**DuPont Elvax® 3128-1**

**Elvax® resins Product Data Sheet**

### Description

**Product Description**
DuPont™ Elvax® 3128-1 is an extrudable ethylene-vinyl acetate copolymer resin available in pellet form for use in conventional extrusion equipment designed to process polyethylene resins.

### Restrictions

**Material Status**
Commercial: Active

### Typical Characteristics

**Composition**
- 9.3% By Weight Vinyl Acetate comonomer content
- Thermal Stabilizer: BHT antioxidant

**Applications**
This resin is designed to provide a low temperature heat seal to itself or many other materials commonly used in flexible packaging applications. The melt properties of this resin allow it to be processed on blown film equipment over a wide range of film thickness and blow-up ratios. It can also be cast or used in coextrusion with a variety of other polymers. This resin is typically used as low temperature seal layer in coextruded films.

### Typical Properties

#### Physical

<table>
<thead>
<tr>
<th>Property</th>
<th>Nominal Values</th>
<th>Test Method(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>*Density ()</td>
<td>0.93 g/cm³</td>
<td>ASTM D792, ISO 1183</td>
</tr>
<tr>
<td>*Melt Flow Rate (190°C/2.16kg)</td>
<td>2 g/10 min</td>
<td>ASTM D1238, ISO 1133</td>
</tr>
</tbody>
</table>

#### Thermal

<table>
<thead>
<tr>
<th>Property</th>
<th>Nominal Values</th>
<th>Test Method(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>*Melting Point (DSC)</td>
<td>99 °C (210.2 °F)</td>
<td>ASTM D3418, ISO 3146</td>
</tr>
<tr>
<td>Freezing Point (DSC)</td>
<td>83 °C (181.4 °F)</td>
<td>ASTM D3418, ISO 3146</td>
</tr>
<tr>
<td>Vicat Softening Point ()</td>
<td>77 °C (170.6 °F)</td>
<td>ASTM D1525, ISO 306</td>
</tr>
</tbody>
</table>

### Processing Information

**General Processing Information**
Elvax® can be used in conventional extrusion equipment designed to process polyethylene resins. However, corrosion-protected barrels, screws, adapters, and dies are recommended, since, at sustained melt temperatures above 455°F (235°C), ethylene vinyl acetate (EVA) resins may thermally degrade and release corrosive by-products.

**Blown Film Processing**

<table>
<thead>
<tr>
<th>Zone</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)

**Cast Film / Sheet Processing Nominal Values**

**Processing Information**
Resin melt temperature should be maintained in the range of 185-235°C (365-455°F) to provide a suitable viscosity and melt strength for cast film / sheet extrusion. Selection of a specific melt temperature will depend on considerations such as desired gauge, cooling capacity, extruder hold up time, winding conditions, and other machine variables.

Feed Zone 135 °C (275 °F)
Second Zone 160 °C (320 °F)
Third Zone 185 °C (365 °F)
Fourth Zone 210 °C (410 °F)
Fifth Zone 210 °C (410 °F)
Adapter Zone 210 °C (410 °F)
Die Zone 210 °C (410 °F)

**FDA Status Information**
ELVAX® 3128-1 EVA 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.

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.A., consult your local DuPont representative.

**Safety & Handling**
THE IMPORTANCE OF PROPER HANDLING & STORAGE:

Maintaining proper handling and storage conditions for DuPont™ Elvax® resins is very important to ensure overall product quality and keep the resin in a free-flowing state. If the Elvax® resin is subjected to sunlight, rain or excessive temperatures, then the resin may not process properly or achieve the desired characteristics in the final product.

It is crucial for Elvax® resins to be kept under proper storage and handling conditions because improper storage and handling may cause the resin to “block” (massing of pellets into large clumps that can hinder the ease of material transfer) or lose the ability to flow freely.

Please refer to the Elvax® Handling Guide for additional information.

For additional 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 Performance Materials representative.

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