



PRIMACOR™ 3540

SK Global Chemical - Ethylene Acrylic Acid Copolymer

Sunday, November 3, 2019

General Information

Product Description

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 SK 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

Material Status	• Commercial: Active
Availability	• North America
Additive	• Antiblock: No • Processing Aid: No • Slip: No
Agency Ratings	• EU 2002/72/EC • FDA 21 CFR 177.1310 (b)
Forms	• Pellets

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.938		ASTM D792
Melt Mass-Flow Rate (190°C/2.16 kg)	7.0	g/10 min	ASTM D1238
Comonomer Content ²	8.5	%	Internal Method
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	85.0	°F	ASTM D1525
Melting Temperature (DSC)	98.0	°F	Internal Method

Processing Information

Extrusion	Nominal Value	Unit	Test Method
Melt Temperature	500 to 572	°F	
Draw Down - Acceleration from 15 g/m ² at 100 m/min (554°F)	230	ft/min	Internal Method
Neck-in - 25 g/m ² (554°F)	3.2	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.

- 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

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Notes

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

² Comonomer content measured by direct titration procedure.
