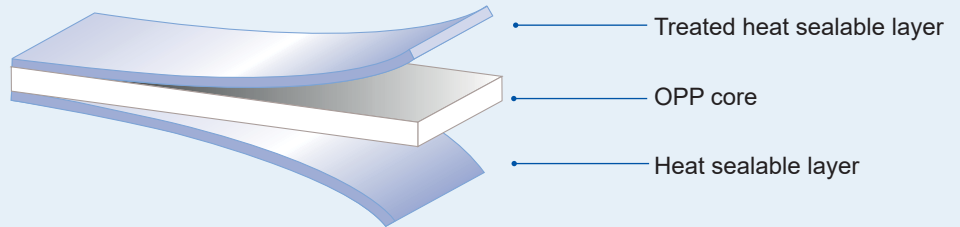


Propafilm™ HTD

Technical Data Sheet

HTD - Very wide seal range, low CoF, heat sealable, two-side sealable coextruded OPP film

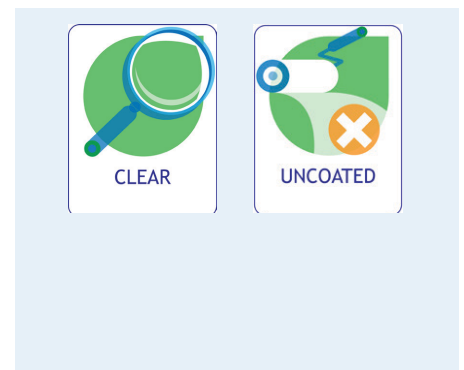


Features

- Wide heat seal range on both sides and opportunity for lower sealing temperatures
- Low CoF on treated side for smooth flow wrapping
- Excellent hot tack for vertical packages
- High transparency, low haze and gloss provide shelf appeal
- Good moisture and odor barrier for product protection

Application

- Horizontal packaging in laminated or single web form
- Vertical packaging in laminated or single web form
- Multi-lane ice cream packaging
- End-fold overwrap utilizing the wide seal range and low CoF on both faces
- Ice cream, Bundle Wrap Soaps, Baked Goods and Confectionery



Technical Properties (Typical Values)

Property	Test Method	Test Conditions	Units	HTD	
Thickness	ASTM D 4321		micron	22	
			gauge	90	
Yield	ASTM D 4321		in ² /lb	34,300	
			m ² /kg	48.8	
Basis Weight	ASTM D 4321		g/m ²	20.5	
			lbs/ream	12.6	
Nominal density	Innovia test method		g/cm ³	0.91	
Tensile strength	Innovia test method		kpsi	MD	23.9
				TD	47.1
Elongation at break	Innovia test method		%	MD	165
				TD	58
Surface tension	ASTM D 2578	Print	mN/m (dyne)	36-39	
Haze	ASTM D 1003		%	<3.0	
Coefficient of Friction	ASTM D 1894	Print Face		0.25	
MVTR	Innovia test method	38°C (100°F)/90% RH	g/m ² /day	5.5	
			g/100in ² /day	0.36	
Heat seal range	Innovia test method	Back	°C (min/max)	95-150	
			°F (min/max)	203-300	
		Print	°C (min/max)	108-150	
			°F (min/max)	225-300	
Heat seal strength	Innovia test method	266°F/14.5psi/0.5sec 130°C/10N/0.5sec	N/15mm	2.0	
			g/in	345	

MD Machine Direction TD Transverse Direction

All properties are tested under standard laboratory conditions: 73 ± 4F, 50 ± 5% RH (23 ± 2°C, 50 ± 5% RH) unless otherwise stated. Where relevant, tests are based on international standards. This document is not a product specification and does not guarantee any specific product attributes. Any existing commercial rights or patents must be observed.

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use our imagination...

Propafilm™ HTD

Technical Data Sheet

Conversion

Treatment and Winding	Surface Printing
One surface treated for printing and/or laminating	Ink recommendations for all print processes are available
Treated surface wound to outside of roll	Printing and anti-static properties guaranteed for 6 months only
See roll tag about treatment specific to roll	Excellent web flatness permits higher speed printing
	Run appropriate trials prior to production
	Consult your ink supplier

Conversion Note -

Generally PVB or NC-based inks with adequate adhesion promoter are suitable for printing on the film. Drying temperatures should not exceed a web temperature of 170°F (76°C).

Where static electricity may be generated, use of static eliminators and maintaining a relative humidity >50% is recommended.

Lamination

Usually laminated to an Innovia Films' film using solvent-based or solvent-less adhesives.

Nominal Reel Diameters

Film	Length (metres)				
HTD 22	1,606	3,213	9,639	21,678	28,917

Film	Length (feet)				
HTD 90	5,269	10,541	31,624	71,122	94,872

Outside Diameter	1/2x	1x	3x	6x	9x
For 3in / 77mm core	9.4" (in) 238mm	12.8" (in) 324mm	-		
For 6in / 153mm core	-		22.3" (in) 566mm	30.8" (in) 781mm	38.1" (in) 949mm

All rolls are wound to length. Actual OD may vary with thickness and winding density variations.

Film Storage and Handling

The films should be placed in the processing area 24 hours prior to processing, to acclimatise. The films are largely unaffected by climatic conditions but should not be stored at temperatures above 104°F (40°C). Under suitable storage conditions, the film can be stored for a period of 6 months without any risk of deterioration.

Food Contact

Propafilm™ HTD is FDA approved for food contact. Please contact Technical Services for other Food Contact statements.

Health & Safety Guidelines

MSDS sheets, as well as other product safety documents, are available for our films upon request.

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