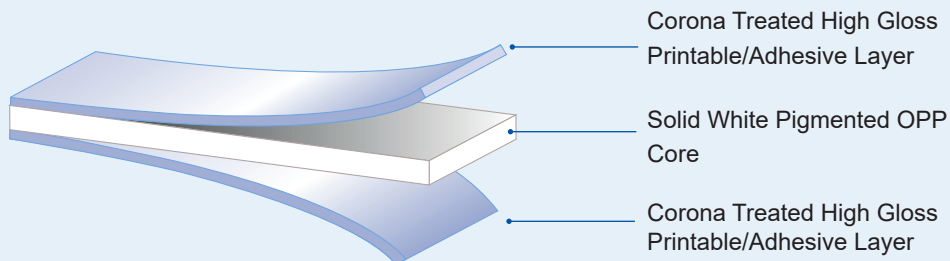


RayoForm™ IWU

Technical Data Sheet

IWU - White Pigmented, Biaxially Oriented Polypropylene Film for In Mould Labelling.

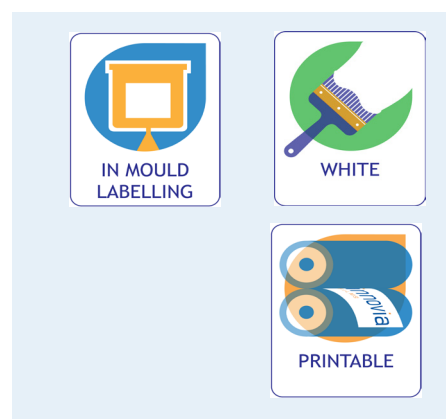


Features

- Excellent whiteness
- High gloss surface both sides
- Anti-static
- Recyclable with polyolefin materials
- Balanced biaxial orientation
- Suitable for sheet fed processes
- No 'orange peel' effect
- Resistant to moisture and oils

Printability

RayoForm™ IWU can be printed by flexographic, gravure, letterpress and screen processes. Its anti-static nature also makes it ideally suited to sheet fed litho processes. However, exact ink systems should be recommended by your supplier. Either surface of RayoForm™ IWU can be printed.



Technical Properties (Typical Values)

Property	Test Method	Test Conditions	Units	IWU	
Thickness	Innovia Films test		micron	55	65
			gauge	220	260
Yield	Innovia Films test		m ² /kg	18.6	15.7
			in ² /lb	13050	11050
			g/m ²	53.9	63.7
Optical opacity	ASTM D 2457	45°	%	80	82
Tensile strength	ASTM D 882	Strain rate 50%/min	MN/m ²	MD	175
				TD	155
			kpsi	MD	25.4
				TD	22.5
Elongation at break	ASTM D 882	Strain rate 50%/min	%	MD	85
				TD	110
Elasticity modulus (1% secant)	ASTM D 882	Strain rate 10%/min	MN/m ²	MD	2400
				TD	2100
			kpsi	MD	348
				TD	304
Dimensional stability	Innovia Films test	60 secs at 130°C (266°F)	%	MD	3.0
				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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RayoForm™ IWU

Technical Data Sheet

Applications

RayoForm™ IWU is a solid white, biaxially oriented polypropylene film for injection in mould labelling of polyethylene and polypropylene containers. Its balanced biaxial orientation makes it ideally suited to the complex die cut shapes required for multi-surface labelling of tubs as well as less demanding cylindrical mouldings. The films balanced orientation also results in reduced container distortion. The films solid nature ensures no 'orange peel' effect after moulding.

Reel Specifications

Nominal Reel Diameters

Film	Single Length (metres)	12x Length (metres)
IWU55	700	8400
IWU65	600	7200

Film	Single Length (feet)	12x Length (feet)
IWU220	2300	27600
IWU260	1970	23650

Other reel lengths are available in multiples of the single length as per the core diameter listed below.

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

Alternative reel lengths/core sizes are available subject to negotiation.

Film Storage and Handling

For the storage of RayoForm™ IWU it is recommended that dry conditions at temperatures below 30°C (86°F) are employed to minimise any deterioration of surface discharge treatment level. RayoForm™ IWU 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

RayoForm™ IWU complies with the applicable EU legislation for most applications involving direct contact with food. Details are given on the Declaration of Compliance. Customers intending to use RayoForm™ IWU in a food contact application should request a copy of this document from Innovia Films.

Health & Safety Guidelines

For Health & Safety information, please refer to literature reference L190.

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Regional Offices:

Europe (UK) Tel +44 16973 42281
Americas (USA) Tel +1 877 822 6273
Asia-Pacific (Aus) Tel +61 3 9303 0600

www.innoviafilms.com
email: labels@innoviafilms.com
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