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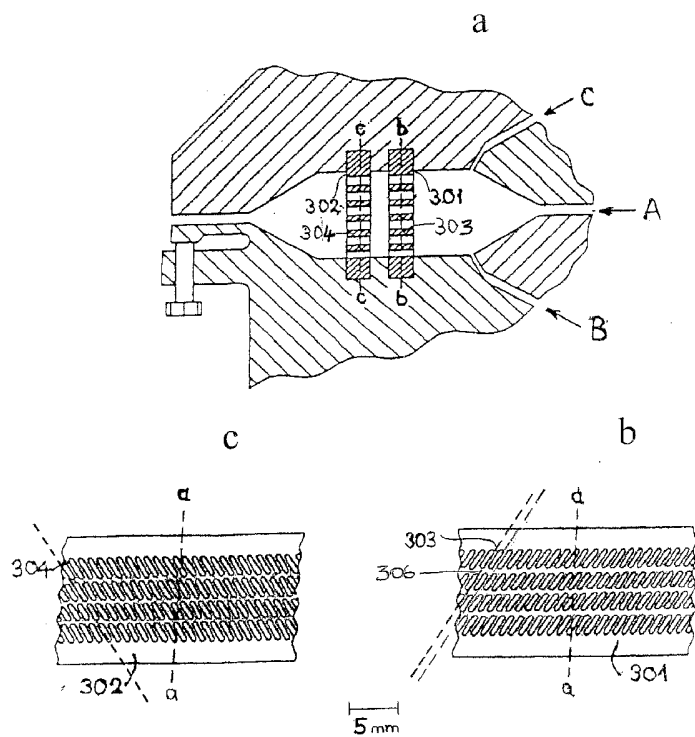
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(54) Title: IMPROVED METHOD OF MANUFACTURING AN ALLOYED FILM AND APPARATUS FOR THE METHOD



(57) Abstract: A method and apparatus for carrying out the method are for forming a sheet or film of thermoplastic polymer alloy by extruding an intimate blend of incompatible polymer materials, such as polypropylene dispersed in LLDPE, through an extrusion die and stretching after extrusion. In the die upstream from the exit is a grid chamber comprising one or more grids, the grid or grids having at least 4 (in the longitudinal sections perpendicular to the main surfaces of the flow) closely spaced lamellae (303) having walls extending several millimetres in the direction of the flow, which are interconnected (306) at intervals such that viewed in sections perpendicular to the direction of flow they form a network, the intervals being essentially longer than the distance between each pair of lamellae and between the lamellae apertures of a size selected to reduce the average size of the dispersed phase of P1 or P2 in the blend, the grid or grids being located at a position in the chamber where the gap is wider than the said exit gap, the grip chamber further comprising a gap reduction portion between the screen and the die exit wherein the gap through which the blend flows is reduced at least part way to the gap of the die exit. There may be two grids with parallel lamellae arranged so that the lamellae of the downstream grid are located mid-way between the lamellae of the



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upstream grid.

IMPROVED METHOD OF MANUFACTURING AN ALLOYED FILM AND APPARATUS FOR THE METHOD

The co-pending International Patent Application WO-A-2004094129 comprises a method of manufacturing an alloyed film consisting of flat
5 micro-fibrils of one or more polymer materials (P1) occluded in, as a matrix material, another polymer material (P2). A high degree of flatness of the fibrils in such morphology, i.e. average ratio between width and thickness, is of high importance for several purposes, especially when the aim is to achieve high barrier properties and the polymer or polymers P1 are selected for this purpose.
10 However, a high degree of fibril flatness can also be important for several other purposes, which shall be dealt with below.

The relevant method described and claimed in the above-mentioned co-pending International Patent Application comprises the steps of a method of forming a film or sheet of thermoplastic polymer alloy in which there is formed
15 an intimate blend of polymer material P1 and polymer material P2, the blend is extruded through a die and the extruded film is stretched after extrusion, in which the flow passage through the die comprises an exit orifice having an exit gap, characterised in that upstream from the exit orifice there is provided a grid chamber comprising one or more grids through which the blend passes, the grid
20 or grids having at least 4 (in the longitudinal sections perpendicular to the main surfaces of the flow) closely spaced lamellae having walls extending several millimetres in the direction of the flow and between the lamellae apertures of a size selected to reduce the average size of the dispersed phase of P1' or P2' in the blend, the grid or grids being located at a position in the chamber where
25 the gap is wider than the said exit gap, the grid chamber further comprising a gap reduction portion between the screen and the die exit wherein the gap through which the blend flows is reduced at least part way to the gap of the die exit.

