



## ReZilok Rx 201

### Datasheet and Process Guide

#### Description

ReZilok Rx 201 tie-layer resin is a functionalized EVA based tie-layer. This tie-layer resin is used to bond dissimilar materials in coextrusion or reflow processes. ReZilok Rx 201 is optimized for adhesion to a variety of materials through chemical and physical bonding mechanisms.

|                          |                            |
|--------------------------|----------------------------|
| <b>Form</b>              | Pellets                    |
| <b>Appearance</b>        | Translucent                |
| <b>Applications</b>      | Multilayer film and tubing |
| <b>Processing Method</b> | Extrusion                  |

#### Typical Properties

| Property                         | Value | Unit              | Test Method |
|----------------------------------|-------|-------------------|-------------|
| Density                          | 0.94  | g/cm <sup>3</sup> | Pycnometer  |
| Melt Flow Rate (190°C / 2.16kg)  | 3     | g/10 min          | ASTM D1238  |
| Hardness                         | 93    | Shore A           | ASTM D2240  |
| Ultimate Tensile Strength        | 1470  | psi               | ASTM D638   |
| Ultimate Tensile Elongation      | 350   | %                 | ASTM D638   |
| Flexural Modulus                 | 9.5   | kpsi              | ASTM D790   |
| Flexural Stress at 5% Deflection | 450   | psi               | ASTM D790   |

Notes:  
Test parts injection molded  
Test parts conditioned at 23°C / 50% RH for 24hr  
Tensile test speed 500mm/min  
Flexural test speed 1%/min

## Drying Requirements

In order to ensure maximum adhesion performance and extrusion surface quality, it is recommended to dry ReZilok Rx 201 at 160°F until moisture content is below 0.05%. In thin walled applications, drying ReZilok Rx 201 removes any potential pellet surface moisture which could influence final product surface aesthetics.

## Recommended Process Temperatures

| Zone            | Temperature (°F) |
|-----------------|------------------|
| Feed Zone       | 300 - 350        |
| Transition Zone | 400 - 450        |
| Metering Zone   | 430 - 480        |
| Adaptor         | 430 - 480        |
| Die             | 430 - 480        |

## Additional Process Considerations

A variety of factors can influence the adhesion performance of ReZilok Rx 201 tie-layer resin. Adhesion is generally improved by increasing the melt temperature, the duration of interlayer contact in the melt state, and the interlayer contact pressure.

## Purging

An EVA resin is recommended for purging prior to or after extrusion of ReZilok Rx 201. To prevent gel or char formation, it is recommended to maintain a slow throughput while the line is sitting idle with ReZilok Rx 201 in the barrel.

## Handling

ReZilok Rx 201 is supplied as free-flowing pellets. In general, ReZilok Rx 201 can be handled similar to standard polyethylene polymers. A Safety Data Sheet for ReZilok Rx 201 should be consulted for other detailed guidelines.

## Storage

Typical shelf life of ReZilok Rx 201 is two years from date of delivery in unopened packaging. When not being used, the container and liner should be closed and stored in a cool dry area protected from UV light.

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See Safety Data Sheet for Health & Safety Consideration