

## 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	
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.

## **Safety & Handling**

Surlyn® 6320 as supplied by DuPont are not considered hazardous materials. As with any hot material, care should be taken to protect the hands and other exposed parts of the body when handling molten polymer. At recommended processing temperatures, small amounts of fumes may evolve from the resins. When resins are overheated, more extensive decomposition may occur. Adequate ventilation should be provided to remove fumes from the work area. Disposal of scrap presents no special problems and can be by landfill or incineration in a properly operated incinerator. Disposal should comply with local, state, and federal regulations. Resin pellets can be a slipping hazard. Loose pellets should be swept up promptly to prevent falls. For more detailed information on the safe handling and disposal of DuPont resins, a Material Safety Data Sheet can be obtained from the DuPont Packaging and Industrial Polymers website or by contacting your sales representative.

*The data listed here fall within the normal range of properties, but they should not be used to establish specification limits nor used alone as the basis of design. The DuPont Company assumes no obligations or liability for any advice furnished or for any results obtained with respect to this information. All such advice is given and accepted at the buyer's risk. The disclosure of information herein is not a licence to operate under, or a recommendation to infringe, any patent of DuPont or others. Since DuPont cannot anticipate all variations in actual end-use conditions, DuPont makes no warranties and assumes no liability in connection with any use of this information.*

*CAUTION: Do not use DuPont materials in medical applications involving implantations in the human body or contact with internal body fluids or tissues unless the material has been provided from DuPont under a written contract that is consistent with DuPont policy regarding medical applications and expressly acknowledges the contemplated use. For further information, please contact your DuPont representative. You may also request a copy of DuPont POLICY Regarding Medical Applications H-50103-3 and DuPont CAUTION Regarding Medical Applications H-50102-3.*

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*This data sheet is effective as of 01/07/2010 8:12 AM and supersedes all previous versions.*