

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	0.938 g/cm ³ ASTM D792 ISO 1183
	Melt Index (2.16 kg @190°C)	20 g/10min	20 g/10min ASTM D1238 ISO 1133
	Comonomer Content ¹	9.7 %	9.7 % SK Method
	Vicat Softening Temperature	162 °F	72.2 °C ASTM D1525 ISO 306
	Melting Temperature (DSC)	203 °F	95.0 °C SK Method

Technical Information

		Nominal Value (English)	Nominal Value (SI)	Test 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
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.

Technical Information

For additional sales, order and technical assistance

Customer Service Representative	cseurope@sk.com	csamericas@sk.com	
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