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(54) Title: ORIENTED COOK-IN FILM WITH GOOD INTERPLY ADHESION

(57) **Abrégé/Abstract:**

A multilayer film suitable for cook-in end use includes an outer layer that includes a homo- or co-polymer of propylene and, directly adhered to the outer layer, a layer that includes at least one of: (a) an ethylene/alkyl acrylate copolymer having a high melting point, (b) propylene/ α -olefin copolymer having a lower propylene mer content than the outer layer and having a high Vicat softening point, and (c) an ethylene/vinyl acetate copolymer with at least 15% vinyl acetate mer content. The film exhibits good seal strength and good adhesion between the two layers, even in areas where the film is sealed, even after the film is oriented, even when the film is subjected to the elevated temperatures involved in cook-in procedures, and even where the film is subjected to, e.g., grease from fatty foods. The film also can include one or more other layers including, for example, bulk layers, O₂- barrier layers, and/or abuse layers.



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(21) International Application Number: PCT/US00/08468 (22) International Filing Date: 30 March 2000 (30.03.00) (30) Priority Data: 09/281, 419 30 March 1999 (30.03.99) US (71) Applicant (for all designated States except US): CRYOVAC, INC. [US/US]; P.O. Box 464, 100 Rogers Bridge Rd., Duncan, SC 29334 (US). (72) Inventors; and (75) Inventors/Applicants (for US only): PIPER, Graham, Richard [US/US]; 1107 Half Mile Way, Greenville, SC 29609 (US). RAMESH, Ram, Kumar [IN/US]; 6 Rosebank Way, Greenville, SC 29615 (US). (74) Agents: HURLEY, Rupert, B., Jr. et al.; Cryovac Inc., 100 Rogers Bridge Rd., P.O. Box 464, Duncan, SC 29334 (US).		(81) Designated States: AE, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CR, CU, CZ, DE, DK, DM, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG). Published <i>With international search report.</i> <i>Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i>
(54) Title: ORIENTED COOK-IN FILM WITH GOOD INTERPLY ADHESION (57) Abstract A multilayer film suitable for cook-in end use includes an outer layer that includes a homo- or co-polymer of propylene and, directly adhered to the outer layer, a layer that includes at least one of: (a) an ethylene/alkyl acrylate copolymer having a high melting point, (b) propylene/ α -olefin copolymer having a lower propylene mer content than the outer layer and having a high Vicat softening point, and (c) an ethylene/vinyl acetate copolymer with at least 15% vinyl acetate mer content. The film exhibits good seal strength and good adhesion between the two layers, even in areas where the film is sealed, even after the film is oriented, even when the film is subjected to the elevated temperatures involved in cook-in procedures, and even where the film is subjected to, e.g., grease from fatty foods. The film also can include one or more other layers including, for example, bulk layers, O ₂ -barrier layers, and/or abuse layers.		

ORIENTED COOK-IN FILM WITH GOOD INTERPLY ADHESION

BACKGROUND INFORMATION

1. Field of the Invention

5 This invention relates generally to thermoplastic packaging materials and, more specifically, to flexible, multilayer films.

2. Background of the Invention

Many food products are processed in thermoplastic film packages by subjecting the packaged product to elevated temperatures produced by, for example, immersion in hot water
10 or exposure to steam. Such thermal processing often is referred to as cook-in, and films used in such processes are known as cook-in films.

A food product that is packaged and processed in this manner can be refrigerated, shipped, and stored until the food product is to be consumed or further processed by, for example, slicing and repackaging into smaller portions for retail display. Alternatively, the
15 processed food can be removed immediately from the cook-in package for consumption or further processing (e.g., sliced and repackaged).

A cook-in film must be capable of withstanding exposure to rather severe temperature conditions for extended periods of time while not compromising its ability to contain the food product. Cook-in processes typically involve a long cook cycle. Submersion in hot (i.e., about
20 55° to 65°C) water for up to about 4 hours is common; submersion in 70° to 100°C water or exposure to steam for up to 12 hours is not uncommon, although most cook-in procedures normally do not involve temperatures in excess of about 90°C. During such extended periods of time at elevated temperatures, any seams in a package formed from a cook-in film preferably resist failure (i.e., pulling apart).

25 Following the cook-in process, the film or package preferably conforms, if not completely then at least substantially, to the shape of the contained food product. Often, this is achieved by allowing the film to heat shrink under cook-in conditions so as to form a tightly fitting package. In other words, the cook-in film desirably possesses sufficient shrink energy such that the amount of thermal energy used to cook the food product
30 also is adequate to shrink the packaging film snugly around the contained product. Alternatively, the cook-in film package can be caused to shrink around the contained food product prior to initiating the cook-in procedure by, for example, placing the package in a heated environment prior to cooking.

Some cook-in applications impose some very stringent performance requirements on films for use therewith. For example, some food products that are processed via cook-in procedures are oxygen sensitive. Cook-in films for these products need to include one or more oxygen barrier layers. Other cook-in applications require that the film or the package made therefrom be printable and be able to retain any image printed thereon.

An increasingly important requirement of cook-in films is that they have good interply adhesion. This is complicated where a layer derived primarily from a homo- or co-polymer of propylene is to be adhered directly to a layer derived primarily from a homo- or co-polymer of ethylene. Although ethylene and propylene are homologues, polymers made from one tend not to adhere well to polymers made from the other. One attempt to counteract this tendency toward poor adhesion has involved blending a polymer including mer units derived from propylene and having a low Vicat softening point with a homo- or co-polymer of ethylene so as to increase the compatibility of the layer formed therefrom with the layer derived primarily from a homo- or co-polymer of propylene. However, even where such a film as made exhibits good interply adhesion, that same film can exhibit mediocre or even poor interply adhesion after it is oriented.

Further, when films of this type are sealed, the sealing process can induce delamination between the seal layer and the layer adjacent thereto. During the cooking process, these same two layers must provide the film with structural integrity and support the seal formed in the seal layer. Also, the seal layer needs to be able to resist the degenerative effects of grease and/or fatty products which often are encountered during cook-in processes. Thus, the need remains for an oriented film with good interply adhesion and sealability.

SUMMARY OF THE INVENTION

Briefly, the present invention provides an oriented multilayer film that includes at least two layers. One of these layers is an outer layer that includes a polymer including mer units derived from propylene. Directly adhered to this outer layer is a second layer including at least one member selected from the group consisting of ethylene/alkyl acrylate copolymer, propylene/ α -olefin copolymer having a propylene mer content less than that of the polymer in the first layer and a Vicat softening point of at least 50°C, and ethylene/vinyl acetate copolymer with at least 15 weight percent vinyl acetate mer content, wherein the ethylene/alkyl acrylate copolymer has a melting point at least about 3°C higher than a reference ethylene/alkyl acrylate copolymer, wherein said reference ethylene/alkyl acrylate copolymer has the same amount and type of alkyl acrylate and ethylene, and wherein said reference

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copolymer is made in a multi-zone autoclave reactor where the ratio of alkyl acrylate to ethylene in a reaction zone is about equal to the overall ethylene to alkyl acrylate ratio fed to the multi-zone autoclave reactor.

5 The film also can include one or more other layers such as, for example, bulk layers, O₂-barrier layers, and/or abuse layers.

 Articles made from the above-described film (e.g., bags and casings), methods of making the film, and methods
10 of using the film also are provided.

 Those of ordinary skill in the art recognize that polymers derived primarily from propylene and polymers derived primarily from ethylene tend not to adhere well to each other. Films including adjacent layers derived from these dissimilar
15 materials can have less-than-optimal adhesion, orientability, degraded optics, and/or gauge non-uniformities, perhaps due to differential stresses within the layers. Nevertheless, work leading to the film of the present invention has shown that layers including at least one of the foregoing co-polymers
20 have good bond strength with layers including a propylene homo- or co-polymer, that a film including such layers can have good optical characteristics, and that a film including such layers can have uniform gauge. In view of the fact that interply bond strength is known to decrease significantly as
25 molecular orientation increases (as occurs when a film is oriented), the good interply adhesion exhibited by the oriented film of the present invention is even further surprising.

 Furthermore, when the second layer includes a
30 propylene/ α -olefin copolymer having a propylene mer content less than that of the first layer, good interply adhesion is

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exhibited with the polypropylene-containing first layer. That the propylene/ α -olefin copolymer of the second layer also exhibits good adhesion to the adjacent polyethylene layer is surprising. That a propylene/ α -olefin copolymer can maintain
5 good interply adhesion with all adjacent layers, even while the film is undergoing orientation, also is surprising. Most surprising is that a second layer which includes a copolymer having a Vicat softening point significantly lower than the cook temperature can maintain good adhesion to adjacent layers
10 through cooking procedures at temperatures up to about 93°C.

In one specific aspect, the invention provides an oriented film suitable for cook-in, comprising: a) an outer layer which comprises an atactic or syndiotactic propylene copolymer; and b) directly adhered to said outer layer, a
15 second layer comprising a propylene/ α -olefin copolymer having a propylene mer content less than that of the propylene copolymer in the outer layer and a Vicat softening point of at least 50°C.

