

DuPont™ Bynel® 39E660

Bynel® resins Product Data Sheet

Description

Product Description BYNEL® Series 3900 resins are anhydride-modified ethylene vinyl acetate polymers. They are available in pellet form for use in conventional extrusion and coextrusion equipment designed to process polyethylene (PE) resins.

Restrictions

Material Status • Developmental: Active

Typical Characteristics

Characteristics / Benefits Physical properties of BYNEL Series 3900 resins are typical of EVA resins with similar density and melt index value.

Applications BYNEL 3900 series resins are most often used to adhere to EVA, EVOH, ionomer, polyamide and PE.

Typical Properties

Physical	Nominal Values	Test Method(s)	
* Density ()	0.94 g/cm³	ASTM D792	ISO 1183
* Melt Flow Rate (190°C/2.16kg)	2.5 g/10 min	ASTM D1238	ISO 1133
Thermal	Nominal Values	Test Method(s)	
* Melting Point (DSC)	95°C (203°F)	ASTM D3418	ISO 3146
Freezing Point (DSC)	74°C (165°F)	ASTM D3418	ISO 3146
Vicat Softening Point ()	72°C (162°F)	ASTM D1525	ISO 306

Additional

Adhesive Evaluation The performance of any adhesive resin should be evaluated within the context of the application. The adhesive is designed to bond materials that would not ordinarily adhere to each other. In most cases, peel strength is used as a measure of performance. Although this is a convenient test, peel strength is affected not only by adhesion, but also by peel angle, separation rate, temperature, and tensile and modulus properties of the materials, and often by the time elapsed since the formation of the bond. Post-treatment of the multi-layer structure, such as heat sealing, thermoforming or orientation can also affect peel strength.

If peel strength is used as a measure of adhesive performance, it is imperative that peel strength be evaluated not only at the time of manufacture, but throughout the life of the product and under all the various conditions to which the structure will be exposed. Only then can the performance of the adhesive be related to peel strength.

Processing Information

General

- * Maximum Processing Temperature 235°C (455°F)

General Processing Information

The temperature profiles shown below are for initial evaluations of BYNEL adhesive resins in the 3900 series. This profile is designed to provide adequate exposure time of the adhesive resin to elevated temperatures. Exposure to elevated temperatures activates the anhydride which improves the bonding capability of the adhesive resin. Regardless of the profile used, the adhesive resin should be exposed to temperatures of a minimum of 210C (410F) to a maximum of 235C (455F) for several minutes prior to contact with the other molten resins in coextrusion in order to ensure adequate performance of the adhesive resin.

Because the BYNEL 3900 Series resins have low softening points, it is a good idea to run the rear of the extruder as cool as possible, then build quickly to the melt temperature. Water cooling of the screw and/or hopper feed throat may help avoid bridging problems.

We suggest that the maximum melt temperature be limited to 235C (455F) to guard against overheating the EVOH. If adhesion results are adequate, we suggest evaluating even lower melt temperatures.

Variation of these suggested temperature profiles may be appropriate depending upon the screw configuration, potential extruder horsepower limitations, potential back pressure limitations, the need to match rheologies and/or the stability of the other resins in the coextrusion. Film quality will also depend upon the residence time of the adhesive resin in the system. Dead spots may result in localized overheating and should be avoided by ensuring the flow path for the adhesive is as streamlined as possible.

We suggest using a standard polyolefin screw when extruding BYNEL 3900 series resins. Excessively deep flights should be avoided as they might result in poor melting of the adhesive resin. Excessively high shear screws should also be avoided to minimize gel and degradation formation. It is also important to properly size the extruder for the output desired. Running large extruders at very low RPMs should be avoided.

For producing monolayer adhesive films with BYNEL 3900 adhesive resins, extrusion conditions commonly used for converting ethylene vinyl acetate resins into films can be employed.

