

General Description and Use			
Argotec SKU Number	SE-381HF		
Typical application	More difficult encapsulated/decorative glass lamination structures		
Polymer	EVA ethylene vinyl acetate (copolymer)		
Extrusion method	Flat-die		
Gauge	15-30 mils (375 - 750 microns)		
Width	Up to 80 inches (2.032 meters)		
Length	Up to 140 yards (128 meters)		
Key attributes	<ul style="list-style-type: none"> ■ High melt flow (HF) for more difficult laminated glass structures ■ High transparency ■ High haze resistance ■ Long-term protection against UV-aging, discoloration and weathering ■ Blocks UV light below 380 nm ■ Non-tacky matte finish ■ Plasticizer-free ■ Self-priming ■ Crosslinked (cured) eliminates creep/cold flow ■ High moisture resistance 		
Typical Properties	Method	Unit	SE-381HF
Light transmission	US/VIS	%	90
Refractive index			>1.45
Haze (0.76 mm/0.030 in.)	ASTM D-1003	%	0.51
Yellowness index	ASTM E-313	YI	1.9
Specific gravity		g/cm ²	0.95
Melting point (uncured)	DSC	°F/°C	144/62
Melt flow rate (uncured)	ASTM D-1238	g/10 min.	43
Tensile strength	ASTM D-638	PSI/MPa	1500/10.3
Elongation	ASTM D-638	%	660
Young's modulus	ASTM D-638	PSI/MPa	724/5.0
Adhesion to glass	ASTM D-903	PLI/N/cm	>50/87.6
Water absorption	ASTM D-570	Wt. %	0.18
Crosslink level	Toluene extraction	%	65-85

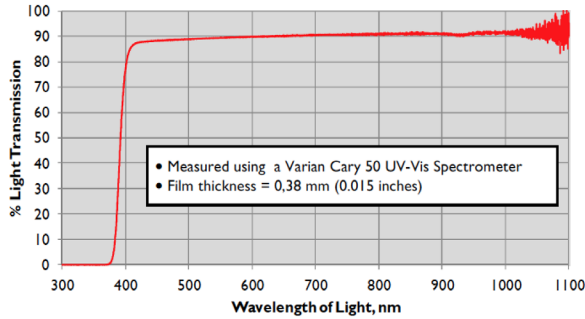


Fig. 1, Typical light transmission spectra

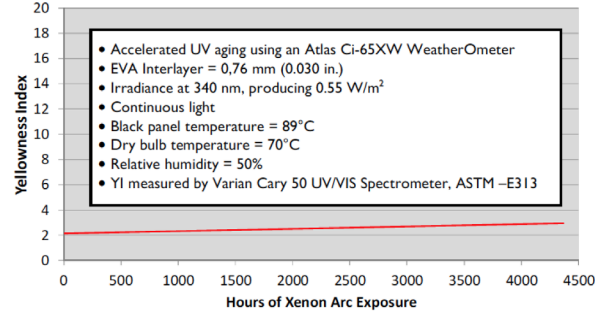


Fig. 2, Typical accelerated UV-aging characteristics

GENERAL PROCESSING INFORMATION

Lamination can be accomplished by autoclave or by vacuum lamination.

A minimum crosslink level of 65% is recommended to prevent creep at high installation temperatures and should be verified by gel content determinations.

Vacuum lamination: Typical process temperatures for the platen range between 239-266°F/115-130°C. Pump down or air evacuation times as required, typically 4-6 minutes. Press times are typically 35 minutes @ 266°F/130°C or 115 minutes @ 239°F/115°C.

Autoclave lamination: Pressurize between 125-180 psi. Raise the glass surface temperatures to 115°C and hold for 115 minutes or as required.

Vacuum bagging is recommended.



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SWM INTL

53 Silvio O. Conte Drive • Greenfield, Massachusetts 01301 U.S.A.
tel: 413/772-2564 • fax: 413-772-2565 • web: www.swmintl.com • email: ams@swmintl.com