In a further specific aspect, the invention
20 provides a cook-in bag defining an inside of the bag and comprising a multiple layer film, comprising: an inside sealing layer comprising a propylene copolymer, wherein the inside sealing layer is adjacent the inside of the bag; and a second layer directly adhered to the inside sealing layer,
25 the second layer comprising an ethylene/alkyl acrylate copolymer selected from: i) ethylene/ethyl acrylate copolymer having a melting point satisfying the equation $MP \geq 120 - 1.03CM$, ii) ethylene/butyl acrylate copolymer having a melting point satisfying the equation $MP \geq 116 -$
30 $1.28CM$, and iii) ethylene/methyl acrylate copolymer having a melting point satisfying the equation $MP \geq 122 - 1.7CM$, wherein: MP is the melting point in °C; CM is the acrylate

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comonomer content in weight percent; the multilayer film is oriented and has a free shrink at 85°C of at least 5% in at least one direction; and the ethylene/alkyl acrylate of the second layer is crosslinked to the extent that the second
5 layer is not delaminated from the outer sealing layer after two hours submersion in water at 65°C.

To assist in understanding the more detailed description of the invention that follows, certain definitions are provided immediately below. These
10 definitions apply herein throughout unless a contrary intention is explicitly indicated:

"polymer" means the polymerization product of one or more monomers and is inclusive of homo-polymers as well as copolymers, terpolymers, tetrapolymers, etc., and blends and
15 modifications of any of the foregoing;

"mer unit" means that portion of a polymer derived from a single reactant molecule; for example, a mer unit from ethylene has the general formula $\text{—CH}_2\text{CH}_2\text{—}$;

"homopolymer" means a polymer consisting
20 essentially of a single type of repeating mer unit;

"copolymer" means a polymer that includes mer units derived from at least two reactants (normally monomers) and is inclusive of random, block, segmented, graft, etc.,
copolymers, as well as copolymers, terpolymers,
25 tetrapolymers, and the like;

"polyolefin" means a polymer in which some mer units are derived from an olefinic monomer which can be linear, branched, cyclic, aliphatic, aromatic, substituted, or unsubstituted (e.g., olefin homopolymers, copolymers of two or

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more olefins, copolymers of an olefin and a non-olefinic comonomer such as a vinyl monomer, and the like);

"(meth)acrylic acid" means acrylic acid and/or methacrylic acid;

5 "(meth)acrylate" means acrylate and/or methacrylate;

 "anhydride-grafted" means a group containing an anhydride moiety, such as that derived from maleic acid, fumaric acid, etc., has been chemically attached to or
10 affiliated with a given polymer;

 "permeance" (in the packaging industry, "permeance" often is referred to as "transmission rate") means the volume of a gas (e.g., O₂) that passes through a given cross section of film (or layer of a film) at a particular temperature and
15 relative humidity when measured according to a standard test such as, for example, ASTM D 1434 or D 3985;

 "longitudinal direction" means that direction along the length of a film, i.e., in the direction of the film as it is formed during extrusion and/or coating;

20 "transverse direction" means that direction across the film and perpendicular to the machine direction;

 "free shrink" means the percent dimensional change, as measured by ASTM D 2732, in a 10 cm x 10 cm specimen of film when subjected to heat;

25 "shrink tension" means the force per average cross-sectional area developed in a film, in a specified direction and at a specified elevated temperature, as the film attempts to shrink at that temperature while being restrained (measured in accordance with ASTM D 2838);

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as a verb, "laminate" means to affix or adhere (by means of, for example, adhesive bonding, pressure bonding, corona lamination, and the like) two or more separately

made film articles to one another so as to form a multilayer structure; as a noun, "laminate" means a product produced by the affixing or adhering just described;

"directly adhered," as applied to film layers, means adhesion of the subject film layer to the object film layer, without a tie layer, adhesive, or other layer therebetween;

5 "between," as applied to film layers, means that the subject layer is disposed in the midst of two object layers, regardless of whether the subject layer is directly adhered to the object layers or whether the subject layer is separated from the object layers by one or more additional layers;

10 "inner layer" means a layer of a film having each of its principal surfaces directly adhered to one other layer of the film;

"outer layer" means a layer of a film having less than both of its principal surfaces directly adhered to other layers of the film;

"inside layer" means the outer layer of a film in which a product is packaged that is closest, relative to the other layers of the film, to the packaged product;

15 "outside layer" means the outer layer of a film in which a product is packaged that is farthest, relative to the other layers of the film, from the packaged product;

"barrier layer" means a film layer with a low permeance toward one or more gases (e.g., O₂);

20 "abuse layer" means an outer layer and/or an inner layer that resists abrasion, puncture, and other potential causes of reduction of package integrity and/or appearance quality;

"tie layer" means an inner layer having the primary purpose of providing interlayer adhesion to adjacent layers that include otherwise non-adhering polymers;

25 "bulk layer" means any layer which has the purpose of increasing the abuse resistance, toughness, modulus, orientability, etc., of a multi-layer film and generally comprises polymers that are inexpensive relative to other polymers in the film;

"seal layer" (or "sealing layer" or "heat seal layer" or "sealant layer") means the outer layer(s) involved in the sealing of the film to itself, another layer of the same or another film, and/or another article which is not a film and

30 (a) with respect to packages with fin seals, the phrase generally refers to the inside layer, which frequently also serves as a food-contact layer in the packaging of foods (although, in a multi-layer film, the composition of the other layers within about 0.075 mm of the surface also can affect sealability and seal strength), or

(b) with respect to packages with lap seals, the phrase generally refers to both the inside and outside layers of the film.

as a noun, "seal" means a bond of a first region of a film surface to a second region of a film surface (or opposing film surfaces) created by heating (e.g., by means of a heated bar, hot wire, hot air, infrared radiation, ultrasonic sealing, etc.) the regions (or surfaces) to at least their respective softening points;

5 "corona treatment" or "corona discharge treatment" means a process in which one or both primary surfaces of a thermoplastic film are subjected to the ionization product of a gas (e.g., air) in close proximity with the film surface(s) so as to cause oxidation and/or other changes to the film surface(s); and

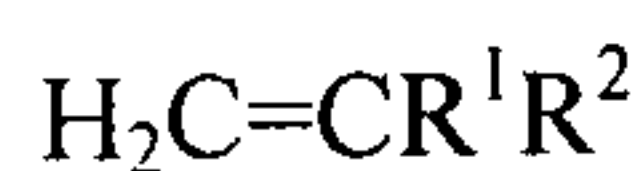
10 "cook" means to heat a food product thereby effecting a change in one or more of the physical or chemical properties thereof (e.g., color, texture, taste, and the like).

Some films, including many which are used in cook-in processes, are oriented prior to use. Orientation involves stretching a film at an elevated temperature (the orientation temperature) followed by setting the film in the stretched configuration (e.g., by cooling). When an unrestrained, non-annealed, oriented polymeric film subsequently is heated to its orientation
15 temperature, heat shrinkage occurs and the film returns almost completely to its original, i.e., pre-oriented, dimensions.

An oriented film has an orientation ratio, which is the multiplication product of the extent to which the film has been expanded in several directions, usually two directions perpendicular to one another. Expansion in the longitudinal direction, sometimes referred to as the machine
20 direction, occurs in the direction the film is formed during extrusion and/or coating. Expansion in the transverse direction means expansion across the width of the film and is perpendicular to the longitudinal direction.

DETAILED DESCRIPTION OF ILLUSTRATIVE EMBODIMENTS

25 The first (outer) layer of the multilayer film of the present invention includes a polymer that includes mer units derived from propylene. Preferably, this polymer includes mer units derived from one or more other monomers, most preferably from a monomer having a general formula



30 where, independently, R^1 is H or a $\text{C}_1\text{-C}_6$ alkyl group and R^2 is H, a $\text{C}_2\text{-C}_6$ alkyl group, or a $\text{C}(\text{O})\text{OR}^3$ group wherein R^3 is H or a $\text{C}_1\text{-C}_6$ alkyl group. Examples of preferred comonomers include $\text{C}_4\text{-C}_8$ α -olefins, ethylene, ethylenically unsaturated acids, and ethylenically unsaturated esters. Useful ethylenically unsaturated acids have the general formula $\text{CH}_2=\text{CRCOOH}$ where R is hydrogen or a $\text{C}_1\text{-C}_{15}$, preferably $\text{C}_1\text{-C}_{10}$, more preferably $\text{C}_1\text{-C}_5$

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alkyl, cycloalkyl, aryl, alkoxy, etc., group. The specific identity of the R group is unimportant as long as it does not interfere with the ability of the ethylenically unsaturated acid to polymerize with the propylene. A preferred ethylenically unsaturated acid is (meth)acrylic acid, with acrylic acid being particularly preferred. (Useful ethylenically unsaturated esters have the same general formula with the exception that the hydroxyl hydrogen atom is replaced by a C₁-C₆ alkyl group.) Preferred copolymers include propylene/C₄-C₈ α -olefin copolymer (particularly where the α -olefin comonomer is 1-butene, 1-hexene, or 1-octene, particularly 1-butene) and propylene/ethylene copolymer. In such copolymers, the mer content derived from propylene preferably is at least about 50%, more preferably at least about 75%, even more preferably at least about 80%, still more preferably at least about 90%, and most preferably at least about 95%.

