

| General Description and Use | | | |
|-----------------------------|---|-------------------|-----------|
| AFFIX™ Number | HT-300 | | |
| 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 |

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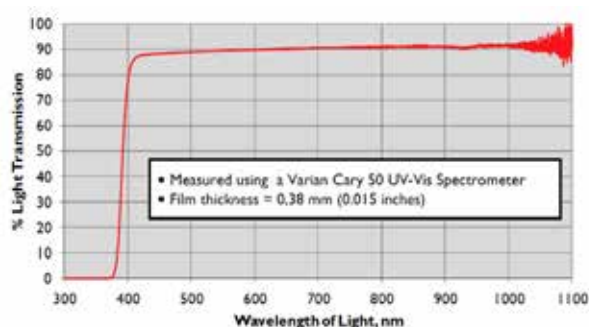


Fig. 1, Typical light transmission spectra

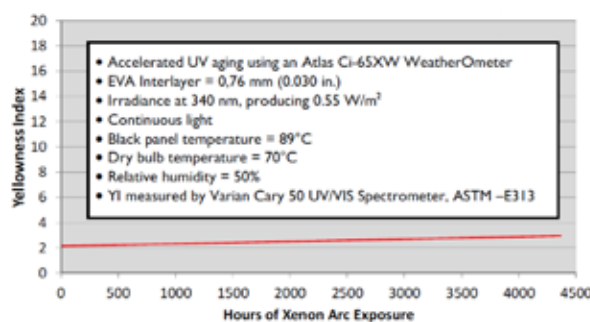


Fig. 2, Typical accelerated UV-aging characteristics

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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