



APPEEL™ 53008

Peelable Resin

Description			
Product Description	APPEEL™ 53008 is a modified ethylene vinyl acetate copolymer resin designed to function as a sealing layer for lidding applications. It is most often suggested to provide strong peelable seals to polypropylene, and moderate seals to polystyrene, polyester, PVC and is available in pellet form for use in conventional extrusion or coextrusion equipment designed to process polyethylene resins.		
Restrictions			
Material Status	Commercial: Active		
Typical Characteristics			
Uses	Lidding Sealant		
Applications	<ul style="list-style-type: none">- Low temperature heat seal. APPEEL™ 53008 offers low temperature heat seals with adequate seal strength at 90C.- Heat sealability to various materials including PE, PP, PS, and Rigid PVC. APPEEL™ 53008 can also be sealed to paper, paperboard, woven fabrics, non-woven fabrics, wood and photographic papers.- APPEEL™ 53008 allows a peelable seal from most plastic materials excluding PE.- High transparency.- Boiling resistance. APPEEL™ 53008 endures boiling process, whose conditions are 85C / 30min.- APPEEL™ 53008 conforms to Code #20 of the Ministry of Health and Welfare Japan. <p>- APPEEL™ 53008 is used as a heat seal layer in lidding material for injection molded and vacuum molded plastic containers, especially HIPS and PS used in the packaging of yogurts, jams, butter and other food items.</p> <p>Typical structures for this lidding would be: OPP/PE/ APPEEL™ 53008 PET/PE/ APPEEL™ 53008 Over lacquer/Print/Foil/PE/ Appeel™ 53008 Paper/PE/Foil/PE/ APPEEL™ 53008</p> <p>APPEEL™ 53008 can also be used as a sealant in general flexible packaging. It provides low temperature seals for snacks and confectionery.</p>		
Typical Properties			
Physical	Nominal Values	Test Method(s)	
*Density ()	0.94 g/cm ³	ASTM D792	ISO 1183
*Melt Flow Rate (190°C/2.16kg)	4.5 g/10 min	ASTM D1238	ISO 1133
Thermal	Nominal Values	Test Method(s)	
*Melting Point (DSC)	94 °C (201.2 °F)	ASTM D3418	ISO 3146
Heat Seal Evaluation	<p>The performance of any sealant resin should be evaluated within the context of the application. The sealant is designed to bond to particular substrate(s). Many variables can affect seal strength, including the physical properties of the substrate being sealed to, thickness, flange or surface design, heat seal temperature, dwell time and pressure. The condition and type of the sealing equipment used, such as roller sealers versus platen seal mechanisms can make a significant difference.</p> <p>In most cases sealant peel strength is used as a measure of performance. Although this is a convenient test, peel strength is affected not only by substrate adhesion but also by peel angle, separation rate, ambient temperature, tensile and modulus properties of the materials, and often by the time elapsed since the formation of the bond.</p> <p>If sealant peel strength is used as a measure of sealant performance, it is imperative that peel strength be evaluated not only at the time of initial heat sealing the lid to the substrate, but throughout the life of the product and under all the conditions to which the sealant will be exposed. Only then does peel strength provide a reliable indication of adhesive performance in the specific application.</p>		

Processing Information

*Maximum Processing Temperature 235 °C (455 °F)

General Processing Information If the process is stopped for short periods of time, the screw for the APPEEL™ extruder should be kept turning at a low rpm to keep material flowing.

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

Blown Film Processing

Nominal Values

Processing Information

Blown Film: The melt temperature of APPEEL™ 53008 should be maintained in the 135 - 185°C range. Selection of a specific melt temperature will depend on screw configuration, potential power limitations, and the need to match melt viscosities. However, melt temperatures above 238C (460F) should be avoided because of possible thermal degradation of the resin.

If the process is stopped for short periods of time, the APPEEL™ 53008 resin extruder should be kept turning at low rpm. For a permanent shutdown, the APPEEL™ 53008 resin should be purged out using an available polyethylene resin run at the same extrusion temperature used for the APPEEL™ 53008 resin. Never raise temperature over 235°C until APPEEL™ 53008 resin is completely purged out. APPEEL™ 53008 requires relatively low processing temperatures and cooling the bottom of hopper due to its low Vicat point and higher comonomer level.

Following is an example for suggested temperature profile on the high side of the processing range. Lower temperatures in the final metering zone, adapter and die are suggested if compatible with the process and application.

Feed Zone 110 °C (230 °F)

Second Zone 135 °C (275 °F)

Third Zone 160 °C (320 °F)

Fourth Zone 160 °C (320 °F)

Fifth Zone 160 °C (320 °F)

Adapter Zone 160 °C (320 °F)

Die Zone 160 °C (320 °F)

Extrusion Coating/Lamination Processing

Nominal Values

Processing Information

Extrusion Coating: The melt temperature of APPEEL™ 53008 should be maintained in the 185 - 235°C range in extrusion coating processes. Selection of a specific melt temperature will depend on screw configuration, potential power limitations, and the need to match melt viscosities. However, melt temperatures above 238C (460F) should be avoided because of possible thermal degradation of the resin.

If the process is stopped for short periods of time, the APPEEL™ 53008 resin extruder should be kept turning at low rpm. For a permanent shutdown, the APPEEL™ 53008 resin should be purged out using an available polyethylene resin run at the same extrusion temperature used for the APPEEL™ 53008 resin. Never raise temperature over 235°C until APPEEL™ 53008 resin is completely purged out. APPEEL™ 53008 requires relatively low processing temperatures and cooling the bottom of hopper due to its low Vicat point and higher comonomer level.

Following is an example for suggested temperature profile on the high side of the processing range. Lower temperatures in the final metering zone, adapter and die are suggested if compatible with the process and application.

Feed Zone 135 °C (275 °F)

Second Zone 185 °C (365 °F)

Third Zone 210 °C (410 °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)

FDA Status Information

APPEEL™ 53008 Lidding 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, 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. APPEEL™ 53008 Lidding Resin may be used in contact with food types I, II, IV-B, VI-A, VI-B, VI-C, VII-B and VIII under Conditions of Use B through H* with no thickness limitation. APPEEL™ 53008 Lidding Resin may also be used for food types III, IV-A, VII-A, and IX under conditions of use B through H* provided the thickness of the final article is less than 1.2 mils (30 microns).

Reference:

http://www.fda.gov/Food/IngredientsPackagingLabeling/PackagingFCS/FoodTypesConditionsofUse/ucm109358.htm

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Regulatory Information

APPEEL™ 53008 complies with Japan Hygienic Olefin and Styrene Plastics Association and MITI no. 20 Food regulation in Japan.

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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