The present invention is similarly characterised, but further characterised
30 in that said lamellae are interconnected at intervals such that viewed in sections

perpendicular to the direction of flow they form a network, the intervals being essentially longer than the distance between each pair of lamellae.

The present patent application has been filed prior to the publication of the above-mentioned International Patent Application.

5 The invention can be used for extrusion of flat as well as tubular film.

The passage of the flow of polymer-in-polymer dispersion between the array of lamellae in a grid divides the flow into flat, ribbon formed sub-flows, which unite again to one flow at the exit from the array of lamellae. During the passage between each pair of lamellae the particles of P1, which are occluded
10 in P2, will become sheared out to flat structures, which are highly elongated in the direction of flow, in other words to flat fibrils. In this respect each pair of lamellae acts similar to a narrow exit slot in a flat or annual extrusion die. There are two advantages of using the described grid-chamber instead of simply extruding the polymer dispersion out of a very narrow exit orifice, whereby it is
15 essential that each grid comprises at least 4 lamellae when viewed in a section parallel with the flow and perpendicular to the main boundaries of the flow, and which therefore in the same view divides the flow into at least 4 sub-flows. One advantage is that by use of such a grid chamber, in comparison with an exit orifice of normal, bigger gap, the back-pressure can be much lower for a given
20 throughput. The other advantage is that, in addition to the flattening which takes place while the sub-flows pass the lamellae, the fibrils are also essentially flattened after the grid or grids when the chamber narrows down towards at the exit of the die.

The use of a conventional screen at the end of an extrusion die is known,
25 see e.g. JP-A-85-110422, but does not help to increase the flatness of the particles in a passing polymer-in-polymer dispersion.

The special advantage of having the lamellae interconnected at intervals (which, in order not to disturb the desired morphology, are essentially longer than the distance between each pair of lamellae) is the mechanical stabilisation.
30 Thereby the thickness of the lamellae e.g. down to 0.5 mm or perhaps lower than this, and spacing between the latter can be made smaller, and/or the grid-chamber can be made higher, such that the number of lamellae (viewed in a

section parallel with the flow and perpendicular to the boundaries of the flow) can be optimised for the purpose of optimising the flatness of the fibrils.

Preferably the intervals between the connections between the lamellae are at least 2 times, more preferably at least 3 times, and still more preferably
5 between about 5 and 10 times as long as the distance between each pair or lamellae.

In one embodiment of the invention the lamellae are flat or slightly curved and are slanted in relation to the main boundaries of the flow as this enters the grid, forming angles between about 10 to about 70 degrees with
10 these boundaries. Preferably there are at least two such grids in series which are slanted in mutually different directions.

In another embodiment of the invention the lamellae are parallel with the main boundaries of the flow as this enters the grid and the connections on opposite sides of each lamellae are mutually displaced.

15 Interconnections link adjacent lamellae and preferably extend the entire thickness (e.g. 5-10mm) of the grid in order to create hollow channels through the grid running parallel to the flow of the polymer. In an alternative embodiment of the invention the interconnections do not extend the entire thickness of the grid and are merely provided at the upstream or downstream
20 ends of the grid, or in between these ends.

The grid can be manufactured by spark erosion of a metal sheet whereby the channels in between the lamellae and interconnecting units are removed from the sheet using electrical discharge. An alternative method of manufacture welds thin (e.g. less than 1mm) plates comprising cross sections of the grid
25 perpendicular to the main boundaries of flow, together with spacers to form a three-dimensional grid of desired thickness. The spacers may be welded to the plates, for example, only at the upstream or downstream ends of the grid or along its entire thickness to form complete channels.

