**DuPont™ Elvaloy® AC 1224**

**Elvaloy® AC resins Product Data Sheet**

### Description

**Product Description**
Elvaloy® AC 1224 is a copolymer of ethylene and methyl acrylate. It is available in pellet form for use in conventional extrusion equipment designed to process polyethylene type resins.

### Restrictions

**Material Status**
- Commercial: Active

### Typical Characteristics

**Composition**
- 24% By Weight Methyl Acrylate comonomer content

### Typical Properties

<table>
<thead>
<tr>
<th>Physical</th>
<th>Nominal Values</th>
<th>Test Method(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Density ()</td>
<td>0.944 g/cm³</td>
<td>ASTM D792</td>
</tr>
<tr>
<td>Melt Flow Rate (190°C/2.16kg)</td>
<td>2 g/10 min</td>
<td>ASTM D1238</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Thermal</th>
<th>Nominal Values</th>
<th>Test Method(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Melting Point (DSC)</td>
<td>91°C (196°F)</td>
<td>ASTM D3418</td>
</tr>
<tr>
<td>Vicat Softening Point ()</td>
<td>48°C (118°F)</td>
<td>ASTM D1525</td>
</tr>
</tbody>
</table>

### Processing Information

**General**
- Maximum Processing Temperature: 310°C (590°F)

**General Processing Information**
Elvaloy® AC 1224 is normally processed at melt temperatures ranging from 160°C - 235°C (320°F - 455°F) in blown film or cast film equipment. A typical blown film extruder temperature profile is given below. Actual processing temperatures will be determined by either the specific equipment or one of the other polymers in a coextrusion. Elvaloy® AC 1224 can also be used in cast extrusions and coextrusions. It is easily processed on standard equipment used for low density polyethylene.

#### Blown Film Processing

<table>
<thead>
<tr>
<th>Blown Film Processing Information</th>
<th>Nominal Values</th>
</tr>
</thead>
<tbody>
<tr>
<td>Feed Zone</td>
<td>135°C (275°F)</td>
</tr>
<tr>
<td>Second Zone</td>
<td>160°C (320°F)</td>
</tr>
<tr>
<td>Third Zone</td>
<td>185°C (365°F)</td>
</tr>
<tr>
<td>Fourth Zone</td>
<td>185°C (365°F)</td>
</tr>
</tbody>
</table>
Fifth Zone 185°C (365°F)
Adapter Zone 185°C (365°F)
Die Zone 185°C (365°F)

FDA Status Information
ELVALOY® AC 1224 Acrylate Copolymer Resin complies with Food and Drug Administration Regulation 21 CFR 177.1340(a) - - 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.

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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

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This data sheet is effective as of 08/08/2010 12:29:19 PM and supersedes all previous versions.