

PRIMACOR™ 3330

Copolymer

Introduction

PRIMACOR™ 3330 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™ 3330 Copolymer exhibits:

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

Applications:

- Flexible packaging laminates
- Plastic tube 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	ASTM D792 ISO 1183
	Melt Index (2.16 kg @190°C)	5.8 g/10min	ASTM D1238 ISO 1133
	Comonomer Content ¹	6.5 %	SK Method
	Vicat Softening Temperature	185 °F	ASTM D1525 ISO 306/A
	Melting Temperature (DSC)	212 °F	100 °C SK Method

Technical Information

		Nominal Value (English)	Nominal Value (SI)	Test 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
Mechanical Properties	Tensile Strength at Yield (Compression Molded)	1210 psi	8.34 Mpa	ASTM D638 ISO 527-2
	Tensile Strength at Break (Compression Molded)	2530 psi	17.4 Mpa	ASTM D638 ISO 527-2
	Tensile Elongation at Break (Compression Molded)	520 %	520 %	ASTM D638 ISO 527-2
Extrusion	Melt Temperature	500-554 °F	260-290 °C	-
	Minimum Coating Thickness	0.80 mil	20 µm	SK Method
	Minimum Coating Weight	12 lb/ream	20 g/m ²	SK Method
	Neck-in (550°F (288°C), 1.0 mil (25.4 µm))	2.0 in	50.8 mm	SK Method
Extrusion Condition³	<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 inch (762 mm) die deckled to 24 inches (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 25g/m² coatings at 290°C set temperature.

³ 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	
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