The propylene copolymer in the outer layer preferably has a melting point of no more than about 155°C, more preferably no more than about 150°C, even more preferably no more than about 145°C, and most preferably no more than about 140°C. In certain preferred embodiments, the propylene copolymer has a melting point of from about 100°C to about 150°C, even more preferably of from about 110°C about 145°C. The propylene copolymer in the outer layer also preferably has a Vicat softening point of at least about 80°C, more preferably at least about 90°C, even more preferably at least about 100°C, yet more preferably at least about 105°C, still more preferably at least about 110°C, and most preferably at least about 115°C. The propylene copolymer can be isotactic, syndiotactic, or atactic.

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The propylene copolymer of the outer layer preferably has a melt index of from about 0.3 to about 50 g/10 min, more preferably of from about 1 to about 20 g/10 min, still more preferably of from about 2 to about 15 g/10 min, even more preferably of from about 3 to about 12 g/10 min, and still more preferably of from about 4 to about 10 g/10 min. Melt index is measured at 230°C according to the procedure set forth in ASTM D 1238.

The outer layer preferably includes at least about 20% (by wt.), more preferably at least about 50% (by wt.), even more preferably at least about 70% (by wt.), still more preferably at least about 80% (by wt.), and most preferably at least about 90% (by wt.) of the propylene copolymer. However, where desired to change or enhance the properties of the outer layer, the propylene copolymer can be blended with up to about 80% (by wt.), more preferably up to about 50% (by wt.), even more preferably up to about 30% (by wt.), still more preferably up to about 20% (by wt.), and most preferably up to about 10% (by wt.) of one or more other polymers. Useful blending polymers include, but are not limited to, polyolefins, polystyrene,

polyamides, polyesters, ethylene/vinyl alcohol copolymer (EVOH), polyvinylidene chloride (PVDC), polyether, polyurethane, polycarbonate, and the like. Preferred among these are those polymers that include mer units derived from ethylene, propylene, and 1-butene. In some instances, the outer layer preferably can include only those polymers containing mer units
5 derived from C₂-C₁₂ α-olefins, ethylenically unsaturated acids, and/or unsaturated esters.

The outer layer preferably has a thickness of from about 0.0025 to about 0.1 mm, more preferably from about 0.005 to about 0.04 mm, even more preferably from about 0.0075 to about 0.025 mm, and most preferably from about 0.01 to about 0.02 mm. Generally, the thickness of the outer layer is from about 1 to about 60%, preferably from about 5 to about 50%, more
10 preferably from about 10 to about 40%, even more preferably from about 12.5 to about 35%, and still more preferably from about 15 to about 30% of the total thickness of the multi-layer film.

The second layer mentioned previously includes at least one member selected from the group consisting of ethylene/alkyl acrylate copolymer, propylene/α-olefin copolymer having a propylene mer content less than that of the polymer in the first layer and a Vicat softening
15 point of at least 50°C, and ethylene/vinyl acetate copolymer with at least 15 percent vinyl acetate mer content, wherein the ethylene/alkyl acrylate copolymer has a melting point at least about 3°C higher than a reference ethylene/alkyl acrylate copolymer, wherein said reference ethylene/alkyl acrylate copolymer has the same amount and type of alkyl acrylate and ethylene, and wherein said reference copolymer is made in a multi-zone autoclave reactor where the
20 ratio of alkyl acrylate to ethylene in a reaction zone is about equal to the overall ethylene to alkyl acrylate ratio fed to the multi-zone autoclave reactor. Preferably, the ethylene/alkyl acrylate copolymers of the films of this invention are copolymers of ethylene and at least one member selected from the group consisting of ethyl acrylate, butyl acrylate, methyl acrylate and methyl methacrylate.

25 A preferred ethylene/ethyl acrylate copolymer of this invention has a melting point determined by the equation, melting point temperature (°C) ≥ 120 - 1.03CM, wherein "CM" is the acrylate comonomer content. More preferably, the ethylene/ethyl acrylate copolymer has a melting point temperature (°C) ≥ 121 - 1.03CM; more preferably, melting point (°C) ≥ 122 - 1.03CM; more preferably, melting point (°C) ≥ 123 - 1.03CM; and more preferably, melting
30 point (°C) ≥ 124 - 1.03CM.

A preferred ethylene/butyl acrylate copolymer of this invention has a melting point determined by the equation, melting point temperature (°C) ≥ 116 - 1.28CM, wherein "CM" is the acrylate comonomer content. More preferably, the ethylene/ethyl acrylate copolymer has a melting point temperature (°C) ≥ 117 - 1.28CM; more preferably, melting point (°C) ≥ 118 -

1.28CM; more preferably, melting point ($^{\circ}\text{C}$) $\geq 119 - 1.28\text{CM}$; and more preferably, melting point ($^{\circ}\text{C}$) $\geq 120 - 1.28\text{CM}$. Thus, a preferred copolymer of this invention made from ethylene and butyl acrylate mers, with a butyl acrylate mer content of 22%, would have a melting point greater than about 88°C [116 minus (1.28 times 22)].

5 A preferred ethylene/methyl acrylate copolymer of this invention has a melting point determined by the equation, melting point temperature ($^{\circ}\text{C}$) $\geq 122 - 1.7\text{CM}$, wherein "CM" is the acrylate comonomer content. More preferably, the ethylene/methyl acrylate copolymer has a melting point temperature ($^{\circ}\text{C}$) $\geq 123 - 1.7\text{CM}$; more preferably, melting point ($^{\circ}\text{C}$) $\geq 124 - 1.7\text{CM}$; more preferably, melting point ($^{\circ}\text{C}$) $\geq 125 - 1.7\text{CM}$; and more preferably, melting
10 point ($^{\circ}\text{C}$) $\geq 126 - 1.7\text{CM}$.

While the above equations generally apply to copolymers with two comonomers, they can also be used to determine preferred melting points for ethyl/alkyl acrylate copolymers with more than two monomers. While the preferred melting point of copolymers with more than two comonomers can be determined by a variety of means, one preferred approach is to use the
15 total acrylate comonomer content in the appropriate equations.

The ethylene/alkyl acrylate copolymer of the second layer preferably has a melt index of from about 0.3 to about 50 g/10 min, more preferably of from about 0.4 to about 20 g/10 min, still more preferably of from about 0.5 to about 10 g/10 min, even more preferably of from about 0.6 to about 5 g/10 min, and still more preferably of from about 0.7 to about 3 g/10 min
20 (measured in the same manner as described *supra*, but at a temperature of 190°C).

The ethylene/alkyl-acrylate copolymers used in the films of the present invention have lower Vicat softening points than conventional ethylene/alkyl acrylate copolymers. For example, a conventional ethylene/butyl acrylate copolymer with 20% of its mer units derived from butyl acrylate has a Vicat softening point of 60°C , whereas a preferred ethylene/butyl acrylate
25 copolymer used herein with 20% of its mer units derived from butyl acrylate has a Vicat softening point of only about 53°C . Although the ordinarily skilled artisan might expect this lower Vicat softening point to result in delamination during cook-in because the cook temperature is higher than the Vicat softening point, superior adhesion in oriented films has surprisingly been found. This is especially surprising for films used for cook-in end use.

30 Furthermore, one of ordinary skill in the art might also expect the lower Vicat softening point of the preferred ethylene/alkyl-acrylate copolymers to exhibit seal-induced delamination. Seal-induced delamination is the delamination of adjacent layers during or after the sealing process. It is believed that seal-induced delamination occurs because the heat from the sealing process melts the seal layer in the area being sealed, as well as any additional layers which

become molten or soft at the sealing temperature. Thus, if the layer adjacent the seal layer has a lower Vicat softening point than the seal layer, then this adjacent layer can decrease the interply bond between the seal layer and the adjacent layer. This is because the sealing process involves the application of heat, and also removal of the sealing element from the seal area while the seal is somewhat hot. If the layer adjacent the seal layer stays relatively molten or fluid-like while the sealing element is being removed, the seal layer may be pulled away from the adjacent layer by the retracting sealing element. While this delamination may not be readily apparent to the naked eye, it can be detected microscopically, and has been discovered to cause problems during cook-in. For example, this has been found to happen, especially with films of the prior art, which incorporate low Vicat softening point propylene/ethylene copolymer or ethylene/vinyl acetate copolymer with vinyl acetate mer content less than about 15%. Poor adhesion is further exacerbated by the cooking process, often resulting in delamination near or in the seal area, and/or seal failure. Thus, it is surprising that ethylene/alkyl acrylate copolymer with a relatively low Vicat softening point exhibits little or no seal-induced delamination or seal failure, even at cook temperatures as high as 93°C. Furthermore, although the higher melting point of these ethylene/alkyl acrylate copolymers might be expected to cause problems in orientation, no such problems have been found.

