PRIMACOR™ 3340

Copolymer

Introduction

PRIMACOR™ 3340 Copolymer is an ethylene acrylic acid copolymer which has been specifically designed by SK for use as an adhesive or sealant layer in extrusion/coextrusion coating and lamination.

PRIMACOR™ 3340 Copolymer exhibits:

- Excellent adhesion to paper, paperboard, metals and polyethylenes
- Excellent hot-tack and sealability
- Good oil and grease resistance
- Insensitivity to moisture

Applications:

- Flexible packaging laminates
- Liquid packaging board laminates

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	0.932 g/cm^3	0.932 g/cm^3	ASTM D792 ISO 1183
	Melt Index (2.16 kg @190°C)	9.0 g/10min	9.0 g/10min	ASTM D1238 ISO 1133
	Comonomer Content[1]	6.5 %	6.5 %	SK Method
	Vicat Softening Temperature	183 °F	83.9 °C	ASTM D1525 ISO 306/A
	Melting Temperature (DSC)	214 °F	101 °C	SK Method
Film Properties	Seal Initiation Temperature[2]	199 °F	92.8 °C	SK Method
	Water Vapor Transmission Rate 100°F (38°C), 90% RH	1.0 g·mil/100in^2/atm/24hr	0.40 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)	1150 psi	7.93 Mpa	ASTM D638 ISO 527-2
	Tensile Strength at Break (Compression Molded)	2500 psi	17.2 Mpa	ASTM D638 ISO 527-2
	Tensile Elongation at Break (Compression Molded)	630 %	630 %	ASTM D638 ISO 527-2
Extrusion	Melt Temperature	500-554 °F	260-290 °C	-
	Minimum Coating Thickness	0.50 mil	13 μm	SK Method
	Minimum Coating Weight	7.5 lb/ream	12 g/m^2	SK Method
	Neck-in[3]	2.8 in	69.9 mm	SK Method
Extrusion Condition[4]	• 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: 550 °F (288 °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/m^2 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.