

## DuPont™ Surlyn® 6320

### Surlyn® resins Product Data Sheet

#### Description

**Product Description** Surlyn® 6320 is a magnesium ionomer thermoplastic resin. It is available for use in conventional extrusion and injection equipment, to create various sheets or shapes.

Surlyn® 6320 thermoplastic resin is an advanced ethylene/acid/acrylate terpolymer, in which some of the MAA acid groups have been partially neutralized with magnesium ions.

#### Restrictions

**Material Status** • Commercial: Active

#### Typical Characteristics

**Features** Magnesium Ionomer

**Characteristics / Benefits** Flexural Modulus (23C) ----- 53.1 MPa ----- ASTM D790  
 Tensile Elongation @ Break (23C) ---- 530% ----- ASTM D638 / ISO 527-2  
 Tensile Strength @ Break (23C) ----- 23.4 MPa ----- ASTM D638 / ISO 527-2  
 Hardness (Shore D) ----- 43 ----- ASTM D2240 / ISO 868

**Applications** Injection Molding / Compounding

#### Typical Properties

Physical	Nominal Values	Test Method(s)	
* Density ( )	0.95 g/cm <sup>3</sup>	ASTM D792	ISO 1183
* Melt Flow Rate (190°C/2.16kg)	1 g/10 min	ASTM D1238	ISO 1133
Thermal	Nominal Values	Test Method(s)	
* Melting Point (DSC)	70°C (158°F)	ASTM D3418	ISO 3146
Freezing Point (DSC)	34°C (93°F)	ASTM D3418	ISO 3146
Vicat Softening Point ( )	49°C (120°F)	ASTM D1525	ISO 306

#### Processing Information

##### General

\* Maximum Processing Temperature 285°C (545°F)

General Processing Information Surlyn® 6320 is normally processed at melt temperatures ranging from 185°-285°C (365°-545°F). Actual processing temperatures will usually be determined by either

the specific equipment or substrate or one of the other polymers in a coextrusion or coinjection..

Materials of construction used in the processing of this resin should be corrosion resistant. Stainless steels of the types 316, 15-5PH, and 17-4PH are excellent, as is quality chrome or nickel plating, and in particular duplex chrome plating. Type 410 stainless steel is satisfactory, but needs to be tempered at a minimum temperature of 600°C (1112°F) to avoid hydrogen-assisted stress corrosion cracking. Alloy steels such as 4140 are borderline in performance. Carbon steels are not satisfactory. While stainless steels can provide adequate corrosion protection, in some cases severe purging difficulties have been encountered. Nickel plating has been satisfactory, but experiments have shown that chrome surfaces have the least adhesion to acid based polymers. In recent years, the quality of chrome plating has been deteriorating due to environmental pressures, and the corrosion protection has not always been adequate. Chrome over top of stainless steel seems to provide the best combination for corrosion protection and ease of purging.

If surface properties of the extruded resin require modification (such as, lower C.o.F. for packaging machine processing), refer to the Conpol™ Processing Additive Resins product information guide.

After processing Surlyn, purge the material out using a polyethylene resin, preferably with a lower melt flow rate than the Surlyn 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 Surlyn in the extruder and die. Properly purge out the Surlyn with a polyethylene, and shut down the line with polyethylene or polypropylene in the system.

#### **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**

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