

# PRIMACOR™ 3540

## Copolymer

### Introduction

PRIMACOR™ 3540 Copolymer is an ethylene acrylic acid copolymer suitable for extrusion coating and extrusion lamination applications.

PRIMACOR™ 3540 Copolymer exhibits:

- Extrusion coating adhesive polymer
- Enhanced adhesion retention

Complies with:

- US. FDA 21 CFR 177.1310(b)
- EU. No 10/2011

Additives:

- Antiblock: No
- Slip: No

### Properties

		Nominal Value (English)	Nominal Value (SI)	Test Method
Resin Properties	Density	0.936 g/cm <sup>3</sup>	0.936 g/cm <sup>3</sup>	ASTM D792
	Melt Index (2.16 kg @190°C)	7.0 g/10min	7.0 g/10min	ASTM D1238
	Comonomer Content <sup>1</sup>	8.5 %	8.5 %	SK Method
	Vicat Softening Temperature	185.0 °F	85.0 °C	ASTM D1525
	Melting Temperature (DSC)	208.4 °F	98.0 °C	SK Method
Extrusion	Melt Temperature	500 - 572 °F	260 - 300 °C	
	Draw Down <sup>2</sup>	230 ft/min	70 m/min	SK Method
	Neck-in <sup>3</sup>	3.2 in.	81.0 mm	SK Method
Extrusion Condition <sup>4</sup>	<ul style="list-style-type: none"> <li>• Extruder: A</li> <li>• Screw Size: 89 mm (3.5 in.); 30:1 L/D</li> <li>• Die Gap: 0.6 mm (24 mil)</li> <li>• Chill Roll Finish: Matte</li> <li>• Chill Roll Temperature: 15 - 20 °C (59 - 68 °F)</li> <li>• Melt Temperature: 290 °C (554 °F)</li> <li>• Air Gap: 250 mm (9.84 in.)</li> <li>• Haul Off Speed: 100 m/min (328 ft/min)</li> </ul>			

<sup>1</sup> Comonomer content measured by direct titration procedure.

<sup>2</sup> Acceleration from 15 g/m<sup>2</sup> at 100 m/min (554 °F (290 °C))

<sup>3</sup> 25 g/m<sup>2</sup> (554 °F (290 °C))

<sup>4</sup> 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.

#### Notes

These are **typical values** and are **not be construed as specifications**. The physical properties are highly dependent on the manufacturing conditions. So customers should confirm performances by their own tests.