When extruding BYNEL 3900 series resins as an exposed outer surface in a multi-layer coextrusion, problems related to the tackiness and high coefficient of friction of these products may be evident. In this case, it is suggested that the extrusion temperature be lowered to 160C - 185C (320C - 365F) or less. Addition of slip and silica-based antblock packages may also be appropriate to prevent blocking and improve film handling, although these additive packages may modify the resin's bonding characteristics.

If the coextrusion process is stopped for short periods of time, the screw in the adhesive extruder should be kept turning at a low RPM level. For a permanent shutdown, the BYNEL adhesive resin should be purged out using an available polyethylene resin run at the same extrusion temperature used during the extrusion process of the adhesive resin. Making frequent changes in screw speed during the shutdown process and subsequent start-up will help remove the previous material from the system more effectively. Sometimes upon start-up of the adhesive resin, excessive amounts of gel may be observed. This may be due to the natural ability of the adhesive resin to act as a purging compound. In this case, continued extrusion will eventually clear up the problem.

CoExtrusion w/EVOH Processing

Nominal Values

CoExtrusion w/EVOH Processing Information

Feed Zone	160°C (320°F)
Second Zone	185°C (365°F)
Third Zone	210°C (410°F)
Fourth Zone	210°C (410°F)

Fifth Zone	210°C (410°F)
Adapter Zone	235°C (455°F)
Die Zone	235°C (455°F)

CoExtrusion w/Nylon Processing	Nominal Values
--------------------------------	----------------

CoExtrusion w/Nylon Processing Information	Proposed Extruder Set Temperatures
Feed Zone	160°C (320°F)
Second Zone	210°C (410°F)
Third Zone	235°C (455°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

BYNEL® 39E660 Adhesive Resin complies with Food and Drug Administration Regulation 21 CFR 177.1350(a)(1) - - Ethylene-vinyl acetate copolymers, 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)(1) of the Regulation. When contacting food Types III, IV-A, V, VI-C, VII-A, and IX (identified in Table 1 of 21 CFR 176.170(c)), the applications are limited to Conditions of Use C, D, E, F, and G (as described in Table 2 of 21 CFR 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

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
974 Centre Road

Asia Pacific

DuPont China Holding Co., Ltd.
Shanghai Branch
399 Keyuan Road, Bldg. 11

Europe / Middle East / Africa

DuPont de Nemours Int'l. S.A.
2,Chemin du Pavillon Box 50
CH-1218 Le Grand Saconnex

Wilmington, Delaware
19805 U.S.A.
Toll-Free (USA): 1-800-628-6208
Telephone: 1-302-774-1000
Fax: 1-302-355-4013

Zhangjiang Hi-Tech Park
Pudong New District, Shanghai
P.R. China (Postcode: 201203)
Telephone +86 21 3862 2888
Fax +86-21-3862-2889

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://bynel.dupont.com>

The data listed here fall within the normal range of properties, but they should not be used to establish specification limits nor used alone as the basis of design. The DuPont Company assumes no obligations or liability for any advice furnished or for any results obtained with respect to this information. All such advice is given and accepted at the buyer's risk. The disclosure of information herein is not a licence to operate under, or a recommendation to infringe, any patent of DuPont or others. Since DuPont cannot anticipate all variations in actual end-use conditions, DuPont makes no warranties and assumes no liability in connection with any use of this information.

CAUTION: Do not use DuPont materials in medical applications involving implantations in the human body or contact with internal body fluids or tissues unless the material has been provided from DuPont under a written contract that is consistent with DuPont policy regarding medical applications and expressly acknowledges the contemplated use. For further information, please contact your DuPont representative. You may also request a copy of DuPont POLICY Regarding Medical Applications H-50103-3 and DuPont CAUTION Regarding Medical Applications H-50102-3.

Copyright © 2009 DuPont. The DuPont Oval Logo, DuPont™, The miracles of science™, and trademarks designated with "®" are registered trademarks or trademarks of E.I. du Pont de Nemours and Company or its affiliates. All rights reserved.

This data sheet is effective as of 08/07/2010 04:46:46 PM and supersedes all previous versions.