



DuPont™ Nucrel® AE

Nucrel® resins Product Data Sheet

Description

Product Description Nucrel® AE is a terpolymer of ethylene, methacrylic acid, and acrylate. It is available for use in conventional extrusion coating, coextrusion coating and extrusion laminating equipment designed to process polyethylene resins.

It can be used as a modifier for PE in blends of approximately 20 to 40% Nucrel® AE with 80 to 60% LDPE for enhancement of foil adhesion properties. The level of adhesion improvement depends on processing conditions.

Restrictions

Material Status Commercial: Active

Typical Characteristics

Uses Adhesives; Packaging; Sealants

Composition Proprietary

Features Improved foil adhesion when processed under the correct conditions.
Increased peak hot tack strength.

Applications

- Foil-containing pouches and sachets for packaging non-aggressive food and miscellaneous non-food products.
- Snack structures
- Other foil, metallized film, or paper coatings as a heat seal or tie layer

Typical Properties

Physical	Nominal Values	Test Method(s)	
*Density ()	0.92 g/cm ³	ASTM D792	ISO 1183
*Melt Flow Rate (190°C/2.16kg)	10 g/10 min	ASTM D1238	ISO 1133
Thermal	Nominal Values	Test Method(s)	
*Melting Point (DSC)	105 °C (221 °F)	ASTM D3418	ISO 3146
Freezing Point (DSC)	85 °C (185 °F)	ASTM D3418	ISO 3146
Vicat Softening Point ()	79 °C (174.2 °F)	ASTM D1525	ISO 306

Processing Information

*Maximum Processing Temperature 325 °C (617 °F)

General Processing Information Nucrel® AE at the recommended blend ratio of 20 to 40% is normally processed at melt temperatures ranging from 290°- 325°C (550°- 617°F) in flat die equipment. Actual processing temperatures will usually be determined by either the specific equipment or substrate or one of the other polymers in a coextrusion.

Materials of construction used in the processing of this resin should be corrosion resistant. Stainless steels of the types 316, 15-5PH, and 17-4PH are excellent, as is quality chrome or nickel plating, and in particular duplex chrome plating. Type 410 stainless steel is satisfactory, but needs to be tempered at a minimum temperature of 600°C (1112°F) to avoid hydrogen-assisted stress corrosion cracking. Alloy steels such as 4140 are borderline in performance. Carbon steels are not satisfactory. While stainless steels can provide adequate corrosion protection, in some cases severe purging difficulties have been encountered. Nickel plating has been satisfactory, but experiments have shown that chrome surfaces have the least adhesion to acid based polymers. In recent years, the quality of chrome plating has been deteriorating due to environmental pressures, and the corrosion protection has not always been adequate. Chrome over top of stainless steel seems to provide the best combination for corrosion protection and ease of purging.

If surface properties of the extruded resin require modification (such as, lower C.o.F. for packaging machine processing), refer to the Conpol™ Processing Additive Resins product information guide.

After processing Nucrel, purge the material out using a polyethylene resin, preferably with a lower melt flow rate than the Nucrel resin in use.

The "Disco Purge Method" is suggested as the preferred purging method, as this method usually results in a more effective purging process. Information on the Disco Purge Method can be obtained via your DuPont Sales Representative.

Never shut down the extrusion system with Nucrel in the extruder and die. Properly purge out the Nucrel with a polyethylene, and shut down the line with polyethylene or polypropylene in the system.

Extrusion Coating/Lamination Processing Nominal Values

Processing Information	A suggested extruder set temperature profile.
Feed Zone	185 °C (365 °F)
Second Zone	235 °C (455 °F)
Third Zone	285 °C (545 °F)
Fourth Zone	310 °C (590 °F)
Fifth Zone	310 °C (590 °F)
Adapter Zone	310 °C (590 °F)
Die Zone	310 °C (590 °F)

FDA Status Information NUCREL® AE complies with Food and Drug Administration Regulation 21 CFR 177.1330(b) - - Ionomeric resins, subject to the limitations and requirements therein. This Regulation describes polymers that may be used in contact with food, subject to the finished food-contact article meeting the extractive limitations under the intended conditions of use, as shown in paragraph (d) of the Regulation.

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Regulatory Information For information on regulatory compliance outside of the U.S., consult your local DuPont representative.

Safety & Handling For information on appropriate Handling & Storage of this polymeric resin, please refer to the material Safety Data Sheet.

A Product Safety Bulletin, material Safety Data Sheet, and/or more detailed information on extrusion processing and/or compounding of this polymeric resin for specific applications are available from your DuPont Performance Materials representative.

Regional Centres

DuPont operates in more than 70 countries.

For help finding a local representative, please contact one of the following regional customer contact centers:

Americas

DuPont Company
Chestnut Run Plaza – Bldg. 730
974 Centre Road
Wilmington, Delaware
19805 U.S.A.
Toll-Free (USA): 1-800-628-6208
Telephone: 1-302-774-1000
Fax: 1-302-355-4013

DuPont do Brasil, S.A.
Alameda Itapecuru, 506
06454-080 Barueri, SP Brasil
Telephone: +55 11 4166 8000
Fax: +55 11 4166 8736

Asia Pacific

DuPont China Holding Co., Ltd.
Shanghai Branch
399 Keyuan Road, Bldg. 11
Zhangjiang Hi-Tech Park
Pudong New District, Shanghai
P.R. China (Postcode: 201203)
Telephone +86 21 3862 2888
Fax +86-21-3862-2889

Europe / Middle East / Africa

DuPont de Nemours Int'1. S.A.
2,Chemin du Pavillon Box 50
CH-1218 Le Grand Saconnex
Geneva, Switzerland
Telephone +41 22 717 51 11
Fax +41 22 717 55 00

<http://www.dupont.com>

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