



Dow Packaging & Specialty Plastics

Product Data Sheet

SURLYN™ 1605

Ionomer

General Information

Product Description SURLYN™ 1605 is an ionomer of ethylene acid copolymer.

The resin can be processed in conventional blown film, cast film, sheet extrusion and coextrusion equipment designed to process polyethylene and ethylene copolymer type resins. It also can be processed in extrusion coating and coextrusion coating equipment designed to process polyethylene and ethylene copolymer type resins.

Status

Material Status Commercial: Active

Typical Characteristics

Composition Sodium Ionomer

Typical Properties

Physical	Nominal Values	Test Method(s)	
*Density ()	0.95 g/cm ³	ASTM D792	ISO 1183
*Melt Flow Index (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 D3417	ISO 3146
Freezing Point (DSC)	67 °C (152.6 °F)	ASTM D3417	ISO 3146
Vicat Softening Point ()	64 °C (147.2 °F)	ASTM D1525	ISO 306

Processing Information

*Maximum Processing Temperature 310 °C (590 °F)

General Processing Information SURLYN™ 1605 is normally processed at melt temperatures ranging from 185°-285°C (365°-545°F) in flat die equipment. For cast film / sheet, a typical extruder profile is below. 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 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 Dow 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.

Blown Film	Nominal Values
Processing Information	A suggested initial extruder temperature set profile.
Feed Zone	135 °C (275 °F)
Second Zone	160 °C (320 °F)
Third Zone	185 °C (365 °F)
Fourth Zone	185 °C (365 °F)
Fifth Zone	185 °C (365 °F)
Adapter Zone	185 °C (365 °F)
Die Zone	185 °C (365 °F)

Cast Film / Sheet	Nominal Values
Processing Information	A suggested initial extruder temperature set profile.
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)

Extrusion Coating/Lamination	Nominal Values
Processing Information	A suggested initial extruder temperature set profile.
Feed Zone	160 °C (320 °F)
Second Zone	210 °C (410 °F)
Third Zone	260 °C (500 °F)
Fourth Zone	285 °C (545 °F)
Fifth Zone	285 °C (545 °F)
Adapter Zone	285 °C (545 °F)
Die Zone	285 °C (545 °F)

FDA Status Information SURLYN™ 1605 complies with Food and Drug Administration Regulation 21 CFR 177.1330(a) - - 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 (c) of the Regulation.

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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.

Product Stewardship

Dow has a fundamental concern for all who make, distribute, and use its products, and for the environment in which we live. This concern is the basis for our product stewardship philosophy by which we assess the safety, health, and environmental information on our products and then take appropriate steps to protect employee and public health and our environment. The success of our product stewardship program rests with each and every individual involved with Dow products - from the initial concept and research, to manufacture, use, sale, disposal, and recycle of each product.

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<https://www.dow.com/en-us/support/product-safety.html>

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For additional information, not covered by the content of this document, contact us via our web site

http://www.dow.com/products_services

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P&SP Disclaimer

Additional Information

To contact Dow via Toll-Free or Local Toll phone numbers in specific countries, please see the following webpage:

<https://www.dow.com/en-us/support/contact-representative.html>

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