When EVA is used in the second layer, it preferably has at least 15% (by wt.), more preferably at least 16% (by wt.), even more preferably at least 17% (by wt.), and most preferably at least about 18% (by wt.) of its mer units derived from vinyl acetate. Further, such EVA preferably has a melt index of from about 0.3 to about 50 g/10 min, more preferably of from about 0.4 to about 20 g/10 min, still more preferably of from about 0.4 to about 10 g/10 min, even more preferably of from about 0.5 to about 5 g/10 min, and most preferably of from about 0.5 to about 2 g/10 min (measured in the same manner as described *supra*, but at a temperature of 190°C). Also, EVA used in the second layer preferably has a melt-point temperature of at least about 65°C, more preferably at least about 74°C, still more preferably at least about 79°C, and most preferably at least about 85°C. In addition, such EVA has a Vicat softening point of at least about 38°C, preferably at least about 52°C, more preferably at least about 63°C, even more preferably at least about 65°C, and most preferably at least about 68°C. Good interply adhesion can be achieved with EVA despite the chemical difference between the propylene mer in the polymer of the outer layer and the dissimilar ethylene mer content in the polymer of the second layer. Surprisingly, even with such a low Vicat softening point, EVA not only survives high temperature cooking processes, but also demonstrates good interply adhesion in oriented films.

Propylene/ α -olefin copolymers used in the second layer preferably have a Vicat softening point of at least about 50°C, more preferably at least about 65°C, even more preferably at least about 75°C and most preferably at least about 80°C. The propylene mer content of these polymers is less than that of the polymer used in the first layer, but at least about 25%. The melting point of these copolymers is lower than the melt-point temperature of the propylene copolymer of the outer layer by at least 3°C, more preferably by at least 6°C, still more preferably by at least 12°C, even more preferably by at least 20°C, and most preferably by at least 25°C. Preferably, the Vicat softening point of the propylene/ α -olefin copolymer of the second layer is less than the Vicat softening point of the propylene copolymer of the outer layer by at least 3°C, more preferably by at least 6°C, still more preferably by at least 12°C, even more preferably by at least 20°C, and most preferably by at least 25°C. Preferably, the propylene/ α -olefin copolymers used in the second layer have a propylene mer content between about 25% and about 95%. Preferably, the Vicat softening point of the propylene/ α -olefin copolymer of the second layer is less than about 125°C, more preferably, less than about 120°C, more preferably, less than about 115°C, more preferably, less than about 110°C, more preferably, less than about 105°C, more preferably, less than about 100°C.

The propylene/ α -olefin copolymers in the second layer have a propylene mer content less than that the propylene mer content of the propylene-mer-containing polymer in the first layer. Preferably, the propylene/ α -olefin copolymer in the second layer has a propylene mer content at least 2 percent less than the propylene mer content of the propylene-mer-containing polymer in the first layer; more preferably, at least 3 percent less; still more preferably, at least 5 percent less; still more preferably, at least 7 percent less; and yet still more preferably, at least 10 percent less. Preferably, the propylene/ α -olefin copolymers in the second layer have a propylene mer content of less than about 95%, more preferably, less than about 93%, more preferably, less than about 90%, more preferably, less than about 88%, more preferably, less than about 85%, and more preferably, less than about 80%. The utilization of the lower propylene mer content propylene copolymers in the second layer facilitates orientation.

The second layer also can include blends of the foregoing polymers. Given below are examples of preferred combinations in which letters are used to represent polymer constituents of blends

X, Y, Z, X+Y, X+Z, Y+Z, and X+Y+Z

wherein X represents ethylene/alkyl acrylate copolymers as described supra; Y represents EVA, as described supra; and Z represents propylene/ α -olefin copolymers, as described supra.

The second layer preferably includes at least about 10%, more preferably, at least about 20%, more preferably at least about 40%, still more preferably at least about 60%, even more preferably at least about 80%, and most preferably at least about 90% of X, Y, and/or Z. One preferred embodiment consists essentially of these polymers. Optional blending

5 polymers include, but are not limited to, polyolefins, polystyrene, polyamides, polyesters, EVOH, PVDC, polyether, polyurethane, polycarbonate, and the like. Preferred among these are those polymers that include mer units derived from ethylene, propylene, and 1-butene. In some instances, the second layer can include only those polymers containing mer units derived from C₂-C₁₂ α-olefins, ethylenically unsaturated acids, and/or unsaturated esters.

10 The second layer preferably has a thickness of from about 0.001 to about 0.1 mm, more preferably from about 0.0025 to about 0.025 mm, and most preferably from about 0.005 to about 0.018 mm. The thickness of the second layer preferably is from about 5 to about 50%, more preferably from about 10 to about 45%, even more preferably from about 12.5 to about 40%, still more preferably from about 15 to about 35%, yet more preferably from about 17 to about

15 25%, and most preferably from about 20 to about 25%, of the total thickness of the multilayer film.

The thickness of the outer layer which includes the propylene copolymer preferably is at least about 25%, more preferably at least about 50%, even more preferably at least about 75%, and even more preferably at least about 90%, and even more preferably at least about

20 100% of the thickness of the second layer.

The multilayer film according to the present invention also can include a layer having a low permeance to oxygen, preferably an oxygen permeance of no more than about (in ascending order of preference) 150 cm³/m²/atm/24 hours,

125 cm³/m²/atm/24 hours, 100 cm³/m²/atm/24 hours, 75 cm³/m²/atm/24 hours, 50

25 cm³/m²/atm/24 hours, 30 cm³/m²/atm/24 hours, 20 cm³/m²/atm/24 hours, and 10 cm³/m²/atm/24 hours. Such an O₂-barrier layer preferably has a thickness of from about 0.001 to about 0.05 mm, more preferably from about 0.00125 to about 0.0125 mm, even more preferably from about 0.002 to about 0.0075 mm, and most preferably from about 0.0025 to about 0.005 mm. The thickness of such a barrier layer preferably is from about 1 to about 60%, more preferably from about 2.5 to

30 about 50%, even more preferably from about 3 to about 40%, still more preferably from about 4 to about 30%, yet still more preferably from about 5 to about 25%, and most preferably from about 5 to about 15%, of the total thickness of the multilayer film. Such an O₂-barrier layer can include one or more of the following polymers: EVOH, PVDC, polyalkylene carbonate,

polyamide, and polyester; of the foregoing, EVOH having from about 32 to about 44 mole percent mer units derived from ethylene is particularly preferred.

The multilayer film of the present invention also can include one or more other layers, preferably from one to four additional layers. Such layer(s) can serve as inner or outer layers and
5 can be classified as bulk layers, abuse layers, etc. Such a layer can include one or more polymers that include mer units derived from at least one of a C₂-C₁₂ α-olefin, styrene, amides, esters, and urethanes. Preferred among these are those homo- and co-polymers that include mer units derived from ethylene, propylene, and 1-butene, even more preferably an ethylene copolymer such as, for example, ethylene/C₃-C₈ α-olefin copolymer, ethylene/ethylenically unsaturated ester
10 copolymer (e.g., ethylene/butyl acrylate copolymer), ethylene/ethylenically unsaturated acid copolymer (e.g., ethylene/(meth)acrylic acid copolymer), and ethylene/vinyl acetate copolymer. Preferred ethylene/vinyl acetate copolymers are those that include from about 2.5 to about 27.5% (by wt.), preferably from about 5 to about 20% (by wt.), even more preferably from about 5 to about 17.5% (by wt.) mer units derived from vinyl acetate. Such a polymer preferably has a melt
15 index of from about 0.3 to about 50, more preferably from about 0.5 to about 20, still more preferably from about 0.7 to about 10, even more preferably from about 0.9 to about 5, and most preferably from about 1 to about 3.

In one embodiment, the film of the present invention can include a layer derived, at least in part, from a polyester and/or a polyamide. This layer can be an inner or outer layer as desired.
20 Where a polyester is included, it preferably has a melting point of from about 130° to about 260°C, more preferably from about 150° to about 255°C, even more preferably from about 170° to about 250°C, still more preferably from about 180° to about 245°C, yet still more preferably from about 200° to about 240°C, and most preferably from about 210° to about 235°C. Examples of suitable polyesters include amorphous (co)polyesters, poly(ethylene/terephthalic acid), and poly(ethylene/naphthalate), although poly(ethylene/terephthalic acid)
25 with at least about 75 mole percent, more preferably at least about 80 mole percent, even more preferably at least about 85 mole percent, and most preferably at least about 90 mole percent of its mer units derived from terephthalic acid can be preferred for certain applications.

Where such a layer includes a polyamide, the polyamide can include one or more of
30 polyamide 6, polyamide 9, polyamide 10, polyamide 11, polyamide 12, polyamide 66, polyamide 610, polyamide 612, polyamide 6I, polyamide 6T, polyamide 69, copolymers made from any of the monomers used to make two or more of the foregoing homopolymers, and blends of any of the foregoing homo- and/or co-polymers. The polyamide preferably has a melting point of from about 130° to about 270°C, more preferably from about 135° to about

260°C, even more preferably from about 140° to about 250°C, still more preferably from about 160° to about 245°C, yet still more preferably from about 180° to about 240°C, and most preferably from about 190° to about 235°C.

Such layers preferably have a thickness of from about 0.0125 to about 1 mm, more preferably from about 0.025 to about 0.5 mm, and most preferably from about 0.05 to about 0.25 mm. The thickness preferably is from about 1 to about 70%, more preferably from about 5 to about 60%, even more preferably from about 10 to about 50%, still more preferably from about 15 to about 45%, and most preferably from about 25 to about 40% based on the total thickness of the multilayer film.

Where an O₂-barrier layer (described *supra*) and an additional layer as just described are included in a multilayer film according to the present invention, the O₂-barrier layer preferably is disposed between the second layer and the additional layer.