The morphology of the extruded, and optionally further oriented film with
30 highly attenuated, very flat micro-fibrils, can provide cross laminates and slit film products with improved strength properties. Furthermore it can be used to manufacture films with a fine cellular, expanded structure. Finely extended,

very flat polypropylene microfibrils, alloyed into a film of linear low density polyethylene (LLDPE) can render a film highly oil resistant, while very flat polyamide microfibrils, also alloyed with LLDPE can do the same and further provide good barrier properties against oxygen. For manufacture of a barrier film, the flat microfibrils can alternatively consist e.g. of EVOH or vinylidene co-polymers.

It is of course important to control that the polymer, which due to its mechanical properties, barrier properties or other special properties is selected to be the P1 component, i.e. to form the flat, occluded fibrils (including fibril networks), actually becomes the P1 component and does not become the matrix material. In this connection the following guidelines can be given.

The lower the concentration of P1, the higher the probability that it will become the occluded phase (when other features are not changed).

The higher the melt viscosity of P1 is as compared to P2 - under the given conditions of melt attenuation - the higher the probability that P1 becomes the occluded phase (when other features are not changed). It is hereby noted that P1 undergoes an increase in melt viscosity near to its point of solidification, and the inventor has established some evidence indicating that slow cooling may convert a P2-in-P1 dispersion into a P1-in-P2 dispersion. It is also likely that such conversion can take place during the crystallization of P1. Preferably the weight proportion of P1 in the mixture is less than 75%, more preferably in the range 5 to 60%, for instance in the range 10 to 60%, most preferably in the range 20 to 50%.

However, when it is feasible it is advisable to obtain the P1-in-P2 occlusion by use of relatively high molecular weights for the polymer of P1 to give it a suitably high melt viscosity (e.g. a melt flow index of at least 0.1, preferably about 0.5), or by the use of relatively low concentrations of this component, then solidify both components by a quick cooling (as further described in WO-A-02/051617 so that the melt-attenuated structure becomes fixed, since a slow cooling seems to produce fibrils of more irregular shape and therefore of lower strength.

The lamellae will produce so-called "die-lines" in the final film. In case the lamellae are parallel with the main boundaries of the grid chamber, the die-lines will be parallel with the major film surfaces, and if the lamellae are slanted, die-lines will form a very small angle e.g. 1 degree or less, with the major film surfaces. During the passage of the sub-flows between the lamellae, the shear will be strongest in the immediate vicinity of each lamellae, and therefore the attenuation and flattening of the P1 fibrils is most pronounced in the die-lines. These die-lines therefore promote the effects of which the present invention claims, while a die-line in conventional extrusion technology is considered to be disadvantageous.

In order to promote the occurrence of such flat die-lines, an embodiment of the invention is characterised in that the grid chamber contains at least two grids S and T, S being directly upstream of T, and the grids are arranged such that each die-line in the flow formed by a lamella of grid S falls generally in the middle of the space between a pair or adjacent lamellae in grid T.

The advantages of arranging the lamellae in this mutually displaced manner is not limited to lamellae supplied with interconnections, but similarly applies to lamellae without such interconnections, and is also considered an inventive improvement in that case. In that case the lamellae in grids S and T should be parallel with one another.

In this aspect there is provided a method of forming a film or sheet of thermoplastic polymer alloy in which there is formed an intimate blend of polymer material P1 and polymer material P2, the blend is extruded through a die and the extruded film is stretched after extrusion in which the flow passage through the die comprises an exit orifice having an exit gap, characterised in that upstream from the exit orifice there is provided a grid chamber comprising one or more grids through which the blend passes, the grid or grids having at least 4 (in the longitudinal sections perpendicular to the main surfaces of the flow) closely spaced lamellae having walls extending several millimetres in the direction of the flow and, between the lamellae apertures of a size selected to reduce the average size of the dispersed phase of P1 or P2 in the blend, the grid or grids being located at a position in the chamber where the gap is wider

than the said exit gap, the grid chamber further comprising a gap reduction portion between the screen and the die exit wherein the gap through which the blend flows is reduced at least part way to the gap of the die exit, further characterised in that the grid chamber contains at least two grids S and T, S being directly upstream of T, and the grids are arranged such that each die-line in the flow formed by a lamella of grid S falls generally in the middle of the space between a pair or adjacent lamellae in grid T. This forms a further aspect of the invention. In this aspect the lamellae may be flat or slightly curved. The lamellae of the two grids should be generally parallel with each other in order that the dielines are as described formed along the length of the lamellae. The extend of any stent is a) described in connection with the first aspect of the invention.

