

Calendered, rigid PVC film. The formulation of our product is in compliance with Regulation (EU) No 10/2011. The rest monomer content regarding Vinylchlorid is max. 1,0 ppm. The film complies with the guideline 94/62 EC ("Packaging and Packaging waste") and is suitable for direct contact with foodstuffs.\*

\* except for surface 304x and 504x, which is technical quality

**Characteristics** Opaque rigid PVC film, impact modified. Suitable for offset UV, digital-, screen-, flexo- and gravure printing.

Surface finish	gls/gls (2020)	gls/hgl (202E)	gls/smt (2030)	smt/cmt (3040)	mtt/gls (5020)	mtt/smt (5030)	mtt/cmt (5040)	mtt/mtt (505R)	xmtt/xmt (6060)
<b>Thickness range (mm)</b>	0,060 - 0,650	0,150 - 0,650	0,150 - 0,300	0,150 - 0,450	0,100 - 0,500	0,100 - 0,500	0,100 - 0,500	0,120 - 0,600	0,120 - 0,650

Embossings **	Fine	Grob 1	Grob 2
Roughness (Rz µm)	3 - 6	10 - 14	20 - 30

\*\* further embossings upon request

**Colours** Standard: white 1522, white 1305 (extra opaque)  
Colours according to the colour swatch

Properties	Value		Unit	Test method
<b>Thickness tolerances</b>				In accordance to DIN ISO 4593 (95% of all measurements)
< 0,200 mm	±10		%	
0,200 – 0,400 mm	± 7			
> 0,400 mm	± 5			
<b>Density</b>	1,34 ± 0,02 (without pigments)		g/cm <sup>3</sup>	DIN EN ISO 1183-1:2004
<b>Tensile impact strength</b>	> 600 (surface gls/gls)		kJ/m <sup>2</sup>	DIN EN ISO 8256
<b>Tensile strength</b>	> 42		N/mm <sup>2</sup>	DIN EN ISO 527-1-3
<b>Vicat softening point</b>	74 ± 2		°C	DIN EN ISO 306 procedure VST/B50 as pressed sheet
<b>MD expansion due to heat ***</b>	(gls/gls)	(mtt/mtt)	%	In accordance to DIN 53377 (140°C/10min)
< 0,100	max. -15	n.a.		
< 0,200 mm	max. - 7	max. -12		
0,200 – 0,400 mm	max. - 5	max. - 8		
> 0,400 mm	max. - 4	max. - 7		
*** +3% in case of embossed films				
<b>Surface tension</b>	glz/glz (2020)	≥ 34 both sides	nN/m (dyn/cm)	In accordance to DIN ISO 8296:2008-03 measured with inks (pens)
	mtt/mtt (505R)	≥ 38 roll-sides		
	mtt/mtt (505R)	≥ 36 air-sides		
	(505R) < 150µm	≥ 32AS ≥ 38RS		

### Processing advice:

To avoid static, the film should be processed at room temperature of 20 to 23°C and a relative humidity between 50 - 60 %.

### Storage conditions:

We recommend storing in original packaging at room temperature below 30°C not directly exposed to sun light and humidity. After transport and storage in cold temperature, acclimatisation of 1 hour per reel diameter or stacking height is necessary.