



Soarnol®

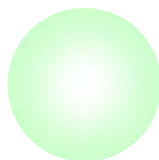
ETHYLENE-VINYLAALCOHOL COPOLYMER



V2504RB

25 mol% Ethylene Content





[General Description]

Soarnol V2504RB is one of the standard grades of “Soarnol®”, its ethylene content is 25 mol% with a low MFR(melt flow rate).

Soarnol V2504RB is truly a unique EVOH with the best gas barrier property at normal humidity of all commercial EVOH resins. It is suited for coextruded blow-molded containers as well as coextruded sheet, coextruded film and coextrusion coating.

[General Properties]

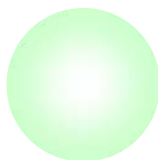
<i>Property</i>	<i>Unit</i>	<i>Value</i>
Ethylene Content	mol%	25
MFR ¹⁾ (@210°C, 2160g)	g/10min	4
Volatile Matter	%	< 0.3
Melting Point ²⁾	deg C	195
Crystallization Temperature ²⁾	deg C	171
Oxygen Permeability ³⁾	cc 20 μ m / m ² day atm	0.3
20deg C-50%RH	cc·mil/100inch ² ·day·atm	0.015
WVTR	g 30 μ m / m ² 24hrs	37-70
40deg C-90%RH		

1): Measured with Melt Indexer

2): Measured with DSC, both heating and cooling speeds of 10deg C /min

3): Measured with OXTRAN 10/50 (MOCON)





[Melt Viscosity]

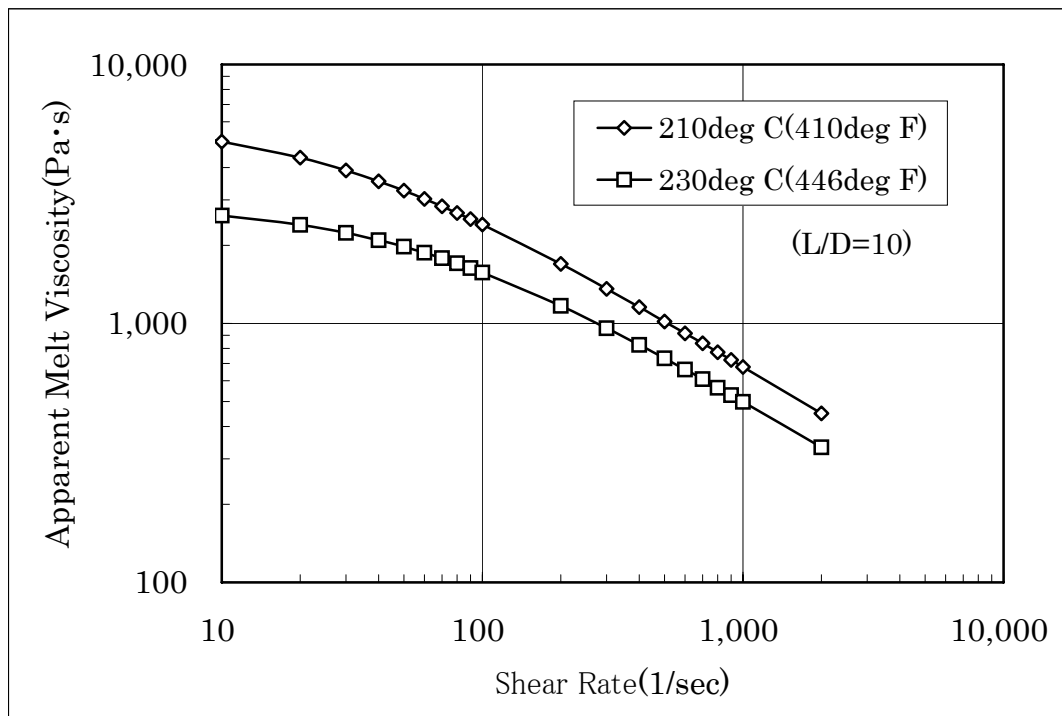


Fig.1 Melt Viscosity of Soarnol V2504RB

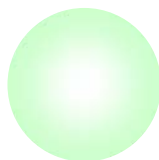
[Example of Processing]

- Extruder: 40 mm ϕ single screw extruder, L/D = 28
- Screw: Full-flighted, constant pitch type, CR = 3.5
- Screen pack: 80/120/50 mesh
- Die: Manifold type, die width = 450 mm, lip clearance = 0.2 mm

Processing Temperature: deg C(deg F)

C ₁	C ₂	C ₃	C ₄	C ₅	Head	Die
180	200	220	230	230	230	200-220
(356)	(392)	(428)	(446)	(446)	(446)	(392-428)





[Hygienic Performance of Soarnol V2504RB]

Soarnol V2504RB contains no heavy metals or other harmful substances.
Soarnol V2504RB meets the Food Sanitation Standards of various countries.

Japan: Ministry of Health and Welfare Announcement No.370(Dec. 28,1959)
and Its Latest Amendment No.18(Jan. 31,1994)

Self-Restrictive Requirements on Food-Contacting Articles
Made of Polyolefins and Certain Polymers

U.S.A.: FDA 21CFR 177.1360(a)(3) and 175.105

E U: European Commission Directive 90/128/EEC,
and Its Latest Amendment

Date Revised: April. 4, 2008

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