

Type: PR 315 4D

Calendered, rigid PVC film. The film complies with the EU – Regulation 10/2011* according to article 16 and 22 and amendments (“Clearance Certificate for items used in contact with foodstuffs”) as well as with 94/62 EC (“Packaging and Packaging waste”).

* Product placed on the market based on the requirements set out in Directive 2002/72/EC are still valid until 5 years after the adoption of the regulation.

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)
Thickness range (mm)	0,060 - 0,650	0,150 - 0,650	0,100 - 0,300	0,150 - 0,450	0,100 - 0,500	0,100 - 0,500	0,100 - 0,500	0,120 - 0,650

Embossings **	Fine	Promatt	Grob 1	Grob 2
Roughness (Rz µm)	3 - 6	6 - 9	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
Thickness tolerances < 0,200 mm 0,200 – 0,400 mm > 0,400 mm	± 10 ± 7 ± 5	%	In accordance to DIN 53370 (95% of all measurements)
Density	1,34 ± 0,01 (without pigments)	g/cm ³	DIN 53479
Tensile impact strength	> 600 (surface gls/gls)	kJ/m ²	DIN EN ISO 8256
Tensile strength	> 42	N/mm ²	DIN EN ISO 527-1-3
Vicat softening point	74 ± 2	°C	DIN EN ISO 306 procedure VST/B50 as pressed sheet
MD expansion due to heat *** < 0,200 <0,100 mm 0,200 – 0,400 mm > 0,400 mm	(gls/gls) max.- 7/15 max.- 5 max.- 4	(mtt/mtt) max.-12 max.- 8 max.- 7	% In accordance to DIN 53377 (140°C/10 min)

*** + 3% in case of embossed films

Surface tension	gls/gls (2020) mtt/mtt (505R) mtt/mtt (505R)	≥ 34 both sides ≥ 38 roll-sides ≥ 36 air-side	mN/m (dynes/cm)	In accordance to DIN 53364 measured with inks (pens)
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Processing advice:

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

Storage condition

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 cm reel diameter or stacking height is necessary.