The multilayer film of the present invention also can include one or more tie layers. Such layers can have a relatively high degree of compatibility with polymers used in O₂-barrier layers (e.g., EVOH or polyamide) as well as with polymers used in other, non-barrier layers (e.g., polyolefins). When such a tie layer is present, it preferably is disposed on one or both primary sides of the O₂-barrier layer, more preferably directly adhered to one or both primary sides of the O₂-barrier layer. Such a tie layer can have a thickness of from about 0.00125 to about 0.05 mm, more preferably from about 0.0015 to about 0.025 mm, even more preferably from about 0.0025 to about 0.01 mm, and most preferably from about 0.003 to about 0.008 mm. Such tie layers can include one or more polymers that contain mer units derived from at least one of C₂-C₁₂ α-olefin, styrene, amide, ester, and urethane; more preferably a C₂ α-olefin; and more preferably, one or more of anhydride-grafted ethylene/α-olefin copolymer, anhydride-grafted ethylene/ethylenically unsaturated ester copolymer, and anhydride-grafted ethylene/ethylenically unsaturated acid copolymer.

Preferably, the film according to the present invention comprises a total of from 2 to 20 layers; more preferably, from 2 to 12 layers; more preferably, from 2 to 9 layers; more preferably, from 3 to 8 layers. Various combinations of layers can be used in the formation of a multilayer film according to the present invention. Given below are some examples of preferred combinations in which letters are used to represent film layers (although only 2- through 5-layer embodiments are provided here for illustrative purposes, more layers can be present):

A/B, A/B/A, A/B/C, A/B/D, A/B/E, A/B/C/D, A/B/C/E, A/B/E/E', A/B/D/E, A/B/D/C, A/B/C/B/A, A/B/C/D/A, A/B/E/B/A, A/B/C/D/E, A/B/C/E/D, A/B/D/C/D, A/B/D/C/E, A/B/D/E/C, A/B/D/E/E', A/B/E/C/E, A/B/E/C/D, A/B/E/D/D', A/B/E/D/E

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wherein

A represents a layer that includes a polymer including mer units derived from propylene (as described *supra* in the description of the first layer);

5 B represents a layer including at least one of X, Y, and Z (as described *supra*);

C represents a layer including a polymer having a low permeance to oxygen (as described *supra*);

10 D and D' represent layers including one or more polymers that include mer units derived from at least one of a C₂-C₁₂ α -olefin, styrene, amide, ester, and urethane; and

E and E' represent layers including a polyester or polyamide.

15 Of course, one or more tie layers can be used in any of the above structures. Additionally, adjacent layers have different compositions.

Regardless of the structure of the multilayer film of the present invention, one or more conventional packaging film additives can be included therein. Examples of additives
20 that can be incorporated include, but are not limited to, antiblocking agents, antifogging agents, slip agents, colorants, flavorings, antimicrobial agents, meat preservatives, and the like. (The ordinarily skilled artisan is aware of numerous examples of each of the foregoing.)
25 Where the multilayer film is to be processed at high speeds, inclusion of one or more antiblocking agents in and/or on one or both outer layers of the film structure can be preferred. Examples of useful antiblocking agents for certain applications are corn starch and ceramic microspheres.

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The multilayer film of the present invention preferably exhibits a sufficient Young's modulus so as to withstand normal handling and use conditions. It preferably has a Young's modulus of at least about 200 MPa, more
5 preferably at least about 230 MPa, even more preferably at least about 260 MPa, still more preferably at least about 300 MPa, yet still more preferably at least about 330 MPa, even further more preferably at least about 360 MPa, and most preferably at least about 400 MPa. (Young's modulus is
10 measured in accordance with ASTM D 882.)

The multilayer film of the present invention preferably exhibits a shrink tension in at least one direction of at least about 0.33 MPa, more preferably at least about 0.67 MPa. The film preferably exhibits a shrink
15 tension of from about 0.67 to about 3.5 MPa, more preferably from about 1 to about 3.3 MPa, even more preferably from about 1.25 to about 3.1 MPa, still more preferably from about 1.5 to about 3 MPa, yet still more preferably from about 1.6 to about 2.9 MPa, and most preferably from about
20 1.75 to about 2.75 MPa.

The multilayer film of the present invention preferably is heat shrinkable. More preferably, the film is biaxially oriented and heat shrinkable. At 85°C, it preferably has a total

free shrink of from about 5 to about 150%, more preferably from about 10 to about 125%, even more preferably from about 15 to about 100%, still more preferably from about 20 to about 90%, yet still more preferably from about 30 to about 85%, even further more preferably from about 35 to about 80%, yet further more preferably from about 40 to about 80%, and most preferably from about 45 to about 80%. Preferably, the multilayer film has a free shrink in at least one direction, at 85°C, of at least about 5%, more preferably, at least about 10%, more preferably, at least about 15%, more preferably, at least about 20%, more preferably, at least about 25%, and more preferably, at least about 30%.

In another preferred embodiment, the multilayer film of the present invention is oriented and then annealed to reduce the level of free shrink. The film can be annealed or heated to an elevated temperature either in-line with (and subsequent to) or off-line from (in a separate process) the orientation process. An annealing process which is in-line with the orientation process is preferred.

While any mechanism known to those of skill in the art can be used to transfer heat to the film of the invention so that it is heated to an elevated temperature, preferably, the heat-transfer mechanism is conduction or convection; more preferably, conduction. Preferably, the film of the present invention is heated to an elevated temperature by bringing it in contact with a heated surface or surfaces followed by cooling of the film. Another preferred heating means is infrared radiation.

Furthermore, the film can be annealed or heated to an elevated temperature while it is in the form of a relatively flat and collapsed film or when it is inflated or non-flat, the latter typically achieved by inflating the film with a fluid, preferably a gas such as air. The process of annealing or heat-setting of the oriented film of the present invention, wherein it is heated to an elevated temperature, can be conducted when the film is either constrained in the transverse direction or when it is unconstrained in the transverse direction. Optionally, the film may be constrained in the transverse direction by inflation with a fluid.

After annealing, the multilayer film preferably has a level of free shrink in at least one direction, at a temperature of 80°C, of less than about 40%; more preferably, less than about 35%; more preferably, less than about 30%; more preferably, less than about 28%; and even more preferably, less than about 25%.

The multilayer film of the present invention preferably is sequentially or bi-axially oriented (preferably at least about 2:1, more preferably at least about 2.5:1, and most preferably at least 3:1 in at least one direction), more preferably biaxially oriented. Orienting involves initially cooling an extruded film to a solid state (by, for example, cascading water or chilled

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air quenching) followed by reheating the film to within its orientation temperature range and stretching it. The stretching step can be accomplished in many ways such as by, for example, "blown bubble" or "tenter framing" techniques, both of which are well known to those skilled in the art. After being heated and stretched, the film is quenched rapidly while being maintained in its stretched configuration so as to set or lock in the oriented molecular configuration. An oriented film can be annealed to reduce or completely eliminate free shrink in one or more directions.

The measurement of optical properties of plastic films, including the measurement of total transmission, haze, clarity, and gloss, is discussed in detail in Pike, LeRoy, "Optical Properties of Packaging Materials", Journal of Plastic Film & Sheeting, vol. 9, no. 3, pp. 173-80 (July 1993). Specifically, haze is a measurement of the transmitted light scattered more than 2.5° from the axis of the incident light. It is measured with a meter similar to a total light transmission meter, with the exception that it contains a light trap to absorb light scattered less than 2.5° as well as regular transmitted light. It is common to measure the total transmitted light first by defeating the light trap and then setting the meter to 100. Then the light trap is allowed to absorb the light scattered less than 2.5° (plus regular transmitted light), and haze is read as a percentage of total transmitted light. Note that the denominator here is total transmitted light ($I_s + I_r$), not incident light (I_i), as in the measurement of total transmitted light.

The haze of a particular film is determined by analyzing it in accordance with 1990 Annual Book of ASTM Standards, section 8, vol. 08.01, ASTM D 1003, "Standard Test Method for Haze and Luminous Transmittance of Transparent

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Plastics", pp. 358-63. Haze results can be obtained using instrumentation such as, for example, an XL 211 HAZEGARD™ system, (Gardner/ Neotec Instrument Division; Silver Spring, Maryland), which requires a minimum sample size of about
5 6.5 cm².

The film of the present invention preferably has a haze of less than about 20%, more preferably of less than about 15%, even more preferably less than about 10%, still more preferably less than about 7.5%, and most preferably
10 less than about 5%.

As used herein, "thickness uniformity" refers to a percent value obtained from the formula

$$U_t = 100 - [(t_{\max} - t_{\min}) / t_{\max}] \times 100]$$

where U_t is thickness uniformity (calculated as a
15 percentage), $t_{\max}$ is the measured maximum thickness, and $t_{\min}$ is the measured minimum thickness. The maximum and minimum thicknesses are determined by taking a number of thickness measurements (e.g., 10) at regular distance intervals along the entirety of the transverse direction of a film sample,
20 recording the highest and lowest thickness values as the maximum and minimum thickness values, respectively, and computing the thickness uniformity (a percent value) using the formula above. A thickness uniformity of 100% represents a film with perfect uniformity, i.e., no
25 measurable differences in thickness. A film in which the film $t_{\min}$ is measured at 45% of the film $t_{\max}$ has a thickness uniformity of only 45%.

