



# INTEGRAL<sup>\*</sup> 835

## Tie Layer Film

INTEGRAL 835 is a coextrusion of two different heat-sensitive adhesive resins. One resin bonds to such substrates as polypropylene, polystyrene, and PVC. The other resin bonds to polyethylene, urethane foam and fabrics. Thus, this film is particularly useful in bonding dissimilar substrates.

New experimental films are continually being developed. Please discuss your particular application needs with your Dow representative.

Heat activation point (inner): 215°F (102°C)  
 Heat activation point (outer): 190°F (87°C)  
 Yield: 208 sq ft/lb/mil (42.6 m<sup>2</sup>/kg/25 μm)  
 Available colors: Clear, blue  
 Gauge range: 2.0-6.0 mil (50-150 μm)  
 Width range: 14-63 in (355-1600 mm)

Physical Properties		Test Method	Imperial Values	Metric Values
Ultimate Tensile Strength	MD	ASTM D 882	3200 psi	22 N/mm <sup>2</sup>
	TD		2800 psi	19 N/mm <sup>2</sup>
2% Secant Modulus	MD	ASTM D 882	12,500 psi	86 N/mm <sup>2</sup>
	TD		13,000 psi	90 N/mm <sup>2</sup>
Ultimate Elongation	MD	ASTM D 882	400%	400%
	TD		500%	500%
Elmendorf Tear Strength	MD	ASTM D 1922	90 g/mil	4 g/μm
	TD		140 g/mil	6 g/μm
Peel Strength to Polystyrene Film		DOW <sup>(2)</sup>	2.7 lb/in width	4.7 N/cm width

(1) Values are averages of typical film; not to be construed as specifications.

(2) Heat seal testing at 300°F (149°C), 30 psi (0.21 MPa), 3 second dwell.

– See “Handling Considerations” reverse side

## Handling Considerations

Material Safety Data sheets for INTEGRAL Adhesive Films are available from The Dow Chemical Company to help customers/users further understand the proper handling of the product. A current MSD Sheet should be requested from your Dow sales representative prior to working with the product.

### Health & Safety

INTEGRAL Adhesive Films products present no unusual health hazards when used in their intended manner. Observe usual industrial safe handling practices. Protect workers from possible contact with hot or molten film. Assure workers of a fresh air supply by appropriate exhaust and ventilation of work areas, especially where film is located. Avoid breathing dusts if such are generated.

During manufacture, handling or use, most film webs will develop and retain a static electrical charge. The magnitude of the charge and how long it will be stored are dependent upon the composition of the web, the kind of handling, and the atmospheric conditions, particularly humidity. INTEGRAL Adhesive Films can discharge such stored electrical energy in the form of a spark, and therefore should not be handled in a flammable or explosive environment. Consult a current MSD sheet prior to working with the product.

### Combustion Characteristics

INTEGRAL Adhesive Films are made of organic ethylene polymers and therefore will burn under the right conditions of heat and oxygen supply. When burning, the product may contribute high fuel value. Normal precautions should be taken to avoid exposure to open flame and other ignition sources. Fires can be extinguished with water, carbon dioxide, or other conventional means, with water fog preferred. In enclosed areas, firefighters should use a self-contained breathing apparatus.

### Disposal

When burned in controlled industrial or municipal incinerators, these films will be consumed with very little resultant ash or smoke. The predominant products of combustion are carbon dioxide and water. If the incinerator is not designed to manage products having the high heat value of plastics, these films should be admixed (<10%) with low heat value waste so the combustion capacity of the incinerator is not exceeded.

When disposed of in a sanitary landfill, these films do not evolve gases or leachates known to pollute water resources. Because they do not provide a food source for bacteria, fungi, insects, or rodents, the films do not attract vermin or vectors in landfill disposal.

*In any disposal of wastes, be certain all applicable federal, state, and local regulations are met.*

### ISO 9000 Certification

The Engineered Films and Laminates business has well defined and documented quality systems at each site. The business has an established quality network with a business quality leader and plant quality coordinators to support maintenance of the quality systems. The quality systems at each site have been third party certified to the ISO 9002 standard. We will be applying for certification to ISO 9001:2000 in the near future. Operation of disciplined quality systems is extremely important to us. This is how we assure we can produce and deliver quality products and services that our customers expect.

### Packaging/Labeling/Traceability

Shipping container will be of sufficient strength and construction to ensure safe transportation to destination under normal shipping conditions.

Each roll and shipment will contain a lot number that is traceable through production records to input materials and process conditions. Material traceability will be according to current Good Manufacturing Practice (cGMP) guidelines in Dow North American facilities.

### cGMP

The films produced by The Dow Chemical Company in North America are produced in facilities that follow the Good Manufacturing Practices Guide for Bulk Pharmaceutical Excipient. This guide has been created by an international consortium to address the needs of Excipients. This product may be produced and sold in Europe, which does not require the adherence to the FDA Good Manufacturing Principles. Please contact the business product stewardship specialist if more details are needed.

### Product Stewardship

The Dow Chemical Company has a fundamental concern for all who make, distribute, and use its products, and for the environment in which we live. This concern is the basis of our product stewardship philosophy by which Dow assesses the health and environmental information on our products and then takes appropriate steps to protect employee and public health and the environment. The Dow product stewardship program rests with every individual involved with Dow products from initial concept and research to the manufacture, sale, distribution, and disposal of each product.

### Customer Notice

Dow encourages its customers and potential users of Dow products to review their applications for such products from the standpoint of human health and environmental quality. Dow personnel will assist customers in dealing with ecological and product safety considerations. Your Dow sales representative can arrange the proper contacts. Dow product literature, including Material Safety Data Sheets, should be consulted prior to the use of Dow products. These may be obtained from your Dow sales representative.

NOTICE: No freedom from any patent owned by Dow or others is to be inferred. Because use conditions and applicable laws may differ from one location to another and may change with time, Customer is responsible for determining whether products and the information in this document are appropriate for Customer's use and for ensuring that Customer's workplace and disposal practices are in compliance with applicable laws and other governmental enactments. Dow assumes no obligation or liability for the information in this document. NO WARRANTIES ARE GIVEN; ALL IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE ARE EXPRESSLY EXCLUDED.

Published August 2001

The Dow Chemical Company, 200 Larkin Center, Midland, MI 48674 USA  
1-800-441-4369 or 989-832-4569  
Dow Customer Information Group, Edegem, Belgium  
+800 3 694 6367\* or +32 3 450 2240  
Telefax: +32 3 450 2815

\*Toll free from Austria, Belgium, Denmark, Finland, France, Germany, Hungary, Ireland, Italy, The Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, and the United Kingdom.

