

# PRIMACOR™ IO 3801

## Description

PRIMACOR™ IO 3801 is an ionomer of ethylene acrylic acid copolymer, and is designed for blown and cast for flexible packaging applications. PRIMACOR™ IO 3801 can provide excellent sealability in coextrusions with Nylon and other film structures.

Ion type

- Sodium Ionomer.

## Typical Properties<sup>1)</sup>

		Nominal Values		Test Method
Physical	Density	0.940 g/cm <sup>3</sup>	0.940 g/cm <sup>3</sup>	ASTM D792
	Melt Index (2.16 kg @190°C)	1.3 g/10min	1.3 g/10min	ASTM D1238
Thermal	Vicat Softening Point	165 °F	74 °C	ASTM D1525
	Melting Point (DSC)	203 °F	95.0 °C	SK Method
Optical	Haze	3.2 %	3.2 %	ASTM D1003
	Gloss(20°)	80	80	ASTM D2457
Films <sup>2)</sup>	Film Thickness	2.0 mil	50.8 um	ASTM D374
	Elmendorf Tear Strength(MD)	20 g	20	ASTM D1922
	Elmendorf Tear Strength(TD)	42 g	42 g	
	Tensile Strength(Yield, MD)	2200 psi	15.2 MPa	ASTM D882
	Tensile Strength(Yield, TD)	1820 psi	12.5 MPa	
	Tensile Strength(Break, MD)	4880 psi	33.6 MPa	ASTM D882
	Tensile Strength(Break, TD)	4980 psi	34.3 MPa	
	Tensile Elongation(MD)	280 %	280 %	ASTM D882
	Tensile Elongation(TD)	400 %	400 %	

## Processing Information

### Extrusion Notes

Fabrication Conditions for Blown Film:

Equipment used to process this resin should be constructed of corrosion resistant material. Dies and adaptors are recommended to be stainless steels and/or duplex chrome and 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. circumference
  - Die Diameter: 8 in.
  - Blow-Up Ratio: 2.5:1
  - Screw Speed: 45 rpm
  - Frost Line Height: 30 in.(762 mm)
- 

<sup>1)</sup> Typical properties: these are not to be construed as specifications

<sup>2)</sup> Monolayer film data