The multilayer film of the present invention preferably has a thickness uniformity of at least 30%, more
30 preferably at least 40%, even more preferably at least 50%, still more preferably at least 60%, yet still more

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preferably at least 70%, even further more preferably at least 80%, and most preferably at least 85%.

The multilayer film of the present invention can have any total thickness desired, so long as the film provides
5 the desired properties, e.g. optics, modulus, seal strength, etc., for the particular packaging operation in which the film is used. The multilayer film of the present invention preferably has a total thickness of from about 0.0075 to about 0.25 mm, more preferably from about 0.0125 to about
10 0.125 mm, more preferably from about 0.025 to about 0.1 mm, even more preferably from about 0.0375 to about 0.09 mm, and most preferably from about 0.045 to about 0.075 mm.

The multilayer film of the present invention can be irradiated and/or corona treated. The techniques involve
15 subjecting a film material to radiation such as corona discharge, plasma, flame, ultraviolet, X-ray, gamma ray, beta ray, and high energy electron treatment, any of which can alter the surface of the film and/or induce cross-linking between molecules of the polymers contained therein. The use
20 of ionizing radiation for crosslinking polymers present in a film structure is disclosed in U.S. Patent No. 4,064,296 (Bornstein et al.). Irradiation is believed to increase inter-ply adhesion by crosslinking the polymer(s) of the second layer, to improve the sealability of the film, to
25 reduce edge tear, and to give the film structural integrity and seal strength sufficient to better survive cook-in conditions. In general, the polymer(s) of the second layer have low Vicat softening points which may induce delamination during the cook-in process. Crosslinking is believed to
30 reduce the tendency of these polymers to soften during the cook cycle and to enhance interply bond strength.

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Radiation dosages are referred to herein in terms of the radiation unit "RAD", with one million RADS, also known as a megarad, being designated as "MR", or, in terms of the radiation unit kiloGray (kGy), with 10 kiloGray representing 1 MR, as is known to those of skill in the art. To produce crosslinking, the polymer is subjected to a suitable radiation dosage of high energy electrons, preferably using an electron accelerator, with a dosage level being determined by standard dosimetry methods. A suitable radiation dosage of high energy electrons is in the range of up to about 13-166 kGy, more preferably about 30-139 kGy, and still more preferably, 50-100 kGy. Preferably, irradiation is carried out by an electron accelerator and the dosage level is determined by standard dosimetry methods. However, other accelerators such as a Van de Graaff or resonating transformer may be used. The radiation is not limited to electrons from an accelerator since any ionizing radiation may be used. A preferred amount of radiation is dependent upon the film and its end use.

If desired or necessary to increase adhesion to an enclosed meat product, all or a portion of the film of the present invention can be corona and/or plasma treated. Corona/plasma treatment involves bringing a film material into the proximity of a gas (e.g., ambient air) which has been ionized. Various forms of plasma treatment known to those of ordinary skill in the art can be used to corona treat an outer surface of a thermoplastic film material. Exemplary techniques are described in, for example, U.S. Patent Nos. 4,120,716 (Bonet) and 4,879,430 (Hoffman). Regardless of whether or not the film of the present invention is corona treated, at least the inside (i.e., protein contact) layer thereof preferably has a surface energy of at least

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about 0.032 J/m², more preferably at least about 0.034 J/m², even more preferably at least about 0.036 J/m², still more preferably at least about 0.038 J/m², yet still more preferably at least about 0.040 J/m², even further more preferably at least about 0.042 J/m², and most preferably at least about 0.044 J/m².

In another embodiment, especially where the film of the present invention is to be used with whole muscle products, the food-contact layer preferably is relatively non-polar. In such applications, providing a food-contact layer with a low surface energy can be desirable so as to avoid pulling off chunks of the whole muscle product when the film is stripped from the product. In such instances, the surface energy of the layer in question preferably is less than about 0.034 J/m², more preferably less than about 0.032 J/m², and most preferably less than about 0.030 J/m².

The film of the present invention preferably can survive cooking for at least two hours, without undergoing delamination or seal failure, at about at least 65°C, more preferably at about at least 70°C, even more preferably at about at least 75°C, still more preferably at about at least 80°C, and most preferably at about at least 85°C. Preferably, the film of the present invention is capable of surviving cooking at the foregoing temperatures for at least about 3 hours, more preferably at least about 4 hours, more preferably, at least about 5 hours, more preferably, at least about 6 hours, more preferably, at least about 8 hours, and most preferably, at least about 12 hours. The product being cooked preferably is a meat though other food-products can also be cooked (e.g., soybean).

A bag can be made from the film of the present invention by sealing to itself the outer layer that includes

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20b

a propylene copolymer, whereby that layer becomes the inside layers of the bag. A bag so made can be an end-seal bag, a side-seal bag, an L-seal bag (i.e., sealed across the bottom and along one side with an open top), or a pouch (i.e.,
5 sealed on three sides with an open top). Additionally, lap seals can be employed.

The film of the present invention can be used to package a variety of products, although it optimally can be used to package proteinaceous food products, particularly
10 meat products, more particularly fatty foods. Examples of meat products that can be packaged include, but are not limited to, poultry (e.g., turkey or chicken breast), bologna, braunschweiger, beef, pork, and whole muscle products such as roast beef.

15 The food packaging just described can be done by first forming a bag or casing from the film (as described immediately above), introducing the product into the bag or casing, then sealing the open side of the bag or casing. Alternatively, the film of the present invention can be
20 wrapped substantially completely around the product and then heat sealed so as to form a package. Where such a bag or package is made from a heat shrinkable film according to the present invention, the film can shrink around the product when it is subjected to heat. Where the product being
25 packaged is a food product, it can be cooked by subjecting the entire bag, casing or package to an elevated temperature for a time sufficient to effectuate the degree of cooking desired.

Advantages of this invention are further
30 illustrated by the following examples. The particular materials and amounts thereof, as well as other conditions

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20c

and details, recited in these examples should not be used to unduly limit this invention.

EXAMPLES

Example 1

5 A coextruded multi-layer film in the form of a tube with a lay-flat width of about 9.5 cm was prepared. Film made from the tube had a structure as shown below (with the first layer being at the inside of the tube and the last layer being at the outside of the tube):

10 A / B / T / C / T / D

wherein

A was a 0.104 mm (4.1 mils) outer layer made from ELTEX™ P KS 409 propylene/ethylene copolymer with a propylene mer content of about 97% and a melting point of 134°C and a Vicat softening point of 120°C (Solvay Polymers; Brussels, Belgium);

5 B was a 0.102 mm (4.0 mils) layer made from 100% ELVAX™ 3165 EVA with 18% (by wt.) vinyl acetate mer content (E.I. DuPont de Nemours, of Wilmington, Delaware).

C was a 0.033 mm (1.3 mils) O₂-barrier layer made from EVAL™ LC-E105A ethylene/vinyl alcohol copolymer (Eval Co. of America; Lisle, Illinois);

10 D was a 0.165 mm (6.5 mils) layer made from a blend of 80% (by wt.) PE 5269T ethylene/vinyl acetate copolymer having a vinyl acetate mer content of 6.5% (Chevron Chemical Co.; Houston, Texas) and 20% (by wt.) FORTIFLEX™ T60-500-119 high density polyethylene (Solvay Polymers, Inc.; Deer Park, Texas); and

each T was a 0.030 mm (1.2 mils) tie layer made from TYMOR™ 1203 anhydride-grafted LLDPE (Morton International; Chicago, Illinois).

15 Each of the resins (or blend of resins in the case of layer D) were extruded separately between about 190° and about 260°C through an annular die heated to approximately 215°C. The resultant extruded multilayer tube was cooled with water and flattened.

20 The tube was passed through an oscillating beam of an electronic cross-linking unit, where it received a total dosage of about 105 kGy. After irradiation, the flattened tape was passed through hot water bath (held at a temperature of from about 96° to about 99°C) for about ½ a minute. The heated tube was inflated into a bubble (thus orienting it), whereupon it had a lay-flat width of about 28 cm and a total thickness of about 0.058 mm. The bubble was stable, and the optics and appearance of the film were good. When the film tubing was immersed in hot water (85°C) for about 10 seconds according to the method described in ASTM D 2732-83, it was
25 determined to have about 20% free shrinkage in the longitudinal direction and about 30% free shrinkage in the transverse direction.

The resulting tubing was converted to bags by sealing across the flattened tube with a heated seal bar. These bags were filled with water and 0.1% (by weight) mineral oil, and clipped at the other end to produce packages. The film layer that contacted the water-mineral
30 oil mixture contact layer was the layer denoted as A above.

The packages were cooked for 2 to 12 hours in a high humidity environment held at a temperature from about 82° to about 93°C. After cooling, the packages were evaluated for leaks. None of the seals were found to have failed. Visual and microscopic inspections of the packages revealed that the film had good interply adhesion, the film withstood the abuses of

heat sealing, the film and heat seal withstood the abuses of the high temperature high humidity environment, and the film and heat seal withstood chemical attack from the mineral oil.

(Microscopic inspections involved cutting the samples through the seal areas at several sites, then examining the cross sections with a standard microscope using a reflected light mode at
5 200× magnification.)

