

PRIMACOR 4608

Copolymer

PRIMACOR™ 4608 Copolymer is an ethylene acrylic acid copolymer suitable for extrusion coating and extrusion lamination applications.

PRIMACOR 4608 Copolymer has been specifically designed for use as a sealant and adhesive layer for flexible packaging and liquid packaging laminates.

PRIMACOR 4608 Copolymer exhibits:

- Excellent adhesion to metallic, paper, and PE substrates.
- Excellent heat sealability and hot-tack.
- Excellent draw down.
- Good oil grease resistance.
- Insensitivity to moisture.

Note:

PRIMACOR 4608 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.
- Liquid packaging laminates.

Physical Properties	Test Method**		Values ⁽¹⁾
	ISO	ASTM	English (SI)
Resin Properties			
Percent Comonomer ⁽²⁾	-	Dow Method	6.5
Melt Index, g/10 min ⁽³⁾	1133	ASTM D 1238	7.75
Density, g/cc	1183	ASTM D 792	0.9340
Vicat Softening Point, °F (°C)	306	ASTM D 1525	187 (86)
DSC Peak Melting Point, °F (°C)	-	Dow Method	210 (99)
Molded Part Properties⁽⁴⁾			
Tensile Yield, psi (MPa)	527/2	ASTM D 638	1080 (7.5)
Ultimate Tensile, psi (MPa)	527/2	ASTM D 638	2880 (20)
Ultimate Elongation, %	527/2	ASTM D 638	590
Extrusion Coating Processability			
Recommended Melt Temperature, °F (°C)			500-554 (260-290)
Neck-in @ 550°F and @ 1.0 mil, inches (mm)	-	Dow Method	3.3 (84)
Minimum Coating Weight, lb/ream (g/m ²)	-	Dow Method	5.3 (8.8)
Minimum Coating Thickness, mil	-	Dow Method	0.35
Coating Performance Properties			
Water Vapour Transmission, (g•25 µm/m ² •day) g-mil/100 in ² •day ⁽⁵⁾		DIN 53122/2	14.6 (.95)
Minimum Heat Seal Temperature, °F (°C) ⁽⁶⁾		Dow Method	90 (194)

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 Gap: 20 mil (0.508 mm)
- Die: 30 inch die deckled to 24 inches
- Melt Temperature: 550°F (288°C)
- Output: 250 lb/hr
- Air Gap: 6 in. (152 mm)

** Specific test settings in accordance to Inter Laboratory Round Robin programs with method priorities for ISO/ASTM.

- (1) Typical values, not to be construed as specifications. Users should confirm results by their own tests.
- (2) Comonomer content measured by a DOW proprietary method that has equivalent accuracy as compared to ASTM D 4094.
- (3) As measured at the time of production.
- (4) Compression molded samples.
- (5) 38°C, 90% R.H.
- (6) 25 g/m² coatings at 290°C set temperature.

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