The die-lines which reflect the pattern of the grid or grids, but in a flattened form, can normally be detected in the final film, e.g. by treating a cross-section of the film with a solvent which dissolves P2 but not P1, and subsequently studying sections of the film in suitably high magnifications by scan electron microscopy. As an example, if P1 is polypropylene and P2 is LLDPE, 30 minutes treatment with xylene at 90°C will develop the fibrillar structure which shows the die-lines.

The invention also comprises the apparatus suited for carrying out the described method in its different embodiments as defined in claims 16 to 25.

Apparatus suitable for carrying out the second aspect of the invention for extruding thermoplastic material to form a film or sheet comprises a die having an exit orifice through which the molten material flows and stretching means for stretching the material after it is extruded characterised in that there is provided a grid chamber upstream from the exit orifice comprising two or more grids through which the extrudate passes, the grid or grids being located at a position in the chamber where the gap is wider than said exit orifice gap, the grid chamber further comprising a gap reduction portion between the grid or grids and the die exit wherein the gap is reduced at least part way to the gap of the exit orifice and is further characterised in that the said at least two grids, S and T, S being directly upstream of T, are arranged such that each die-line in the

flow formed by a lamella of grid S falls generally in the middle of the space between a pair or adjacent lamellae in grid T.

An embodiment of the invention is characterised by the following features: P1 and P2 are incompatible to such an extent that they exist as separate phases in the final film, but are compatibilised sufficiently for practical purposes either by use of an alloying agent or mechanically by sufficient mixing and attenuation, and P2 in its unoriented state at 20°C exhibits a coefficient of elasticity (E) which is at least 15% lower than E of P1. Preferably but not necessarily the mechanically determined melting point of P1 is at least about 20°C higher than that of P2. By adaptations of rheological conditions, percentages of the components, and conditions for mixing and attenuation, the alloy is formed substantially as a dispersion of microscopically fine fibrils or fibril network of P1 surrounded by P2, whereby each fibril extends mainly in one direction and generally has a thickness around or lower than 5 µm, preferably around or lower than 1 µm, and still more preferably around or lower than 0.1 µm and width at least 5 times its thickness, more preferable at least 10 times or even 20 times its thickness. Furthermore the film is preferably stretched after at least P1 has been solidified.

By a random blending technique (as the blending always will be carried out in practice) to form microscopically or submicroscopically fine fibrils of one polymer occluded in another polymer as matrix, it will always be impossible to give the fibrils cross sectional dimensions which are even along their width, since the fibrils disturb each other's regularity, except if their concentration in the matrix is very low. This and irregularities caused by the crystallisation of the very fine fibrils has a negative influence on the strength of the resultant film. However, in very flat fibrils these effects are to some extent evened out, especially when the alloy has been rapidly cooled, and therefore the present invention in itself presents an advantage relating to the strength of the produced film, and of tape or cross laminates made from this film.

In this use of the invention, a step of the stretching after solidification may be transverse to the direction of the fibrils. Preferably the film is then allowed to contract in the direction of the fibrils during this stretching. The

possibilities for contraction can be established by a preceding fine transverse pleating of the film. This step of stretching transverse to the direction of the fibrils can also be preceded by stretching in the direction of the fibrils while the latter are solid.

5 As regards to the choice of polymers for this strength promoting use of the invention, P1 can e.g. consist of propylene polymers including crystalline copolymers of propylene or propylene homopolymer, or polyamide, or polyethylene terephthalate, and P2 can e.g. mainly consist of a propylene
10 copolymer, or ethylene polymer including copolymers of ethylene, preferably with other alpha-olefins, P2 preferably comprising linear low density polyethylene.

