

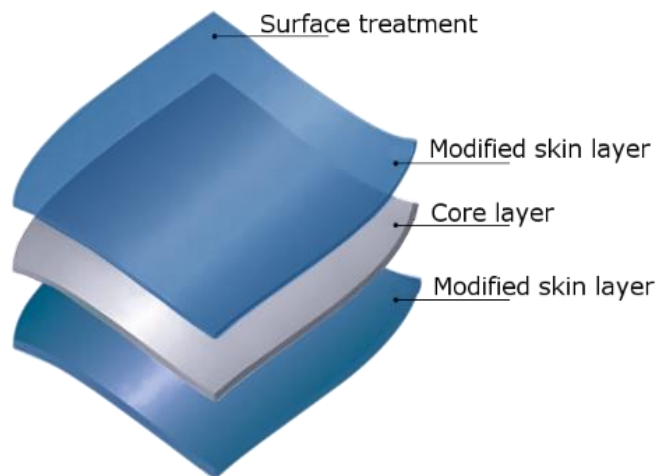
FXCL is coextruded BOPP film, heat sealable. The film is suitable for high-speed packing machines due to its low coefficient of friction. One side corona treated.

TYPICAL APPLICATIONS

General purpose packaging

High speed packaging HFFS and VFFS

High quality rotogravure and flexo printing



| Properties | Test Methods | Deviation | Typical Values | | | | | | |
|-----------------------------------------------------------|-----------------|------------|----------------|-------------|-------------|-------------|-------------|-------------|-------------|
| | | | 15 | 18 | 20 | 25 | 30 | 40 | 48 |
| Thickness μm | Internal method | | 15 | 18 | 20 | 25 | 30 | 40 | 48 |
| Average thickness deviation % | | \pm | 2.5 | 2.5 | 2.5 | 2.5 | 2 | 2 | 2 |
| Yield, m^2/kg | | $\pm 5\%$ | 73 | 61.0 | 54.9 | 44.0 | 36.6 | 27.4 | 22.9 |
| Unit weight, g/m^2 | | $\pm 5\%$ | 13.7 | 16.4 | 18.2 | 22.8 | 27.3 | 36.4 | 43.7 |
| Gloss (45°) | ASTM D 2457 | ± 2 | 85 | 85 | 85 | 85 | 85 | 85 | 85 |
| Haze, % | ASTM D 1003 | ± 0.2 | 1.8 | 1.8 | 2.0 | 2.2 | 2.4 | 2.8 | 2.8 |
| Coefficient of Friction* | ASTM D 1894 | ± 0.04 | 0.2 | 0.2 | 0.2 | 0.2 | 0.2 | 0.2 | 0.2 |
| Shrinkage, % | BMS TT 0.2 | | | | | | | | |
| MD | | | 4.5 | 4.0 | 4.0 | 4.0 | 4.0 | 4.0 | 4.0 |
| (120°C , 5 min) TD | | | 2.5 | 2.0 | 2.0 | 2.0 | 2.0 | 2.0 | 2.0 |
| Elongation at break, % | ASTM D 882 | ± 30 | | | | | | | |
| MD | | | 210 | 210 | 210 | 210 | 210 | 210 | 210 |
| TD | | | 90 | 80 | 80 | 80 | 80 | 80 | 80 |
| Sealing range **, $^\circ\text{C}$ | | | 105÷ 145 | 105÷ 145 | 105÷ 145 | 105÷ 145 | 105÷ 145 | 105÷ 145 | 105÷ 145 |
| Seal strength, N/15 mm, 130°C , 1 bar 1 sec | BMS TT 0.1 | ± 0.5 | 2.3 | 2.6 | 2.6 | 2.6 | 2.8 | 2.8 | 2.8 |
| OTR ($\text{cc}/\text{m}^2/\text{day}$) | ASTM D3985 | | 2200 | 2100 | 1900 | 1600 | 1300 | 950 | 930 |
| WVTR ($\text{gr}/\text{m}^2/\text{day}$) | ASTM F1249 | | 8 | 7 | 6.5 | 6 | 5 | 3.5 | 3.0 |
| Tensile strength, MPa | | | | | | | | | |
| MD | ASTM D 882 | ± 30 | 130 | 130 | 140 | 140 | 140 | 150 | 150 |
| TD | | | 230 | 230 | 240 | 240 | 240 | 250 | 250 |
| Surface treatment, dynes/cm | ASTM D 2578a | | Min 38 | Min 38 | Min 38 | Min 38 | Min 38 | Min 38 | Min 38 |

* - COF dynamic, film/film, untreated/untreated side

** - The sealing range starts with SIT (sealing initiation temperature), untreated/untreated side

The specified values are based on average results, measured by the manufacturer during standard production. They should not be considered as Data Sheet of any particular product.

The end user should be satisfied as to the suitability of the product for the intended application and the present regulatory regime. Therefore, Plastchim-T AD disclaims any liability for damages arising from the non-suitability of the product for the effected application.

FOOD CONTACT

The BOPP Film complies with all national and international standards and requirements for food contact. The Declaration of Compliance is accessible at www.plastchim-t.com.

PACKING

| | Core Diameter | Outer Diameter * | Notes |
|-------------------|---------------|------------------|---------------------------------------------------|
| Vertical | 152 mm (6`) | ≤ 550 mm | ≤ 700 mm – two or more rows > 700 mm – one row |
| | 76 mm (3`) | | |
| Horizontal | 152 mm (6`) | ≤ 770 mm | |
| | 76 mm (3`) | | |

(*) In case of no other requirements

TOLERANCES

| Weight tolerance, depending on the order volume | Width tolerance | Length tolerance |
|-------------------------------------------------|-----------------|------------------|
| ≤ 1 000 kg ± 20% | ± 2 mm | ±5 % |
| 1001 ÷ 10 000 ± 10% | | |
| >10 000 ± 5% | | |

Storage and Transportation Terms & Conditions

Palletizing of goods is done according to customer's requirements.

The storage of all goods is in dry, covered and clean warehouses.

The transportation of the goods is carried out in dry, covered and clean means of transport.

The recommended temperature of storage/transportation is 10-30°C. If the temperature is not within the recommended limits, the following issues may occur:

- Decrease of dyne level
- Higher haze of the film
- Poor adhesion of the film surface that on a later stage could be an issue for laminating and printing
- Extremely low COF that can trouble further processing

Excessive humidity can be a reason for film blocking.

It is recommended that BOPP film should be tempered at operating room temperature for 24 hours before use.

Before printing or laminating of BOPP films it is recommended the use of an inline treatment station in order to boost the treatment level of the printable surface or to be used adequate primer to achieve a perfect product.

Adherence to the above mentioned storage and transport conditions ensures that the film is suitable to be used up to 6 months after production.

Claims regarding to the transportation are accepted within 1 week after the delivery date. If any, a record has to be taken in the CMR.