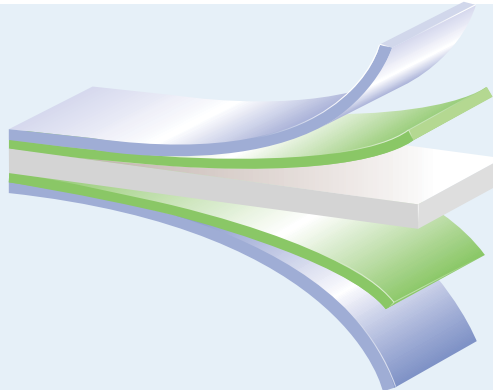


Propafilm™ QLD

Technical Data Sheet

QLD - White, high gloss, cavitated, multi-layer coextruded OPP film with an ultra-wide heat seal range



- High gloss treated heat sealable layer
- OPP Layer
- White cavitated OPP core
- OPP Layer
- High gloss heat sealable layer (very wide 125° F / 70°C range)

Features

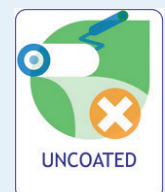
Ultra wide seal range (125°F / 70°C) provides:

- Economic savings vs coated and hot melt structures
- Very high horizontal machine speeds and efficiencies by lowering sealing temperatures
- Yield advantage of 50% over transparent and solid films

High gloss, opacity, puncture resistance and barrier properties

Application

- Confectionery
- Baked goods
- Horizontal packaging in a single web or laminated form
- End-fold overwrap in single web or laminated form



Technical Properties (Typical Values)

Property	Test Method	Test Conditions	Units	QLD			
				30	35	45	
Thickness	Innovia test method		micron	30	35	45	
			gauge	120	140	170	
Yield	ASTM D 4321		in ² /lb	34,500	29,900	23,400	
			m ² /kg	49.0	42.6	33.3	
Basis Weight	ASTM D 4321		g/m ²	20.4	23.5	30.0	
			lbs/ream	12.5	14.4	18.4	
Nominal density	Innovia test method		g/cm ³	0.73	0.71	0.70	
Breaking load	Innovia test method		lbs/in	MD	15	17	21
				TD	29	38	48
Elongation at break	Innovia test method		%	MD	140	140	140
				TD	35	35	35
Gloss	Innovia test method		[45°]	50	50	50	
Opacity	Innovia test method		%	78	82	85	
Whiteness	Innovia test method		% (Berger)	88	89	90	
Surface tension	ASTM D 2578	Print	mN/m (dyne)	36-39	36-39	36-39	
Coefficient of Friction	ASTM D 1894	Treated to Treated		0.30	0.30	0.60	
MVTR	Innovia test method	38°C (100°F)/90% RH	g/m ² /day	6.5	5.5	4.4	
			g/100in ² /day	0.42	0.35	0.28	
Heat seal range back		(min/max) (min/max)	°C (min/max)	80-150	80-150	80-150	
			°F (min/max)	175-300	175-300	175-300	
Heat seal strength	Innovia test method	Back 266°F/14.5psi/0.5sec 130°C/10N/0.5sec	N/15mm	1	1	1	
			g/in	173	173	173	

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.
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Propafilm™ QLD

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, coating or adhesive 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. Can be laminated to Innovia's transparent films using solvent-based or solvent-less laminations.

Nominal Reel Diameters

Film	Length (metres)				
QLD 30	1,340	2,680	8,040	16,080	24,120
QLD 35	1,138	2,275	6,825	13,650	20,475
QLD 45	875	1,750	5,250	10,500	158,750

Film	Length (feet)				
QLD 120	4,396	8,793	26,378	52,756	79,134
QLD 140	3,732	7,464	22,392	44,783	67,175
QLD 170	2,871	5,741	17,224	34,449	51,673

Outside Diameter	1/2x	1x	3x	6x	9x
For 3in / 77mm core	9.5" (in) 242mm	13" (in) 330mm	-	-	-
For 6in / 153mm core	-	-	22.7" (in) 576mm	31.3" (in) 796mm	38.1" (in) 967mm

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™ QLD 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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