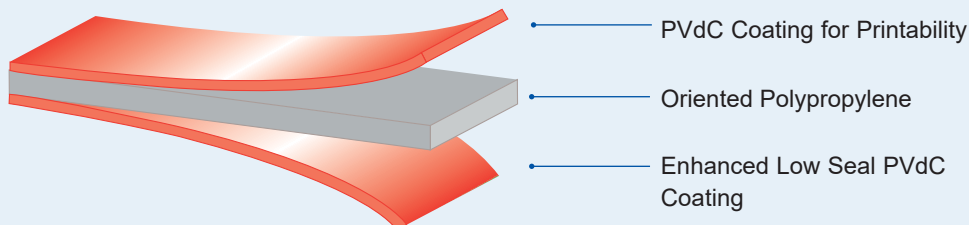


Propafilm™ RXD

Technical Data Sheet

RXD - Barrier Coated Film.

Biaxially oriented polypropylene (BOPP) film coated on both sides with an aqueous dispersion of polyolefinic chloride (PVdC) copolymers.



Features

- Differentially PVdC coated to optimise superb printability with excellent sealability/machinability
- Excellent barrier to water vapour, gases and aromas
- One side preferential print surface, one side wide seal surface
- Puncture and impact-resistance properties are maintained even at low temperatures
- Unaffected by variations in climatic conditions

Applications

RXD22(90) is suitable for use as a single web or in laminate structures for overwrapping and form-fill-seal packaging.

RXD28(110)/32(130)/35(140) are recommended for use in plain and printed overwrapping applications in the biscuit and bakery industries. Also suited for use as a single web or in laminate structures for medium to large packs on form-fill-seal machines.

Technical Properties (Typical Values)

| Property | Test Method | Test Conditions | Units | RXD | | | | |
|--|--------------------|---|--------------------------------|-----------|-------|-------|-------|--|
| | | | | 22 | 28 | 32 | 35 | |
| Thickness | Innovia Films test | | micron | 22 | 28 | 32 | 35 | |
| | | | gauge | 90 | 110 | 130 | 140 | |
| Yield | Innovia Films test | | m ² /kg | 48.2 | 39.6 | 33.6 | 29.1 | |
| | | | in ² /lb | 33900 | 27850 | 23600 | 20450 | |
| | | | g/m ² | 20.7 | 25.3 | 29.8 | 34.4 | |
| Permeability to: Water vapour | ASTM F 1249 | 38°C 90% RH 100°F 90% RH | g/m ² .24 hrs | 4.8 | 4.0 | 3.6 | 3.3 | |
| | | | g/100in ² . 24 hrs | 0.31 | 0.26 | 0.23 | 0.21 | |
| Oxygen | ASTM F 1927 | 23°C 0% RH 73°F 0% RH | cc/m ² .24 hrs | 15 | 15 | 15 | 15 | |
| | | | cc/100in ² . 24 hrs | 0.97 | 0.97 | 0.97 | 0.97 | |
| Optical: Gloss | ASTM D 2457 | 45° | units | 110 | | | | |
| Haze (wide angle) | ASTM D 1003 | 2.5° | % | 2.0 | | | | |
| Coefficient of friction (film to film) | ASTM D 1894 | Static/ Dynamic | | 0.20-0.30 | | | | |
| | | | | 0.20-0.30 | | | | |
| Sealing range | Innovia Films test | 2 secs; 0.10MN/m ² 2 secs; 15 psi | °C | 95-145 | | | | |
| | | | °F | 200-295 | | | | |
| Seal strength | Innovia Films test | 130°C; 2 secs; 0.10MN/m ² 265°F; 2 secs; 15 psi | g(f)/25mm/ in | >350 | | | | |
| Shrinkage | Innovia Films test | 60 secs at 120°C (250°F) 60 secs at 130°C (265°F) | % | MD | 4.0 | | | |
| | | | | TD | Nil | | | |
| | | | | MD | 7.0 | | | |
| | | | | TD | 1.0 | | | |

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™ RXD

Technical Data Sheet

Reel Specifications



Nominal Reel Diameters

| Film | Single Length (metres) | 12x Length (metres) |
|--------|------------------------|---------------------|
| RXD22 | 1700 | 20400 |
| RXD28 | 1500 | 18000 |
| RXD32 | 1250 | 15000 |
| RXD35 | 1100 | 13200 |
| Film | Single Length (feet) | 12x Length (feet) |
| RXD90 | 5600 | 66950 |
| RXD110 | 4900 | 59050 |
| RXD130 | 4100 | 49200 |
| RXD140 | 3610 | 43320 |

Other reel lengths are available subject to negotiation.

| Outside Diameter | 1x | 2x | 4x | 6x | 8x | 12x |
|----------------------|---------------|---------------|----------------|----------------|----------------|---------------|
| For 77mm / 3in core | 240mm 9½in | 330mm 13in | 450mm 18in | - | - | - |
| For 153mm / 6in core | - | - | 475mm 18¾in | 570mm 22½in | 650mm 25½in | 785mm 31in |

The preferred print surface is available on either the inner or outer surface of Propafilm™ RXD. The print 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™ RXD but it is recommended that dry conditions at temperatures below 30°C (85°F) are employed. Propafilm™ RXD 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™ RXD 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™ RXD 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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