

PRIMACOR™ 3460

Copolymer

Introduction

PRIMACOR™ 3460 Copolymer is an ethylene acrylic acid copolymer suitable for extrusion coating and extrusion lamination applications. PRIMACOR™ 3460 Copolymer has been specifically designed for use as a sealant and adhesive layer in flexible packaging laminates and thin paper coating.

PRIMACOR™ 3460 Copolymer exhibits:

- Excellent heat sealability and hot tack
- Excellent adhesion to metallic, paper and polyethylene substrates
- Good stress crack resistance
- Designed specifically for high line speeds and low processing temperature
- Insensitive to moisture

Applications:

- Flexible packaging
- Thin paper coating
- Metallic substrate lamination

Complies with:

- US. FDA 21 CFR 177.1310(a)(1)
- EU. No 10/2011

Additives:

- Antiblock: No
- Slip: No

Properties

	Nominal Value (English)	Nominal Value (SI)	Test Method
Resin Properties	Density	0.938 g/cm ³	ASTM D792 ISO 1183
	Melt Index (2.16 kg @190°C)	20 g/10min	ASTM D1238 ISO 1133
	Comonomer Content ¹	9.7 %	SK Method
	Vicat Softening Temperature	162 °F	ASTM D1525 ISO 306
	Melting Temperature (DSC)	203 °F	95.0 °C SK Method
Film Properties	Seal Initiation Temperature ²	185 °F	85.0 °C SK Method
	Water Vapor Transmission Rate 100 °F (38 °C), 90% RH	1.1 g·mil/100in ² /atm/24hr	0.44 g·mm/m ² /atm/24hr DIN 53122/2



		Nominal Value (English)	Nominal Value (SI)	Test Method
Mechanical Properties	Tensile Strength at Yield (Compression Molded)	1050 psi	7.24 MPa	ASTM D638 ISO 527-2
	Tensile Strength at Break (Compression Molded)	2350 psi	16.2 MPa	ASTM D638 ISO 527-2
	Tensile Elongation at Break (Compression Molded)	580 %	580 %	ASTM D638 ISO 527-2
Extrusion	Melt Temperature	428 - 500 °F	220 - 260 °C	
	Minimum Coating Thickness	0.40 mil	10 µm	SK Method
	Minimum Coating Weight	6.0 lb/ream	9.8 g/m ²	SK Method
	Neck-in ³	2.8 in.	71.1 mm	SK Method
Extrusion Condition⁴	<ul style="list-style-type: none"> • Screw Size: 3.5 in. (89 mm); 30:1 L/D • Die Gap: 20 mil (0.508 mm) • Die: 30 in. (762 mm) die deckled to 24 in. (609.6 mm) • Melt Temperature: 425 °F (218 °C) • Output: 250 lb/hr (113.4 kg/hr) • Air Gap: 6 in. (152 mm) 			

¹ Comonomer content measured by a SK proprietary method that has equivalent accuracy as compared to ASTM D 4094.

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

³ 550 °F (288 °C), 1.0 mil (25.4 µm)

⁴ 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.

