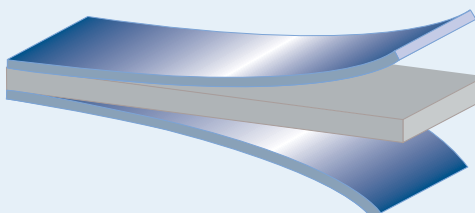


Propafilm™ RLC (Tobacco)

Technical Datasheet

RLC - Low Heat-Seal Threshold Film for Inner Liner.

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



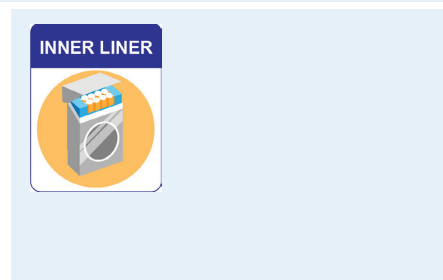
- Corona Treated Sealable Layer
- Oriented Polypropylene
- Low Seal Threshold Layer

Features

- Heat-sealable both sides, one side having a low heat-seal threshold
- Excellent water vapour barrier
- Treated one side for printing and laminating

Applications

RLC has been designed specifically 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.



Technical Properties (Typical Values)

Property	Test Method	Test Conditions	Units	RLC	
Thickness	Innovia Films test		micron	20	
			gauge	80	
Yield	Innovia Films test		m ² /kg	54.9	
			in ² /lb	38600	
			g/m ²	18.2	
Permeability to: Water vapour	ASTM F 1249	38°C 90% RH 100°F 90% RH	g/m ² .24 hrs	8.0	
			g/100in ² . 24 hrs	0.52	
Oxygen	ASTM F 1927	23°C 0% RH 73°F 0% RH	cc/m ² .24 hrs	2500	
			cc/100in ² . 24 hrs	161	
Optical: Gloss Haze (wide angle)	ASTM D 2457 ASTM D 1003	20° 2.5°	units	95	
			%	1.5	
Coefficient of friction (out to out)	ASTM D 1894	Static/ Dynamic		0.55	
				0.50	
Corona treatment	Innovia Films test		dynes/cm	38	
Tensile strength	ASTM D 882	Strain rate 50% / min	MN/m ²	MD	175
				TD	165
			lb/in ²	MD	25400
				TD	23900
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
			lb/in ²	MD	377100
				TD	333600
Sealing range	Innovia Films test	2 secs; 0.10MN/m ² 2 secs; 15 psi	°C	90-145	
			°F	195-295	
				untreated to untreated	
Seal strength	Innovia Films test	130°C; 2 secs; 0.10MN/m ² 265°F; 2 secs; 15 psi/in ²	g(f)/25mm/ in	>350	
			untreated to untreated		
Shrinkage	Innovia Films test	60 secs at 130°C (266°F)	%	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,(73 ± 4F, 50 ± 5% RH), unless otherwise stated. Where relevant, tests are based on international testing standards.
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Propafilm™ RLC (Tobacco)

Technical Data Sheet

Reel Specifications

Nominal Reel Diameters

Film	12x Length (metres)
RLC20	22800

Film	12x Length (feet)
RLC80	74803

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

Corona Discharge Treatment

Propafilm™ RLC 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™ RLC. 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™ RLC but it is recommended that dry conditions at temperatures below 30°C (85°F) are employed to minimise any deterioration of surface discharge treatment level. Propafilm™ RLC 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™ RLC complies with the applicable EU and US legislation for most applications involving direct contact with foods. Full details are given on the Declaration of Compliance. Customers intending to use Propafilm™ RLC 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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