In another embodiment of the invention, which has been mentioned above, P1 is chosen to exhibit desirable barrier properties. This use is further characterised by the following features:

15 P1 and P2 are incompatible to such an extent that they exist as separate phases in the final film, but are compatibilised sufficiently for practical purposes either by use of an alloying agent or mechanically by sufficient mixing and attenuation. By adaptations of rheological conditions, percentages of the components, and conditions for mixing and attenuation, the alloy is formed
20 substantially as a dispersion of microscopically fine fibrils or fibril network of P1 surrounded by P2, whereby each fibril generally extends in one main direction and generally has a thickness around or lower than 5µm, preferably around or lower than 1µm, and a width at least 5 times its thickness, preferably 10 and more preferably at least 20 times its thickness.

25 It is well known that flake-shaped particles, e.g. mica powder exerts a barrier effect, since it forces the penetrating molecules of gas, aroma substance, or harming liquid to diffuse like in a labyrinth. However, such flake shaped particles will normally have a negative influence on the strength of the film unless its concentration and therefore effect is low. Normally barrier
30 properties therefore are achieved by coextrusion, including optionally coextrusion of tie layers, together with the main layer of the film. When two heatseal layers also are required, the die must normally be constructed for no

less than 6 layers, or in case 2 barrier layers are needed, for 9 layers. Such dies are commercially available but expensive. Under use of the invention, one, two or more barrier forming polymers, P1a, P1b etc, can be alloyed with the main polymer P2 without any use of the expensive tie-polymers. If special surface layers for heatsealing are not required this means that a simple 1-
5 component die is sufficient when additionally supplied with the described grid chamber. If surface layers for heatsealing are required, a 3-layer coextrusion die is needed, but in any case the saving in investment is very important. The barrier effect may not be quite as high as achieved with the expensive dies, but
10 good enough for many purposes. Examples of applicable barrier polymers:

Polypropylene or polyethylene terephthalate can protect cross laminates, which mainly are based on polyethylene, against destruction by oil; nylon 6 or 66 can do the same and also form a barrier against oxygen, while EVOH and co-polymers of vinylidene chloride very efficiently can form a barrier against
15 oxygen, oil and most aroma substances.

Finally, as already mentioned the method according to the second aspect of the invention can with advantage be used to make film with a fine cellular, expanded structure, especially for conversion to tape or cross laminates. This use is characterised by the following features:

20 P1 and P2 are incompatible to such an extent that they exist as separate phases in the final film, but are compatibilized sufficiently for practical purposes either by use of an alloying agent or mechanically by sufficient mixing and attenuation.

By adaptations of rheological conditions, percentages of the components, and conditions for mixing and attenuation the alloy is formed substantially as a
25 dispersion of microscopically fine fibrils or fibril network of P1 surrounded by P2, whereby each fibril extends mainly in one direction and generally has a thickness around or lower than 5 μm , preferably around or lower than 1 μm and width at least 5 times its thickness, preferably at least 10 or even 20 times its
30 thickness. There is added an expansion agent prior to or during the extrusion, which agent is soluble in P2 but generally not in P1, whereby expansion is established after the extrusion step.

Since the expansion agent is generally not soluble in P1, the fibrils act as barriers to the expansion agent, thereby they strongly promote an efficient and fine expansion. The film (or tapes made by slitting of the film) may additionally be strongly oriented prior to, during, or after the expansion, and they may be converted to split fibre networks e.g. by rubbing action.

The invention shall now be explained in further detail with reference to the drawings.

Figure 1a shows the exit of a co-extrusion die according to the invention, which may be flat or circular, supplied with two grid-formed screens for the purpose of making the fibrillar dispersion finer and the fibrils pronouncedly flat. The sketch represents a section through a-a in Fig. 1b.

Figure 1b shows a section through b-b in Fig. 1a, and similarly Fig. 1c shows a section through c-c in Fig. 1a. In the case of a circular die these Figures show folded-out circular sections.

Figure 2 shows an alternative pattern of the grid structure, likewise in a section perpendicular to the direction of flow.

An appropriate scale is shown on the sheet of drawings.

In Figs. 1a, b and c the major flow in the die which comprises a dispersion of P1 in P2 expands, e.g. from a thickness of about 2.5 mm to a thickness of about 20 mm, and is then coextruded with two minor surface layers which are selected for instance for improvement of bonding, heat-seal properties and/or frictional properties.

