



# AMPLIFY™ IO 3802 Functional Polymer

**Overview** AMPLIFY™ IO 3802 Ethylene Acrylic Acid Ionomer is designed for blown and cast film coextrusion for flexible packaging applications. It provides excellent sealability in coextrusions with nylon and other film structures.

- For Food and Specialty Applications
- Excellent Sealant for use in blown and cast film coextrusions

Complies with:

- U.S. FDA 21 CFR 177.1310 (c)
- Europe EU-Directive 2002/72/EC

Consult the regulations for complete details.

**Additive**      • Antiblock: No                                      • Slip: No                                      • Processing Aid: No

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	0.954 g/cm <sup>3</sup>	0.954 g/cm <sup>3</sup>	ASTM D792
Melt Index (190°C/2.16 kg)	2.8 g/10 min	2.8 g/10 min	ASTM D1238
Ion Type	Sodium (Na)	Sodium (Na)	
Films	Nominal Value (English)	Nominal Value (SI)	Test Method
Film Thickness - Tested	2.0 mil	51 µm	
Tensile Strength			ASTM D882 <sup>1</sup>
MD: Yield, 2.0 mil (51 µm)	3350 psi	23.1 MPa	
TD: Yield, 2.0 mil (51 µm)	2820 psi	19.5 MPa	
MD: Break, 2.0 mil (51 µm)	5540 psi	38.2 MPa	
TD: Break, 2.0 mil (51 µm)	5720 psi	39.4 MPa	
Tensile Elongation			ASTM D882 <sup>1</sup>
MD: Break, 2.0 mil (51 µm)	240 %	240 %	
TD: Break, 2.0 mil (51 µm)	330 %	330 %	
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Vicat Softening Temperature	153 °F	67.2 °C	ASTM D1525
Melting Temperature (DSC)	192 °F	88.9 °C	Dow Method

**Extrusion Notes**

Fabrication Conditions For Blown Film:

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.

- Screw Size: A and B = 2.5 in. (64 mm), C = 2 in. (51 mm); 30:1 L/D/Size
- Screw Type: A = HS, B = DSBII, C = SFSM
- Die Gap: 70 mil (1.78 mm)
- Melt Temperature: A and B = 420°F (216°C), C = 470°F (243°C)
- Output: 10 lb/hr/in. of die circumference
- Die Diameter: 8 in.
- Blow-Up Ratio: 2.5:1
- Screw Speed: 45 rpm
- Frost Line Height: 30 in. (762 mm)

**Notes**

These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.

<sup>1</sup> Monolayer film data.

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Published: 2007-05-08

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