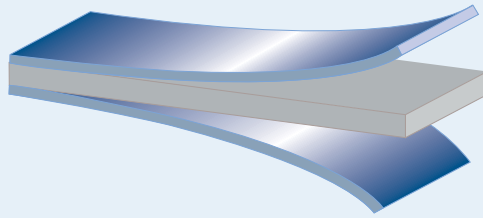


# Propafilm™ XLT (Tobacco)

## Technical Datasheet

### XLT - High Speed Overwrapping Film with Shrink Tightening Properties.

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



High Slip Sealable Layer  
Oriented Polypropylene Blend  
Low Slip Sealable Layer

### Features

- Excellent sparkle and gloss
- Superior controlled, balanced shrinkage
- Enhanced machine performance with excellent seal range and scuff resistance
- Satisfies requirements for vending blocking applications
- Excellent moisture and flavour barrier
- Differential slip properties for tight wraps
- Overcomes film relaxation problems
- Resistant to solvent attack

### Applications

XLT is suitable for use in the tobacco industry for both high speed overwrapping of printed packs and display outers where exceptional pack appearance and wrap tightness are required.



### Technical Properties (Typical Values)

| Property                               | Test Method        | Test Conditions   | Units                          | XLT     |
|--|--------------------|---|--------------------------------|---------|
| Thickness                              | Innovia Films test |   | micron                         | 16      |
|  |                    |   | gauge                          | 65      |
| Yield                                  | Innovia Films test |   | m <sup>2</sup> /kg             | 66.6    |
|  |                    |   | in <sup>2</sup> /lb            | 46800   |
|  |                    |   | g/m <sup>2</sup>               | 15.0    |
| Permeability to: Water vapour          | ASTM F 1249        | 38°C 90% RH<br>100°F 90% RH                                   | g/m <sup>2</sup> .24 hrs       | 7.6     |
|  |                    |   | g/100in <sup>2</sup> . 24 hrs  | 0.49    |
| Oxygen                                 | ASTM F 1927        | 23°C 0% RH<br>73°F 0% RH                                      | cc/m <sup>2</sup> .24 hrs      | 2200    |
|  |                    |   | cc/100in <sup>2</sup> . 24 hrs | 142     |
| Optical: Gloss                         | ASTM D 2457        | 20°   | units                          | 135     |
| Haze (wide angle)                      | ASTM D 1003        | 2.5°  | %                              | 1.2     |
| Coefficient of friction (film to film) | ASTM D 1894        | Static/<br>Dynamic  |                                | 0.35    |
|  |                    |   |                                | 0.25    |
| Blocking                               | Innovia Films test | 70°C (158°F) / 200g / 2hrs                                    | N                              | 5       |
| Tensile strength                       | ASTM D 882         | Strain rate<br>50% / min                                      | MN/m <sup>2</sup> MD           | 170     |
|  |                    |   | TD                             | 210     |
|  |                    |   | lb/in <sup>2</sup> MD          | 24700   |
|  |                    |   | TD                             | 30500   |
| Elongation at break                    | ASTM D 882         | Strain rate<br>50% / min                                      | % MD                           | 120     |
|  |                    |   | TD                             | 80      |
| Elasticity modulus (1% secant)         | ASTM D 882         | Strain rate<br>10% / min                                      | MN/m <sup>2</sup> MD           | 3000    |
|  |                    |   | TD                             | 3600    |
|  |                    |   | lb/in <sup>2</sup> MD          | 435100  |
|  |                    |   | TD                             | 522100  |
| Sealing range                          | Innovia Films test | 2 secs; 0.10MN/m <sup>2</sup><br>2 secs; 15 psi               | °C                             | 110-140 |
|  |                    |   | °F                             | 230-285 |
| Seal strength                          | Innovia Films test | 109°C; 2 secs; 0.10MN/m <sup>2</sup><br>225°F; 2 secs; 15 psi | g(f)/25mm/<br>in               | 480     |
| Shrinkage                              | Innovia Films test | 60 secs at 80°C<br>(176°F)<br>60 secs at 120°C<br>(248°F)     | % MD                           | 3.7     |
|  |                    |   | TD                             | 3.5     |
|  |                    |   | MD                             | 7.0     |
|  |                    |   | TD                             | 11.0    |

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™ XLT

## Technical Data Sheet

### Reel Specifications

#### Nominal Reel Diameters

| Film  | 2x Length (metres) |
|-------|--------------------|
| XLT16 | 4700               |
| Film  | 2x Length (feet)   |
| XLT65 | 15420              |

Our preferred reel length is 2x. Other reel lengths are available on request.

| Outside Diameter    | 2x            | 4x | 6x | 8x | 12x |
|---------------------|---------------|----|----|----|-----|
| For 77mm / 3in core | 330mm<br>13in | -  | -  | -  | -   |

### Film Winding

Propafilm™ XLT has differential slip properties for maximum wrap tightness. When overwrapping, it is advised to use the low slip surface on the inside of the packs. The low slip surface is identified by a symbol on the reel label as below.

| Low Slip/Treated Surface | Ordering Code | Label Symbol          |
|--------------------------|---------------|-----------------------|
| Inside                   | I             | Low slip/treatable >> |
| Outside                  | O             | Low slip/treatable << |

\*For printing application consult an Innovia Films Technical Representative

### Film Storage and Handling

No special conditions are required for the storage of Propafilm™ XLT but it is recommended that dry conditions at temperatures below 30°C (86°F) are employed. Propafilm™ XLT 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™ XLT 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™ XLT 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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