The composite flow of the 3 layers in the 20mm deep grid chamber passes the two grid-like screens (301) and (302), each a few mm thick (e.g. 5-10 mm) portions of which are shown in figs. 1b and 1c respectively. Each comprises an array of lamellae (303) and (304) each e.g. about 1 mm thick, and spaced e.g. about 1 mm from each other. The lamellae are joined by interconnections (306). Screens (301) and (302) are mirror images of each other so that the flow is sheared most efficiently as it passes.

Immediately following screen (302) the flow is compressed to a thickness, e.g. 2.5 mm which is convenient for its exit from the coextrusion die. Hereby the polymer-in-polymer dispersion becomes further attenuated to form

the desired final cross-sectional dimensions of each fibril, and at the same time the die-lines formed by the lamellae (303) and (304) are flattened. With the mentioned dimensions in the die, and the shown angle of slanting of the lamellae, the die-lines and the flat fibrils will form an angle of about 8° to the main surfaces of the film at the exit from the die. The subsequent stretching processes will usually bring the angle down to around 1° or less. These die-lines can normally be detected in the final film, as explained in the foregoing, the pattern of die-lines in a cross-section of the film is a flattened picture of the grid.

10 In Fig. 2, the lamellae (305) are not slanted but parallel with the main surfaces of the chamber. The connections (307 and 308) between the lamellae are mutually displaced to avoid directly die-lines going through the film.

CLAIMS

1. A method of forming a film or sheet of thermoplastic polymer alloy in which there is formed an intimate blend of polymer material P1 and polymer material P2, the blend is extruded through a die and the extruded film is stretched after extrusion in which the flow passage through the die comprises an exit orifice having an exit gap, characterised in that upstream from the exit orifice there is provided a grid chamber comprising one or more grids through which the blend passes, the grid or grids having at least 4 (in the longitudinal sections perpendicular to the main surfaces of the flow) closely spaced lamellae having walls extending several millimetres in the direction of the flow, which are interconnected at intervals such that viewed in sections perpendicular to the direction of flow they form a network, the intervals being essentially longer than the distance between each pair of lamellae and, between the lamellae apertures of a size selected to reduce the average size of the dispersed phase of P1 or P2 in the blend, the grid or grids being located at a position in the chamber where the gap is wider than the said exit gap, the grid chamber further comprising a gap reduction portion between the screen and the die exit wherein the gap through which the blend flows is reduced at least part way to the gap of the die exit.
2. A method according to claim 1, characterised in that the said intervals are at least 2 times, preferably at least 3 times, and more preferably at least 5 times as long as the distance between each pair of lamellae.
3. A method according to claim 1, characterised in that the lamellae are flat or slightly curved and are slanted in relation to the main boundaries of the flow as this enters the grid, forming angles between about 10 to about 70 degrees with these boundaries.
4. A method according to claim 3, characterised in that there are at least two such grids which are slanted in mutually different directions.
5. A method according to claim 1, characterised in that the lamellae are parallel with the main boundaries of the flow as this enters the grid and the connections on opposite sides of each lamellae are mutually displaced.

6. A method according to claim 1, characterised in that the grid chamber contains at least two such grids S and T, S being directly upstream of T, said grids being arranged such that each die-line in the flow formed by a lamellae of grid S falls generally in the middle of the space between a pair or adjacent lamellae in grid T.

7. A method according to any preceding claim in which P1 is present in the blend in an amount of 5 to 75%, preferably 10 to 60%, more preferably 20 to 5%, by weight.

8. A method according to any preceding claim in which P1 has a MFI of at least 0.1, preferably about 0.5.

9. A method according to any preceding claim in which P1 is selected from propylene (co)polymers, polyamides, ethylene-vinyl alcohol copolymers, vinylidene (co)polymers and polyesters, and P2 comprises predominantly olefin polymers.

10. A method according to claim 9 in which P2 is a propylene (co)polymer or an ethylene (co)polymer.

11. A method according to any preceding claim in which P2 in its unoriented state at 20°C exhibits a coefficient of elasticity (E) which is at least 15% lower than E of P1.

