



Dow Packaging & Speciality Plastics Product Data Sheet

NUCREL™ AE

Acid Copolymer

Description			
Product Description	NUCREL™ AE is a terpolymer of ethylene, methacrylic acid, and acrylate. It is available for use in conventional extrusion coating, coextrusion coating and extrusion laminating equipment designed to process polyethylene resins. It can be used as a modifier for PE in blends of approximately 20 to 40% NUCREL™ AE with 80 to 60% LDPE for enhancement of foil adhesion properties. The level of adhesion improvement depends on processing conditions.		
Restrictions			
Material Status	Commercial: Active		
Typical Characteristics			
Uses	Adhesives; Packaging; Sealants		
Composition	Proprietary		
Features	Improved foil adhesion when processed under the correct conditions. Increased peak hot tack strength.		
Applications	<ul style="list-style-type: none">- Foil-containing pouches and sachets for packaging non-aggressive food and miscellaneous non-food products.- Snack structures- Other foil, metallized film, or paper coatings as a heat seal or tie layer		
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)	10 g/10 min	ASTM D1238	ISO 1133
Thermal	Nominal Values	Test Method(s)	
*Melting Point (DSC)	105 °C (221 °F)	ASTM D3418	ISO 3146
Freezing Point (DSC)	85 °C (185 °F)	ASTM D3418	ISO 3146
Vicat Softening Point ()	79 °C (174.2 °F)	ASTM D1525	ISO 306
Processing Information			
*Maximum Processing Temperature	325 °C (617 °F)		
General Processing Information	NUCREL™ AE at the recommended blend ratio of 20 to 40% is normally processed at melt temperatures ranging from 290°- 325°C (550°- 617°F) in flat die equipment. Actual processing temperatures will usually be determined by either the specific equipment or substrate or one of the other polymers in a coextrusion. 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 NUCREL™, purge the material out using a polyethylene resin, preferably with a lower melt flow rate than the NUCREL™ 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 Dow Sales Representative.

Never shut down the extrusion system with NUCREL™ in the extruder and die. Properly purge out the NUCREL™ with a polyethylene, and shut down the line with polyethylene or polypropylene in the system.

Extrusion Coating/Lamination Processing

Nominal Values

Processing Information

A suggested extruder set temperature profile.

Feed Zone

185 °C (365 °F)

Second Zone

235 °C (455 °F)

Third Zone

285 °C (545 °F)

Fourth Zone

310 °C (590 °F)

Fifth Zone

310 °C (590 °F)

Adapter Zone

310 °C (590 °F)

Die Zone

310 °C (590 °F)

FDA Status Information

NUCREL™ AE complies with Food and Drug Administration Regulation 21 CFR 177.1330(b) - - Ionomeric 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 (d) 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 Dow 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, Dow 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 Dow 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 Dow representative.

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- b. use in cardiac prosthetic devices regardless of the length of time involved (“cardiac prosthetic devices” include, but are not limited to, pacemaker leads and devices, artificial hearts, heart valves, intra-aortic balloons and control systems, and ventricular bypass-assisted devices);
- c. use as a critical component in medical devices that support or sustain human life; or
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