Example 2

A coextruded multi-layer film in the form of a tube with a lay-flat width of about 9.5 cm was prepared in the same manner as described in Example 1. The film had a structure as shown below (with the first layer being at the inside of the tube and the last layer being at the outside of
10 the tube):

$$A / B_1 / T / C / T / D$$

wherein

A, C, D, and T were the same as in Example 1, and

B₁ was a 0.102 mm (4.0 mils) layer including 30 (by wt.) TAFMER™ XR 107

15 propylene/α-olefin copolymer (Mitsui Plastics, Inc), and 70% (by wt.) SLX 9103

homogeneous ethylene/hexene/butene terpolymer having a density of 0.901 g/cm³ (Exxon

Chemical Co.; Baytown, TX). TAFMER™ XR 107 propylene/α-olefin copolymer has a

Vicat softening point of 91°C, and a propylene mer content of less than about 95 percent.

The tube was processed as described in Example 1 to produce an oriented film having the
20 same thickness and lay-flat width as the film in Example 1. This film was converted to bags, filled with water, sealed, and clipped to form a package. The packages were cooked for 2 to 12 hours in a high humidity environment held at a temperature of from about 82° to about 93°C. After cooling, the packages were evaluated for leaks. None of the seals were found to have failed. Visual inspection of the packages revealed that the film had good interply adhesion
25 that, the film withstood the abuses of heat sealing, and that the film and heat seal withstood the abuses of the high temperature high humidity environment.

Example 3

A coextruded multi-layer film in the form of a tube with a lay-flat width of about 9.5 cm was prepared in the same manner as described in Example 1. The film had a structure as shown
30 below (with the first layer being at the inside of the tube and the last layer being at the outside of the tube):

$$A / B_2 / T / C / T / D$$

wherein

A, C, D, and T were the same as in Example 1, and

B₂ was a 0.102 mm (4.0 mils) layer made from DS1134-70 ethylene/butyl-acrylate copolymer with 20% butyl acrylate mer content, a melting point of 96°C, and a Vicat softening point of 53°C (Chevron Chemical Co.).

5 The tube was processed as described in Example 1 to produce an oriented film having the same thickness and lay-flat width as the film in Example 1. This film was converted to bags, filled with a water-mineral oil mixture, sealed, and tested as in Example 1. None of the seals were found to have failed.

10 Example 3 illustrates the good performance of a film having a propylene/ethylene seal layer with a second layer containing an ethylene/butyl-acrylate copolymer. Based on the performance of ethylene/butyl-acrylate copolymer, it is believed that ethylene/ethyl acrylate copolymer and ethylene/methyl-acrylate copolymer are also operable in the multilayer cook-in film according to the present invention.

Comparative Example 1

15 Samples of commercially available bags were formed, filled, and subjected to the same high temperature and high humidity and exposure to mineral oil as described in Example 1. The second layer of these bags (corresponding to layer B, B₁, and B₂ in the films of Examples 1-3, respectively) included a blend of 70% ethylene/vinyl acetate copolymer having a 6.5% vinyl acetate mer content and 30% ethylene/propylene copolymer having a 20% propylene mer content. The ethylene/propylene copolymer softens at about room temperature. All the other
20 layers of the film had the same thicknesses, compositions, and positions as the films of Examples 1-3. Also, the thickness of the second layer of this film was the same as the thicknesses of the second layers in the film of Examples 1-3.

Bags of this type have been used for several years, especially for cooking meat products. In some applications, this type of sealed bag failed to contain the product when
25 subjected to high temperature and high humidity conditions as part of cooking due to seal failure. (Other types of failures observed included ruptured bag walls and pinhole leaks in the seals.)

Example 4: Cook-In

30 Cook tests were conducted on bags made from the films described in Examples 1-3 and compared to the results of identical cook tests on the commercial bags. Film tubing was heat sealed on one end, filled with a mixture of 0.1% mineral oil in water solution, clipped on the other end so as to form packages. Twenty-four of these packages were heated for three hours at about 93°C while 60 were heated for about 12 hours at about 82°C.

The results of these tests are compiled in Table 1 immediately below.

Table 1

Type of film used in bag	Percentage of failures – 93°C test	Percentage of failures – 82°C test
Ex. 1	0%	0%
Ex. 2	10%	0%
Ex. 3	0%	0%
Comparative 1	100%	60%

The data of Table 1 show that films in which the second layer (i.e., the layer adjacent
5 to the outer layer which includes a polymer including mer units derived from propylene)
includes at least one of X, Y, and Z survive cooking, have strong seals, and do not delaminate
when subjected to rigorous temperature and chemical conditions. This is in contrast to
commercially available films in which the second layer includes a 70/30 (by wt.) blend of
ethylene/vinyl acetate copolymer and ethylene/propylene copolymer, even though the
10 ethylene/propylene copolymer of the second layer adheres well with the propylene copolymer
used in the first layer.

Example 5: Peel Test

For the non-oriented tubes of Examples 1-3 and the oriented films made therefrom as
well as the material from Comparative Example 1, interply bond strength was evaluated. For
15 the tubes and films from Examples 1-3, it was not possible to initiate or sustain delamination at
the interface between the first and second layers (i.e., layers A and B).

The non-oriented material from Comparative Example 1 was delaminated only after
using a solvent to initiate the peel and only with great difficulty, i.e., by applying a force of
37.8 N. However, the oriented film from Comparative Example 1 was delaminated more easily
20 and peeled with a force of only 0.62 N.

This shows that a film according to the present invention retains its good interply
adhesion after orientation whereas previously available films, although having good interply
adhesion prior to orientation, have poor interply adhesion after orientation. It also shows that
oriented films have poorer inter-ply bond strength and that it is difficult to predict what level of
25 bond strength an oriented film will have as compared to the same structure in a non-oriented
film.

Comparative Example 2

A coextruded multilayer film in the form of a tube with a lay-flat width of about 9.5 cm
was prepared in the same manner as described in Example 1. The film had a structure as shown

below (with the first layer being at the inside of the tube and the last layer being at the outside of the tube):

$$A / B_3 / T / C / T / D$$

wherein

5 A, C, D, and T were the same as in Example 1, and

B_3 was a 0.102 mm (4.0 mils) layer made from 100% ESCORENE™ LD-705.15
ethylene/vinyl acetate copolymer with 13.3% vinyl acetate mer content, a 0.40 melt index,
and a density of 0.934 g/cm³ (Exxon Chemical Co.).

10 The tube was processed as described in Example 1 to produce an oriented film having the
same thickness and lay-flat width as the film of Example 1. This film was converted into bags,
five of which were filled with a water-mineral oil mixture, sealed, and tested as in Example 1.
Three of the sealed packages leaked due to failed seals when heated to about 93°C for about 2
hours.

15 This demonstrates that not all ethylene/vinyl acetate copolymers yield the desired
attributes of the film of the present invention. Instead, only those with at least 15 weight
percent mer units derived from vinyl acetate yield the desired results.

 Various modifications and alterations that do not depart from the scope and spirit of
this invention will become apparent to those skilled in the art. This invention is not to be
unduly limited to the illustrative embodiments set forth herein.

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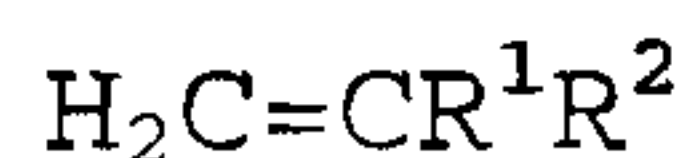
CLAIMS:

1. An oriented film suitable for cook-in, comprising:

a) an outer layer which comprises an atactic or syndiotactic propylene copolymer; and

5 b) directly adhered to said outer layer, a second layer comprising a propylene/ α -olefin copolymer having a propylene mer content less than that of the propylene copolymer in the outer layer and a Vicat softening point of at least 50°C.

10 2. The film of claim 1, wherein the propylene copolymer of the outer layer comprises:



as polymerized comonomer, wherein, independently:

R^1 is H or a C_1 - C_6 alkyl group, and

15 R^2 is H, a C_2 - C_6 alkyl group, or a $\text{C}(\text{O})\text{OR}^3$ group, wherein R^3 is H or a C_1 - C_6 alkyl group.

3. The film of claim 1 or 2, wherein the propylene copolymer of the outer layer has at least one of a melting point of no more than about 155°C and a Vicat softening point
20 of at least about 80°C.

4. The film of any one of claims 1 to 3, wherein the outer layer comprises at least about 80 weight % propylene copolymer.

5. The film of any one of claims 1 to 4, wherein the
25 second layer comprises a propylene/ C_2 - C_8 α -olefin copolymer.

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6. The film of any one of claims 1 to 5, wherein the second layer further comprises up to about 80 weight percent of one or more other polymers.

7. The film of any one of claims 1 to 6, further comprising a layer comprising a polymer selected from ethylene/vinyl alcohol copolymer and poly(vinylidene chloride).

8. The film of any one of claims 1 to 6, further comprising a layer comprising a polymer selected from polyalkylene carbonate, polyamide, and polyester.

9. The film of any one of claims 1 to 8, further comprising a third layer comprising a polymer selected from a C₂-C₁₂ α -olefin polymer, polystyrene, polyamide, polyester, and polyurethane.

