temperature	500 to 554	°F	
Minimum Coating Thickness	0.80	mil	Internal Method
Minimum Coating Weight	12	lb/ream	Internal Method
Neck-in (550°F, 1.0 mil)	2.0	in	Internal Method

Extrusion Notes

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.

- Screw Size: 3.5 in. (89 mm); 30:1 L/D
- Die: 30 inch die deckled to 24 inches
- Die Gap: 20 mil (0.508 mm)
- Melt Temperature: 550 °F (288 °C)
- Output: 250 lb/hr
- Air Gap: 6 in. (152 mm)

Notes

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

² Comonomer content measured by a proprietary method that has equivalent accuracy as compared to ASTM D 4094.

³ 25 g/m² coatings at 290°C set temperature.