



DuPont™ Appeel® 20D752

Appeel® resins Product Data Sheet

Description

Product Description DuPont™ Appeel 20D752 is a modified ethylene acrylate copolymer designed to function as a sealing layer for lidding applications. It is most often suggested to provide peelable seals over a broad temperature range to a number of container materials including PS and PP. Appeel 20D752 offers good peelability to PE, and also can be used to seal to itself resulting in a cohesive peel system. Appeel 20D752 is available in pellet form for use in conventional extrusion and coextrusion equipment designed to process polyethylene resins.

Restrictions

Material Status Commercial: Active

Typical Characteristics

Uses Lidding Sealant

Typical Properties

Physical	Nominal Values	Test Method(s)	
*Density ()	0.98 g/cm ³	ASTM D792	ISO 1183
*Melt Flow Rate (190°C/2.16kg)	4.0 g/10 min	ASTM D1238	ISO 1133
Thermal	Nominal Values	Test Method(s)	
*Melting Point (DSC)	90 °C (194 °F)	ASTM D3418	ISO 3146
Vicat Softening Point ()	68 °C (154.4 °F)	ASTM D1525	ISO 306

Heat Seal Evaluation The performance of any sealant resin should be evaluated within the context of the application. The sealant is designed to bond to particular substrate(s). Many variables can affect seal strength, including the physical properties of the substrate being sealed to, thickness, flange or surface design, heat seal temperature, dwell time and pressure. The condition and type of the sealing equipment used, such as roller sealers versus platen seal mechanisms can make a significant difference.

In most cases sealant peel strength is used as a measure of performance. Although this is a convenient test, peel strength is affected not only by substrate adhesion but also by peel angle, separation rate, ambient temperature, tensile and modulus properties of the materials, and often by the time elapsed since the formation of the bond.

If sealant peel strength is used as a measure of sealant performance, it is imperative that peel strength be evaluated not only at the time of initial heat sealing the lid to the substrate, but throughout the life of the product and under all the conditions to which the sealant will be exposed. Only then does peel strength provide a reliable indication of adhesive performance in the specific application.

Processing Information

*Maximum Processing Temperature 260 °C (500 °F)

General Processing Information If the process is stopped for short periods of time, the screw for the Appeel® extruder should be kept turning at a low rpm to keep material flowing.

After processing Appeel®, purge the material out using a polyethylene resin, preferably with a lower melt flow rate than the Appeel® 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 Appeel® in the extruder and die. Properly purge out the Appeel® with a polyethylene, and shut down the line with polyethylene or polypropylene in the system.

Blown Film Processing

Processing Information **Nominal Values** Blown Film: In blown film coextrusion processes the temperature of the Appeel® 20D752 should be maintained in the 160 - 185° C range. It is also important that the Appeel® 20D752 be supported with materials having sufficient melt strength.

Following is an example of a suggested temperature profile for blown film processing. Adjustments would then be made to suit the individual process and applications needs.

Feed Zone 140 °C (284 °F)

Second Zone	150 °C (302 °F)
Third Zone	160 °C (320 °F)
Fourth Zone	180 °C (356 °F)
Fifth Zone	180 °C (356 °F)
Adapter Zone	180 °C (356 °F)
Die Zone	170 °C (338 °F)

FDA Status Information	<p>Appeel® 20D752 resin complies with Food and Drug Administration Regulation 21 CFR 177.1340 - - Ethylene-methyl acrylate copolymer 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 (b) of the Regulation.</p> <p>The information and certifications provided herein are based on data we believe to be reliable, to the best of our knowledge. The information and certifications apply only to the specific material designated herein as sold by DuPont and do not apply to use in any process or in combination with any other material. They are provided at the request of and without charge to our customers. Accordingly, DuPont cannot guarantee or warrant such certifications or information and assumes no liability for their use.</p>
Regulatory Information	<p>In Europe a diversity of regulations apply in various countries. In addition, constant changes linked to the effort of their harmonization under the umbrella of European Union Directive can be observed. This makes it impossible to accurately describe the food contact status in this brochure. Updated statements describing the situation in the various European countries can be obtained through your local sales representative.</p>
Safety & Handling	<p>For information on appropriate Handling & Storage of this polymeric resin, please refer to the Material Safety Data Sheet.</p> <p>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 Packaging and Industrial Polymers representative.</p>

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'l. 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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