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Technical Data Sheet

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PHARMALENE®

FL 35 PH

EVA

Ethylene vinyl acetate copolymer

Pharmalene FL 35 PH is an ethylene vinyl acetate copolymer (EVA) for blown film extrusion, extrusion & injection moulding, manufactured using high pressure tubular technology. It is produced according to good manufacturing practices (GMP).

Main Application

Pharmalene FL 35 PH is intended for the use within pharmaceutical sector and is characterized by good stretchability and sealability. Pharmalene FL 35 PH is suitable for the production of transdermal patches and other TTS applications or can be used for injection molded articles for healthcare applications.

Main Properties

Resin Properties	Value	Unit	Test Method
Melt Flow Rate (190 °C/2,16 kg)	2,5	g/10min	ISO 1133
Vinyl acetate content	9	%	Internal method
Density	0,929	g/cm ³	ISO 1183
Melting Point	97	°C	Internal method
Brittleness temperature	< -80	°C	ASTM D 746
Vicat softening point (1 kg)	72	°C	ISO 306/A
Film Properties *	Value	Unit	Test Method
Tensile stress at yield MD	6	MPa	ISO 527-3
Tensile stress at yield TD	6	MPa	ISO 527-3
Tensile stress at break MD	28	MPa	ISO 527-3
Tensile stress at break TD	28	MPa	ISO 527-3
Elongation at break MD	500	%	ISO 527-3
Elongation at break TD	700	%	ISO 527-3
1% Secant modulus MD	65	MPa	ISO 527-3
1% Secant modulus TD	70	MPa	ISO 527-3
Elmendorf tear resistance MD	22	N/mm	ISO 6383-2
Elmendorf tear resistance TD	45	N/mm	ISO 6383-2
Impact resistance F50 (Dart Drop Test)	450	g	ISO 7765-1/A
Dynamic coefficient of friction (COF)	> 0,5	-	ISO 8295
Haze	3	%	ISO 14782
Gloss, 45°	80	%	ASTM D 2457
Recommended film thickness	25 ÷ 80	micron	-
Molded Specimen Properties *	Value	Unit	Test Method
Hardness Shore A:	94	-	ISO 868 A
Hardness Shore D:	42	-	ISO 868 A
Flexural Modulus:	90	MPa	ISO 178

(*) Film properties are typical of a blown film extruded at 200 °C. Molded specimen properties are referred to Injection Molding specimens. Actual properties may vary depending upon operating conditions and additive package.

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This document is constituted of 2 pages

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Processing notes

Pharmalene FL 35 PH can be processed by conventional blown film extrusion equipments. Operation temperature from 170°C to 200°C is recommended. Depending on extrusion conditions, the suggested film thickness is 25÷80 µm.

Storage and Handling

Pharmalene FL 35 PH is supplied in pellet form. This material may readily be conveyed and bulk fed through equipment designed for conventional pelletised polyethylene resin, provided the equipment is designed to prevent accumulation of fines and dust particles that are contained in all polyethylene resins. These fines and dust particles can, under certain conditions, pose an explosion hazard. We recommend that the conveying system used, is equipped with filters of adequate size, operated and maintained in such a manner to ensure that no leaks develop and earthed adequately. We further recommend, that good housekeeping should be practised throughout your facility.

Shelf Life: Polyethylene can be stored over a long period of time, as long as it is stored protected from solar irradiation, in a ventilated, dry and cool place, with a temperature kept below 50°C. Any exposure of the material to solar irradiation, reinforced by higher temperatures, has a detrimental impact on the product quality and can induce a degradation, which goes on subsequently.

We guarantee that Versalis Pharmalene® products keep complying with Versalis sales specification for 2 years after date of delivery under the recommended storage conditions. This statement does not prevent user performing MFR and density tests on the incoming material and every year for quality evaluation.

Ensuring a consistent material quality, we strongly recommend to follow the above mentioned handling and storage conditions for all Pharmalene® products. In case of non-respect of these storage precautions, Versalis cannot be held liable to any quality problem related to inappropriate handling and storage of the material and shelf-life can be altered.

Before using this product it is recommended to refer to the relevant Safety Data Sheet (SDS) for more detailed information.

Availability

Contact the Versalis sales office nearest to you regarding availability and your specific application requirements.

Food Contact Status

Pharmalene FL 35 PH complies with the European Union (Reg. 10/2011) and the USA (FDA) rules, related to the use of plastic materials intended for contact with foodstuffs. The composition of our product is compliant to the relevant sections of the European Pharmacopoeia (10th ed.) and those of the U.S. Pharmacopoeia (USP 42). Certificates of compliance are available upon request.

Technical Management Polyethylene Pharmalene

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DISCLAIMER: It is the responsibility of the user to verify the technical suitability and the safe and regulatory compliant usage of this product in all medical and pharmaceutical applications. If a usage of this product in applications of the pharmaceutical and medical sector, such as Class I, IIa, IIb or III Medical Devices (U.S. FDA, Health Canada and/or EU Directive 2007/47/EC) and in applications involving permanent implantation into the human body, is intended, user must consult Versalis to receive prior written approval for each specific product and applications.

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