

PRIMACOR™ 1321

Copolymer

Introduction

PRIMACOR™ 1321 Copolymer is an ethylene acrylic acid copolymer suitable for extruded blown and cast film. PRIMACOR™ 1321 Copolymer has been specifically designed for use as an adhesive layer in composite films or sealant layer in flexible packaging structures.

PRIMACOR™ 1321 Copolymer exhibits:

- Good interlayer adhesion to PE and PA
- Good optical properties
- Excellent toughness and strength
- Excellent environmental stress crack and product resistance
- Good hot-tack and sealability
- Insensitivity to moisture

Applications:

- Multilayer films
- Food packaging

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	0.935 g/cm ³	0.935 g/cm ³ ASTM D792 ISO 1183
	Melt Index ¹ (2.16 kg @190°C)	2.6 g/10min	2.6 g/10min ASTM D1238 ISO 1133
	Comonomer Contents ²	6.5 %	6.5 % SK Method
	Vicat Softening Temperature	192 °F	88.9 °C ASTM D1525 ISO 306
	Melting Temperature (DSC)	217 °F	103 °C SK Method

Technical Information

		Nominal Value (English)	Nominal Value (SI)	Test Method	
Mechanical Properties	Tensile Strength at Yield ³ (Compression Molded)	1460 psi	10.0 MPa	ASTM D638 ISO 527-2/508	
	Tensile Strength at Break ³ (Compression Molded)	2910 psi	20.1 MPa	ASTM D638 ISO 527-2/508	
	Tensile Elongation at Break ³ (Compression Molded)	640 %	640 %	ASTM D638 ISO 527-2/508	
Film Properties	Film Thickness	2.0 mil	50.8 µm	ASTM D374	
	Haze	3.7 %	3.7 %	ASTM D1003 ISO 14782	
	Gloss (45°)	76	76	ASTM D2457	
	Dart Drop Impact	410 g	410 g	ASTM D1709B ISO 7765-1/B	
	Elmendorf Tear Strength	MD	270 g	270 g	ASTM D1922
		TD	390 g	390 g	ISO 6383-2
	Tensile Strength at Yield	MD	1640 psi	11.3 MPa	ASTM D882
		TD	1620 psi	11.1 MPa	ISO 527-3
	Tensile Strength at Break	MD	4610 psi	31.8 MPa	ASTM D882
		TD	4620 psi	31.9 MPa	ISO 527-3
Tensile Elongation at Break	MD	460 %	460 %	ASTM D882	
	TD	510 %	510 %	ISO 527-3	
Extrusion Condition⁴	<ul style="list-style-type: none"> • Screw Size: 2.5 in. (63.5 mm); 30:1 L/D; Single Flight with Maddock Mixer • Die Gap: 40 mil (1.0 mm) • Die Diameter: 6 in. (152.4 mm) • Melt Temperature: 380 °F (193 °C) • Output: 6 lb/hr/in. of Die Circumference (1.07 kg/hr/cm of Die Circumference) • Blow-up Ratio: 2.5:1 • Frost Line Height: 29 in. (737 mm) 				

¹ As measured at the time of production.

² Comonomer content measured by a SK proprietary method that has equivalent accuracy as compared to ASTM D 4094.

³ 20 in/min (510 mm/min)

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.

Technical Information

For additional sales, order and technical assistance

Customer Service Representative	cseurope@sk.com	csamericas@sk.com	
Asia Pacific		America	
Shanghai (Head Quarter)	+86-21-6197-0243	Houston	+1-713-850-0005
Shanghai (TS&D)	+86-21-6197-0128	Europe	
Seoul	+82-2-2121-6745	Paris	www.sk-fp.com
Tokyo	+81-3-3591-0343	Madrid	+34-910477688
Southeast Asia/Australia		Middle East/Africa	
Singapore	+65-6671-1566	Dubai	+971-4-252-5277