

DuPont™ Appeel® 22D843

Appeel® resins Product Data Sheet

Description

Product Description

DuPont™ Appeel® 22D843 is a polypropylene modified ethylene acrylate resin designed to function as a masterbatch to achieve peelability in polypropylene based sealant layers.

It provides peelable seals over a broad temperature range. The peel layers will sustain sterilization conditions of 121°C for 20 minutes through 134°C for 6 minutes depending on the base of the PP seal materials.

When blending for this type of application, 22D843 should be evaluated as a modifier for HoPP or CoPP by addition rates between 20% to 40% by weight. Blends with CoPP will usually provide better results.

Appeel® 22D843 is available in pellet form for use in conventional extrusion and coextrusion equipment designed to process polyethylene resins.

Restrictions

Material Status

- Developmental: Active

Typical Characteristics

Features

DuPont™ Appeel® 22D843 may also be considered to evaluate as a sealing layer for lidding applications, though it has not been tested in this manner yet. It may have functionality as a peelable sealant to a number of container materials including PET, PVC, PS and PP, as well as Paper surfaces.

Typical Properties

Physical

* Density ()

Nominal Values

0.937 g/cm³

Test Method(s)

ASTM D792 ISO 1183

* Melt Flow Rate (230°C/2.16kg)

6.4 g/10 min

ASTM D1238 ISO 1133

Melt Flow Rate (190°C/2.16kg)

2.6 g/10 min

ASTM D1238 ISO 1133

Thermal

* Melting Point (DSC)

Nominal Values

136°C (277°F)

Test Method(s)

ASTM D3418 ISO 3146

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

General

* Maximum Processing Temperature 300°C (572°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

Nominal Values

Blown Film Processing Information The following applies if evaluating Appeel 22D843 in its pure form as a peelable sealant either via monofilm or as a pure layer in a coextruded film.

Blown Film: In blown film coextrusion processes the temperature of the Appeel® 22D843 should be maintained in the 160 - 185° C range. It is also important that the Appeel® 22D843 be supported with materials having sufficient melt strength.

Additive package: For blown film processing, if film blocking is an issue, please consult with your DuPont technical representative for a recommendation.

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

Appeel® 22D843 Lidding Sealant Resin complies with Food and Drug Administration Regulation 21 CFR 177.1340 - - Ethylene-methyl acrylate copolymer resins, subject to the limitations and requirements therein. Appeel® 22D843 Lidding Sealant Resin may be used in non-cooking applications under conditions corresponding to Conditions of Use C (Hot filled or Pasteurized above 150F, includes microwave reheating) through G (frozen storage, no thermal treatment in the container) (21 CFR 176.170, Table 2, subject to the finished food-contact article meeting the extractive limitations under the intended conditions of use, as shown in paragraph 21 CFR 177.1340 paragraph (b).

Appeel® 22D843 Lidding Sealant Resin may also be used for packaging all food types in a cooking application at a maximum thickness of 3.5 mils in pouches under retort conditions only, corresponding to Condition of Use A (21 CFR 176.170, Table

2), subject to the finished food-contact article meeting the extractive limitations under the intended conditions of use, as shown in paragraph 21 CFR 177.1340 paragraph (b). Such use may properly be said to comply with Federal Food, Drug and Cosmetic Act and all applicable food additive regulations.

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.

Regulatory Information

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.

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 Packaging and Industrial Polymers representative.

Read and Understand the Material Safety Data Sheet (MSDS) before using this product

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:

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Regarding Medical Applications H-50102-3.

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