10. The film of any one of claims 1 to 8, further comprising a third layer comprising a polymer selected from polyethylene, polypropylene, and poly(1-butene).

11. The film of any one of claims 1 to 8, further comprising a third layer comprising a polymer selected from a polyester and a polyamide.

12. The film of any one of claims 1 to 8, further comprising a third layer comprising a polymer selected from polyamide 6, polyamide 9, polyamide 10, polyamide 11, polyamide 12, polyamide 66, polyamide 610, polyamide 612, polyamide 6I, polyamide 6T, polyamide 69, and copolymers comprising as polymerized mer units the monomers involved in making any two or more of the foregoing polyamides.

13. The film of any one of claims 1 to 12, further comprising an abuse layer comprising a polymer selected from

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a C₂-C₁₂ α -olefin polymer, polystyrene, polyamide, polyester, and polyurethane.

14. The film of any one of claims 1 to 13, wherein the film has a free shrink at 85°C of at least 5% in at least
5 one direction.

15. The film of any one of claims 1 to 14, wherein the second layer comprises cross-linked polymer.

16. The film of any one of claims 1 to 15, wherein the propylene/ α -olefin copolymer has a melting point of less
10 than 120°C.

17. The film of claim 16, wherein the propylene/ α -olefin copolymer has a melting point of less than 115°C.

18. The film of any one of claims 1 to 17, wherein the propylene/ α -olefin copolymer has an α -olefin content of at
15 least 10 weight %.

19. The film of claim 18, wherein the propylene/ α -olefin copolymer has an α -olefin content of at least 12 weight %.

20. The film of claim 19, wherein the propylene/ α -olefin copolymer has an α -olefin content of at least
20 15 weight %.

21. The film of claim 20, wherein the propylene/ α -olefin copolymer has an α -olefin content of at least 20 weight %.

25 22. The film of any one of claims 1 to 21, wherein the film has a total free shrink at 85°C of from about 10% to about 125%.

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23. The film of claim 22, wherein the film has a total free shrink at 85°C of from about 20% to about 90%.

24. The film of any one of claims 1 to 23, wherein the film has a free shrink at 85°C in at least one direction of
5 at least about 15%.

25. The film of any one of claims 1 to 24, wherein the propylene/ α -olefin copolymer has a propylene mer content of less than 93 weight %.

26. The film of claim 25, wherein the propylene/
10 α -olefin copolymer has a propylene mer content of less than 88 weight %.

27. The film of any one of claims 1 to 26, wherein the melting point of the propylene/ α -olefin copolymer of the second layer is at least 3°C lower than the melting point of
15 the propylene copolymer of the outer layer.

28. A bag comprising the film of any of claims 1 to 27, wherein the outer layer of the film is sealed to itself so as to form a bag defining an inside and an outside of the bag, wherein the outer film layer is adjacent the inside of
20 the bag.

29. The bag of claim 28, wherein the bag is capable of withstanding cooking to a temperature of about 80°C for at least about 3 hours without undergoing seal failure.

30. A method of packaging a food product, comprising:
25 substantially completely surrounding the food product in the film of any of claims 1 to 27; and

sealing the film to itself to provide an enclosed food product.

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31. The method of claim 30, further comprising
subjecting the enclosed food product to an elevated
temperature sufficient to cook the enclosed food product.

32. A cook-in bag defining an inside of the bag and
5 comprising a multiple layer film, comprising:

an inside sealing layer comprising a propylene
copolymer, wherein the inside sealing layer is adjacent the
inside of the bag; and

a second layer directly adhered to the inside
10 sealing layer, the second layer comprising an ethylene/alkyl
acrylate copolymer selected from: i) ethylene/ethyl acrylate
copolymer having a melting point satisfying the equation
 $MP \geq 120 - 1.03CM$, ii) ethylene/butyl acrylate copolymer
having a melting point satisfying the equation
15 $MP \geq 116 - 1.28CM$, and iii) ethylene/methyl acrylate
copolymer having a melting point satisfying the equation
 $MP \geq 122 - 1.7CM$, wherein:

MP is the melting point in °C;

CM is the acrylate comonomer content in weight
20 percent;

the multilayer film is oriented and has a free
shrink at 85°C of at least 5% in at least one direction; and

the ethylene/alkyl acrylate of the second layer is
crosslinked to the extent that the second layer is not
25 delaminated from the outer sealing layer after two hours
submersion in water at 65°C.

33. The cook-in bag of claim 32, wherein the
ethylene/alkyl acrylate copolymer comprises ethylene/ethyl
acrylate copolymer.

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34. The cook-in bag of claim 32, wherein the ethylene/alkyl acrylate copolymer comprises ethylene/butyl acrylate copolymer.

35. The cook-in bag of claim 32, wherein the
5 ethylene/alkyl acrylate copolymer comprises ethylene/methyl acrylate copolymer.

36. The cook-in bag of claim 32, wherein the ethylene/alkyl acrylate copolymer comprises ethylene/ethyl acrylate copolymer having a melting point satisfying the
10 equation $MP \geq 122 - 1.03CM$.

37. The cook-in bag of claim 32, wherein the ethylene/alkyl acrylate copolymer comprises ethylene/butyl acrylate copolymer having a melting point satisfying the equation $MP \geq 118 - 1.28CM$.

15 38. The cook-in bag of claim 32, wherein the ethylene/alkyl acrylate copolymer comprises ethylene/methyl acrylate copolymer having a melting point satisfying the equation $MP \geq 124 - 1.7CM$.

39. The cook-in bag of any one of claims 32 to 38,
20 wherein the Vicat softening point of the ethylene/acrylate copolymer is less than the Vicat softening point of the propylene copolymer.

40. The cook-in bag of any one of claims 32 to 39,
25 wherein the propylene copolymer comprises isotactic propylene copolymer.

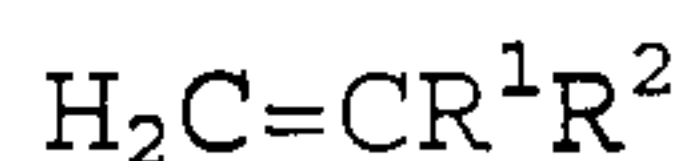
41. The cook-in bag of any one of claims 32 to 39,
wherein the propylene copolymer comprises syndiotactic propylene copolymer.

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42. The cook-in bag of any one of claims 32 to 39, wherein the propylene copolymer comprises atactic propylene copolymer.

43. The cook-in bag of any one of claims 32 to 42,
5 wherein the propylene copolymer of the inside sealing layer comprises:



as polymerized comonomer, wherein, independently:

R^1 is H or a C_1 - C_6 alkyl group, and

10 R^2 is H, a C_2 - C_6 alkyl group, or a $\text{C}(\text{O})\text{OR}^3$ group, wherein R^3 is H or a C_1 - C_6 alkyl group.

44. The cook-in bag of any one of claims 32 to 43, wherein the propylene copolymer of the inside sealing layer has at least one of a melting point of no more than about
15 155°C and a Vicat softening point of at least about 80°C .

45. The cook-in bag of any one of claims 32 to 44, wherein the inside sealing layer of the film comprises at least about 80% by weight of the propylene copolymer.

46. The cook-in bag of any one of claims 32 to 45,
20 wherein the second layer of the film further comprises up to about 80 weight percent of one or more other polymers.

47. The cook-in bag of any one of claims 32 to 46, wherein the film further comprises a barrier layer comprising a polymer selected from ethylene/vinyl alcohol
25 copolymer, poly(vinylidene chloride), polyalkylene carbonate, polyamide, and polyester.

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48. The cook-in bag of any one of claims 32 to 47, wherein the inside sealing layer is sealed to itself to form the bag.

49. The cook-in bag of any one of claims 32 to 47,
5 wherein:

the cook-in bag defines an outside and the multilayer film comprises an outside layer adjacent the outside of the bag; and

the inside sealing layer is sealed to the outside
10 layer to form the bag in a lap seal arrangement.

50. The cook-in bag of any one of claims 32 to 49, wherein the film has a total free shrink of from about 10% to about 125% at 85°C.

51. The cook-in bag of claim 50, wherein the film has
15 a total free shrink of from about 20% to about 90% at 85°C.

52. The cook-in bag of any one of claims 32 to 51, wherein the film has a free shrink in at least one direction of at least about 15% at 85°C.

53. The cook-in bag of any one of claims 32 to 52,
20 wherein the ethylene/alkyl acrylate of the second layer is crosslinked to the extent that the second layer is not delaminated from the inside sealing layer after two hours submersion in water at 80°C.

54. The cook-in bag of any one of claims 32 to 52,
25 wherein the ethylene/alkyl acrylate of the second layer is crosslinked to the extent that the second layer is not delaminated from the inside sealing layer after three hours submersion in water at 85°C.

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55. The cook-in bag of any one of claims 32 to 52, wherein the ethylene/alkyl acrylate of the second layer is crosslinked to the extent that the second layer is not delaminated from the inside sealing layer after three hours
5 submersion in water at 93°C.

56. The cook-in bag of any one of claims 32 to 55, wherein the second layer is not delaminated from the inside sealing layer after two hours submersion in water at 65°C and exposure to 37.8 N of peel force.

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