

DuPont™ Appeel® 55041

Appeel® resins Product Data Sheet

Description

Product Description	DuPont™ Appeel® 55041 is a modified polyolefin resin designed to function as a sealing layer for lidding applications, most commonly sealing to polypropylene. It is available in pellet form for use in conventional extrusion or coextrusion equipment designed to process polyethylene resins.
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Restrictions

Material Status	<ul style="list-style-type: none"> • Developmental: Active
Availability	<ul style="list-style-type: none"> • Asia, Australia, Pacific Rim

Typical Characteristics

Uses	<ul style="list-style-type: none"> • Lidding Sealant
Applications	<ul style="list-style-type: none"> - Appeel® 55041 has strong sealability to PP and allows a peelable seal from it. - Boiling resistance. Appeel® 55041 endures boiling process. - In the case of: OPET/ adh // Appeel® 55041 , these film structures endure boiling condition at 120C / 30min - Appeel® 55041 conforms to Code #20 of the Ministry of Health and Welfare Japan. <p>Typical structures for this lidding would be: OPET / adhesive // Appeel® 55041 OPET / adhesive // coex film with Appeel® 55041</p> <p>Appeel® 55041 is used as a heat seal layer in lidding material for injection molded and vacuum molded PP containers used in the packaging of puddings, jelly, and other food items.</p>

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)	4 g/10 min	ASTM D1238	ISO 1133
Thermal	Nominal Values	Test Method(s)	
* Melting Point (DSC)	140°C (284°F)	ASTM D3418	ISO 3146
Vicat Softening Point ()	80°C (176°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

General

* 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

Nominal Values

Blown Film Processing Information

Blown Film: The melt temperature of Appeel® 55041 should be maintained in the 160 - 185°C range. Selection of a specific melt temperature will depend on screw configuration, potential power limitations, and the need to match melt viscosities. However, melt temperatures above 260°C should be avoided because of possible thermal degradation of the resin.

If the process is stopped for short periods of time, the Appeel® 55041 resin extruder should be kept turning at low rpm. For a permanent shutdown, the Appeel® 55041 resin should be purged out using an available polyethylene resin run at the same extrusion temperature used for the Appeel® 55041 resin. Never raise temperature over 260°C until Appeel® 55041 resin is completely purged out. Appeel® 55041 requires relatively low processing temperatures and cooling the bottom of hopper due to its low Vicat point and higher comonomer level.

Following is an example for suggested temperature profile on the low side of the processing range. Higher temperatures in the final metering zone, adapter and die are suggested if compatible with the process and application.

Feed Zone	135°C (275°F)
Second Zone	160°C (320°F)
Third Zone	160°C (320°F)
Fourth Zone	160°C (320°F)
Fifth Zone	160°C (320°F)
Adapter Zone	160°C (320°F)
Die Zone	160°C (320°F)

Cast Film / Sheet Processing

Nominal Values

Cast Film / Sheet Processing

Cast Film: The melt temperature of Appeel® 55041 should be maintained in the 210 - 235°C range. Selection of a specific melt temperature will depend on screw configuration, potential power limitations, and the need to match melt viscosities. However, melt temperatures above 260°C should be avoided because of possible thermal degradation of the resin.

If the process is stopped for short periods of time, the Appeel® 55041 resin extruder

should be kept turning at low rpm. For a permanent shutdown, the Appeel® 55041 resin should be purged out using an available polyethylene resin run at the same extrusion temperature used for the Appeel® 55041 resin. Never raise temperature over 260°C until Appeel® 55041 resin is completely purged out. Appeel® 55041 requires relatively low processing temperatures and cooling the bottom of hopper due to its low Vicat point and higher comonomer level.

Following is an example for suggested temperature profile on the high side of the processing range. Lower temperatures in the final metering zone, adapter and die are suggested if compatible with the process and application.

Feed Zone	160°C (320°F)
Second Zone	185°C (365°F)
Third Zone	210°C (410°F)
Fourth Zone	235°C (455°F)
Fifth Zone	235°C (455°F)
Adapter Zone	235°C (455°F)
Die Zone	235°C (455°F)

FDA Status Information

Appeel® 55041 resin complies with Food and Drug Administration Regulation 21 CFR 177.1520(c)3.2a with limitations: Final article must meet thickness limitation of 0.1 mm (4 mil) as per 177.1520(c)3.6, Final blend is restricted to food types as per 177.1520(c)3.7. This regulation describes resinous and polymeric coatings for polyolefin films that may be used in contact with food types I, II, IV-B, VI-A, VI-B, VI-C, VII-B and VIII identified in Table of 21 CFR 176.170(c) under Conditions of Use A through H described in 176.170(c).

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

Appeel® 55041 complies with Japan Hygienic Olefin and Styrene Plastics Association and MITI no. 20 Food regulation in Japan.

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 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:

Americas

DuPont Company
Chestnut Run Plaza – Bldg. 730

Asia Pacific

DuPont China Holding Co., Ltd.
Shanghai Branch

Europe / Middle East / Africa

DuPont de Nemours Int'l. S.A.
2,Chemin du Pavillon Box 50

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

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

CH-1218 Le Grand Saconnex
Geneva, Switzerland
Telephone +41 22 717 51 11
Fax +41 22 717 55 00

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

<http://appeel.dupont.com>

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This data sheet is effective as of 09/24/2009 06:01:31 PM and supersedes all previous versions.