12. A method according to any preceding claim in which one or more materials are coextruded through the die on one or both surfaces of the polymer alloy.

13. A method according to claim 12 in which the coextruded material forms a heat seal layer on one or each surface of the film or sheet.

14. A method according to any preceding claim in which the stretching of the film after extension is carried out after cooling the film to a temperature at which at least P1 has solidified.

15. A method according to claim 14 in which the stretching is transverse to the direction of the fibrils of P1, preferably while the film is allowed to contract in the direction of the fibrils.

16. Apparatus for extruding thermoplastic material to form a film or sheet comprising a die having an exit orifice through which the molten material

flows and stretching means for stretching the material after it is extruded, characterised in that there is provided a grid chamber upstream from the exit orifice comprising one (301) or more (302) grids through which the extrudate passes, the grid or grids being located at a position in the chamber where the gap is wider than said exit orifice gap, the grid chamber further comprising a gap reduction portion between the grid or grids and the die exit wherein the gap is reduced at least part way to the gap of the exit orifice, the grid or grids having at least 4 (in the longitudinal sections perpendicular to the main surfaces of the flow) closely spaced lamellae (303) having walls extending several millimetres in the direction of the flow, which are interconnected (306) at intervals such that viewed in sections perpendicular to the direction of flow they form a network, the intervals being essentially longer than the distance between each pair of lamellae.

17. Apparatus according to claim 16 characterised in that the said intervals are at least 2 times, preferably at least 3 times, and more preferably at least 5 times as long as the distance between each pair of lamellae.

18. Apparatus according to claim 16 characterised in that the lamellae are flat or slightly curved and are slanted in relation to the main boundaries of the flow as this enters the grid, forming angles between about 10 to about 70 degrees with these boundaries.

19. Apparatus according to claim 18 characterised in that there are at least two such grids which are slanted in mutually different directions.

20. Apparatus according to claim 16 characterised in that the lamellae are parallel with the main boundaries of the flow as this enters the grid and the connections on opposite sides of each lamellae are mutually displaced.

21. Apparatus according to claim 16 characterised in that the grid chamber contains at least two such grids S and T, S being directly upstream of T, said grids being arranged such that each lamella in the downstream grid T is located mid-way between a pair of adjacent lamellae of the upstream grid S in a direction perpendicular to the flow of extrudate.

22. Apparatus according to claim 16 in which the die includes means for coextruding a second thermoplastic material to form a layer on one or each surface of the first thermoplastic material.

23. Apparatus according to claim 16 in which the stretching means
5 stretch the film or sheet in the machine direction.

24. Apparatus according to claim 16 in which the stretching means include means for allowing contraction of the film transverse to the direction of stretching.

25. Apparatus according to claim 16 which includes cooling means
10 between the exit orifice and the stretching means.

Fig. 1a.

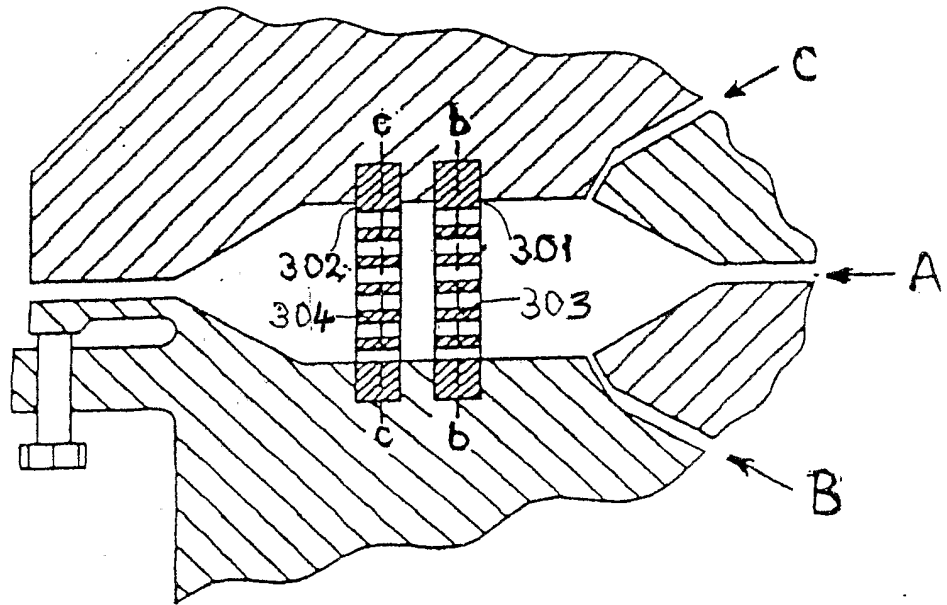


Fig. 1c.

