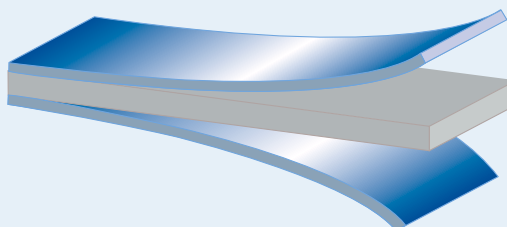


Technical Data Sheet

ILC - Low Heat-Seal Threshold film for Inner Liner.

Biaxially oriented polypropylene (BOPP) film co-extruded on both sides with polyolefinic copolymers.



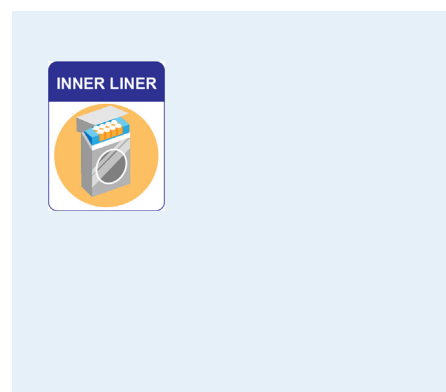
- Corona Treated Sealable Layer
- Oriented Polypropylene
- Low Seal Threshold Layer

Features

- Heat-sealable on both sides, one side having a low heat-seal threshold
- Excellent water vapour barrier
- Treated one side for printing and laminating
- Puncture and impact-resistance maintained at low temperatures

Applications

ILC has been optimised for the purpose of being used in a laminate structure for Tobacco Inner liner in conjunction with a reseal label. The film can be used plain or printed, with the outer layer engineered to run on high speed tobacco machines and to work with a resealable label.



Technical Properties (Typical Values)

Property	Test Method	Test Conditions	Units	ILC	
Thickness	Innovia Films test		micron	20	25
Yield	Innovia Films test		m ² /kg g/m ²	54.9 18.2	44.0 22.7
Permeability to: Water vapour	ASTM F 1249	23°C 85% RH 38°C 90% RH	g/m ² .24 hrs	1.4 8.0	1.2 6.0
Oxygen	ASTM F 1927	23°C 0% RH	cc/m ² .24 hrs	2500	1800
Optical: Gloss	ASTM D 2457	45°	units	95	
Haze (wide angle)	ASTM D 1003	2.5°	%	1.5	
Coefficient of friction (film to film)	ASTM D 1894	Static Dynamic		0.5 0.45	
Tensile Strength	ASTM D 882	Strain rate 50%/min	MN/m ²	MD	175
				TD	165
Elongation at break	ASTM D 882	Strain rate 50%/min	%	MD	75
				TD	90
Elasticity Modulus (1% secant)	ASTM D 882	Strain rate 10%/min	MN/m ²	MD	2600
				TD	2300
Sealing range	Innovia Films test	2 secs; 0.10MN/m ² 2 secs; 15 psi	°C °F	85-145 untreated to untreated	
Seal strength	Innovia Films test	130°; 2 secs; 0.10MN/m ² 265°F; 2 secs; 15 psi	g(f)/25mm/ in	>350 untreated to untreated	
Shrinkage	Innovia Films test	60 secs at 130°C	%	MD	6.0
				TD	2.5

MD Machine Direction TD Transverse Direction

All properties are tested under standard laboratory conditions: 23 ± 2°C, 50 ± 5% RH, unless otherwise stated. Where relevant, tests are based on international testing standards.

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Propafilm™ ILC

Technical Data Sheet

Reel Specifications

Nominal Reel Diameters

Film	12x Length (metres)
ILC20	22800
ILC25	18000



Other reel lengths are available subject to negotiation.

Outside Diameter	6x	8x	12x
For 77mm / 3in core	-	-	-
For 153mm / 6in core	570mm 22½in	650mm 25½in	785mm 31in

Film Preferred Print Surface

Corona Discharge Treatment

Propafilm™ ILC is corona discharge treated on one side only, the reverse side exhibiting a low heat-seal threshold. The treated surface can be wound as either the inner or outer surface of Propafilm™ ILC. The treated surface is indicated by a symbol on a label attached to each reel.

Treated Surface	Ordering Code	Label Symbol
Inside	I	
Outside	O	

Film Storage and Handling

No special conditions are required for the storage of Propafilm™ ILC but it is recommended that dry conditions at temperatures below 30°C are employed to minimise any deterioration of surface discharge treatment level. Propafilm™ ILC is suitable for use for 6 months from the date of delivery and stocks should be used in rotation. Films should be allowed to reach operating room temperatures for 24 hours before use.

Food Contact

Propafilm™ ILC complies with the applicable EU legislation for most applications involving direct contact with foods. Full details are given on the Declaration of Compliance. Customers intending to use Propafilm™ ILC in a food contact application should request a copy of this document from Innovia Films. Details of compliance with food contact legislation in non-EU countries are also available upon request.

Health & Safety Guidelines

For Health & Safety information, please refer to literature reference B190.

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