



PRIMACOR™ 3330 Copolymer

Overview PRIMACOR™ 3330 Copolymer is an ethylene acrylic acid copolymer suitable for extrusion coating and extrusion lamination applications.

PRIMACOR 3330 Copolymer has been specifically designed for use as an adhesive resin for extrusion and coextrusion coating and extrusion lamination or sealant layer. PRIMACOR 3330 Copolymer exhibits:

- Excellent adhesion to metallic, paper and PE substrates.
- Excellent heat sealability and hot tack.
- Excellent toughness.
- Excellent oil and grease resistance.
- Insensitive to moisture.

Note:

PRIMACOR 3330 Copolymer should comply with FDA regulation 177.1310 and with most European food contact regulations when used unmodified and processed according to good manufacturing practices for food contact applications. Please contact your nearest office regarding food contact compliance statements. The purchaser remains responsible for determining whether the use complies with all relevant regulations.

Applications:

- Flexible packaging laminates.
- Plastic tube laminates.

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	0.932 g/cm ³	0.932 g/cm ³	ASTM D792 ISO 1183
Melt Index (190°C/2.16 kg)	5.8 g/10 min	5.8 g/10 min	ISO 1133 ASTM D1238 ¹
Comonomer Content	6.5 %	6.5 %	Dow Method ²
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength			ASTM D638 ISO 527-2
Yield, Compression Molded	1210 psi	8.34 MPa	
Break, Compression Molded	2530 psi	17.4 MPa	
Tensile Elongation			ASTM D638 ISO 527-2
Break, Compression Molded	520 %	520 %	
Films	Nominal Value (English)	Nominal Value (SI)	Test Method
Seal Initiation Temperature	199 °F	92.8 °C	Dow Method ³
Water Vapor Transmission Rate 100°F (38°C), 90% RH	1.0 g·mil/100in ² /at m/24 hr	0.40 g·mm/m ² /atm/ 24 hr	DIN 53122/2
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Vicat Softening Temperature	185 °F	85.0 °C	ASTM D1525 ISO 306
Melting Temperature (DSC)	212 °F	100 °C	Dow Method
Extrusion	Nominal Value (English)	Nominal Value (SI)	Test Method
Melt Temperature	500 to 554 °F	260 to 290 °C	
Minimum Coating Thickness	0.800 mil	0.800 mil	Dow Method
Minimum Coating Weight	12 lb/ream	20 g/m ²	Dow Method
Neck-in 550°F (288°C), 0.00100 in (0.0254 mm)	2.0 in	5.1 cm	Dow Method

Extrusion Notes

Fabrication Conditions For Extrusion Coating 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: 3.5 in. (89 mm); 30:1 L/D
- Die: 30 inch die deckled to 24 inches
- Die Gap: 20 mil (0.508 mm)
- Melt Temperature: 550 °F (288 °C)
- Output: 250 lb/hr
- Air Gap: 6 in. (152 mm)

Notes

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

¹ As measured at the time of production.

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

³ 25 g/m² coatings at 290°C set temperature.

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