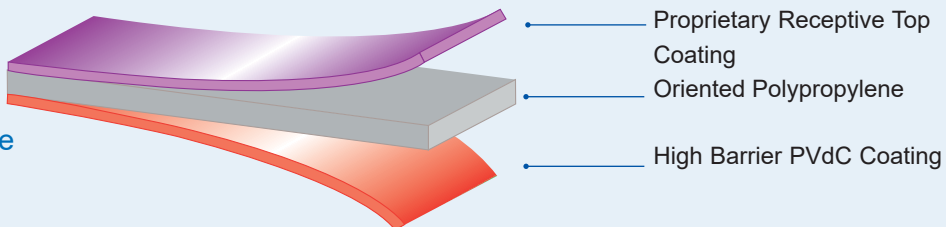


# Propafilm™ XDI

## Technical Data Sheet

### XDI - Coated High Barrier Film

- Biaxially oriented polypropylene (BOPP) film with a HP Indigo® ElectroInk™ receptive coating on one side and an aqueous dispersion of polyvinylidene chloride (PVdC) on the other side.



### Features

- Proprietary ElectroInk™ receptive top coat
- Excellent seal properties in terms of strength, hot tack and integrity
- Totally forgiving on horizontal flow-wrap machines
- Very high barrier to water vapour, gases and aromas
- Good optical properties
- No seal compatibility between print coating and PVdC coatings

### Applications

**XDI31(125)** is suitable for use as single film or in laminate structures for form-fill-seal packaging especially in the bakery and biscuit industries, requiring strong seals and excellent seal integrity.

### Technical Properties (Typical Values)

Property	Test Method	Test Conditions	Units	XDI
Thickness	Innovia Films test		micron	31
			gauge	125
Yield	Innovia Films test		m <sup>2</sup> /kg	34.5
			in <sup>2</sup> /lb	24250
			g/m <sup>2</sup>	29.0
Permeability to: Water vapour	ASTM F 1249	38°C 90% RH 100°F 90% RH	g/m <sup>2</sup> .24 hrs	3.2
			g/100in <sup>2</sup> . 24 hrs	0.21
Oxygen	ASTM F 1927	23°C 0% RH 73°F 0% RH	cc/m <sup>2</sup> .24 hrs	6
			cc/100in <sup>2</sup> . 24 hrs	0.4
Optical: Gloss	ASTM D 2457	45°	units	100
Haze (wide angle)	ASTM D 1003	2.5°	%	2-3
Coefficient of friction	ASTM D 1894	Dynamic		0.40
Sealing range	Innovia Films test	2 secs; 0.10MN/m <sup>2</sup> 2 secs; 15 psi	°C	105-145
			°F	221-293
Seal strength	Innovia Films test	130°C; 2 secs; 0.10MN/m <sup>2</sup> 265°F; 2 secs; 15 psi	g(f)/25mm/ in	>400
Shrinkage	Innovia Films test	60 secs at 120°C (250°F)	% MD	4.9
			% TD	1.4
		60 secs at 130°C (265°F)	% MD	8.6
			% TD	2.0

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.

Ref B660 - 1 of 2 - 0819

# Propafilm™ XDI

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### Reel Specifications

#### Nominal Reel Diameters

Film	Single Length (metres)	12x Length (metres)
XDI31	1250	14400

Film	Single Length (feet)	12x Length (feet)
XDI125	3950	47250

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

### Preferred Print Surface

The preferred print surface is available on either the inner or outer surface of Propafilm™ XDI. 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

The low heat-seal threshold and wide seal range of Propafilm™ XDI film allows its use in particularly demanding packaging machine applications. Care should therefore be taken to protect reels of film from storage temperatures above 30°C (85°F) and localised sources of heat above 45°C (113°F). Reels of Propafilm™ XDI should be protected from high levels of moisture and accidental water splashes at all times. The reels should remain in the protective coverings supplied until ready for use on converting or packaging machinery. Converted reels, in both master and slit reel form should be similarly protected at all times. Propafilm™ XDI 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™ XDI 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™ XDI 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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Ref B660 - 2 of 2 - 0819

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