



PRIMACOR™ 3801

SK Global Chemical - Ionomer

Sunday, November 3, 2019

General Information

Product Description

PRIMACOR™ 3801 Ethylene Acrylic Acid Ionomer is designed for blown and cast film coextrusion for flexible packaging applications. It provides excellent sealability in coextrusions with nylon and other film structures.

- For Food and Specialty Applications
- Excellent Sealant for use in blown and cast film coextrusions

Complies with:

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

Consult the regulations for complete details

General

Material Status	• Commercial: Active		
Availability	• Europe	• Latin America	• North America
Additive	• Antiblock: No	• Processing Aid: No	• Slip: No
Agency Ratings	• EU No 10/2011	• FDA 21 CFR 177.1310 (b)	
Forms	• Pellets		
Processing Method	• Blown Film	• Cast Film	• Coextrusion

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	0.942		ASTM D792
Melt Mass-Flow Rate (190°C/2.16 kg)	1.3	g/10 min	ASTM D1238
Ion Type	Sodium (Na)		
Films	Nominal Value	Unit	Test Method
Film Thickness - Tested	2	mil	
Tensile Strength - MD ² (Yield, 2.0 mil)	2200	psi	ASTM D882
Tensile Strength - TD ² (Yield, 2.0 mil)	1820	psi	ASTM D882
Tensile Strength - MD ² (Break, 2.0 mil)	4880	psi	ASTM D882
Tensile Strength - TD ² (Break, 2.0 mil)	4980	psi	ASTM D882
Tensile Elongation - MD ² (Break, 2.0 mil)	280	%	ASTM D882
Tensile Elongation - TD ² (Break, 2.0 mil)	400	%	ASTM D882
Elmendorf Tear Strength - MD ² (2.0 mil)	20	g	ASTM D1922
Elmendorf Tear Strength - TD ² (2.0 mil)	42	g	ASTM D1922
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	199	°F	ASTM D1525
Melting Temperature (DSC)	203	°F	Internal Method
Optical	Nominal Value	Unit	Test Method
Gloss ² (20°, 2.00 mil)	80		ASTM D2457
Haze ² (2.00 mil)	3.20	%	ASTM D1003

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Extrusion Notes

Fabrication Conditions For Blown 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: A and B = 2.5 in. (64 mm), C = 2 in. (51 mm); 30:1 L/D/Size
- Screw Type: A = HS, B = DSBII, C = SFSM
- Die Gap: 70 mil (1.78 mm)
- Melt Temperature: A and B = 420°F (216°C), C = 470°F (243°C)
- Output: 10 lb/hr/in. of die circumference
- Die Diameter: 8 in.
- Blow-Up Ratio: 2.5:1
- Screw Speed: 45 rpm
- Frost Line Height: 30 in. (762 mm)

Notes

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

² Monolayer film data.