Fig. 1b.

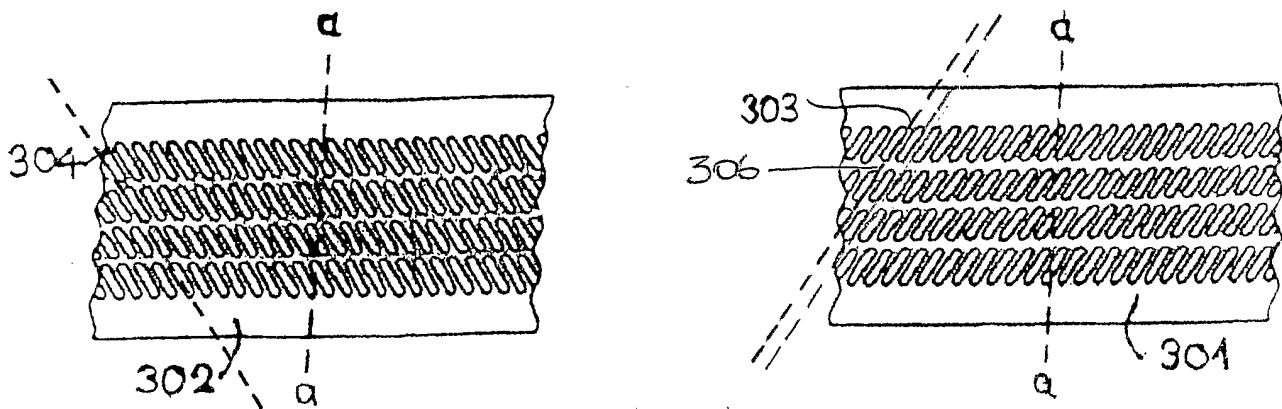
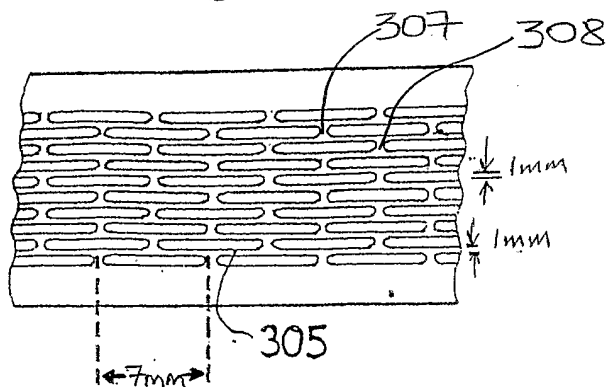


Fig. 2



INTERNATIONAL SEARCH REPORT

International application No
.../EP2005/012184A. CLASSIFICATION OF SUBJECT MATTER
B29C47/36 . B29C47/14

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
B29C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	EP 0 337 719 A (JSP CORPORATION) 18 October 1989 (1989-10-18) page 3, line 28 - line 56; figures 1-4	1-25
A	PATENT ABSTRACTS OF JAPAN vol. 006, no. 204 (M-164), 15 October 1982 (1982-10-15) -& JP 57 110422 A (SEKISUI KASEIHIN KOGYO KK), 9 July 1982 (1982-07-09) cited in the application abstract; figures	1-25
P,A	WO 2004/094129 A (RASMUSSEN, OLE-BENDT) 4 November 2004 (2004-11-04) cited in the application claims 32,73; figures 3a-c	1-25

 Further documents are listed in the continuation of Box C. See patent family annex.

* Special categories of cited documents :

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- *&* document member of the same patent family

Date of the actual completion of the international search

14 February 2006

Date of mailing of the international search report

20/02/2006

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No
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