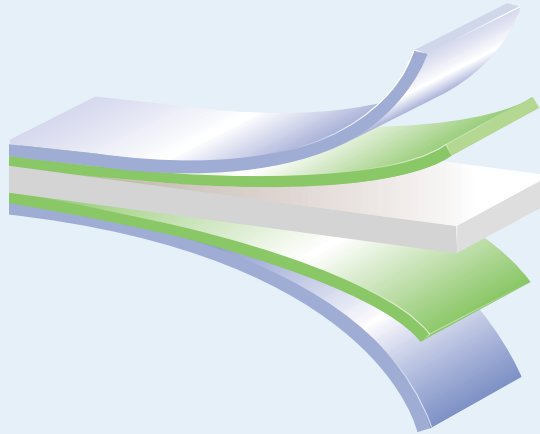


RayoForm™ IM

Technical Data Sheet

IM - White opaque, cavitated, Biaxially oriented polypropylene (BOPP) film, both sides heat sealable, one side matt.



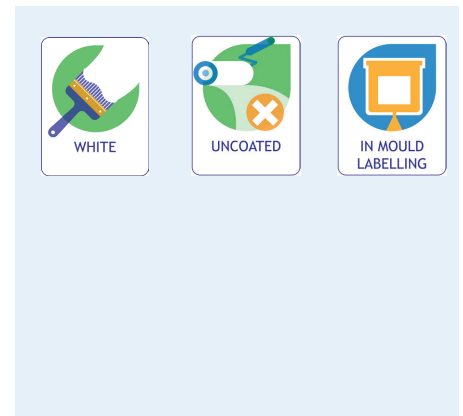
- Treated Heat Sealable Glossy Layer
- White OPP Interlayer
- Cavitated OPP Core
- White OPP Interlayer
- Treated Mould-Ready Matt Layer

Features

- Both sides corona treated
- High opacity
- Good mechanical properties
- Perfect sealability
- High light barrier
- High water vapour barrier

Applications

- Flexographic and off-set UV printing
- Injection in-mould labels



Technical Properties (Typical Values)

Property	Test Method	Test Conditions	Units	IM	
Thickness	ISO 4593		micron	60	65
Yield Unit weight	ISO 536		m ² /kg g/m ²	26.88 37.20	24.81 40.30
Opacity	ISO 2471		%	85	
Gloss (outside/inside)	ASTM D 2457	45°	GU	60/20	
Density	ISO 845		g/cm ³	0.62	
Coefficient of friction (inner/inner)	ISO 8295	Dynamic		0.35	
Corona treatment (outside/inside)	ISO 8296		mN/m (dyne)	38/38	
Tensile Strength	ISO 527-1,-3		N/mm ²	MD TD	100 200
Elongation at break	ISO 527-1,-3		%	MD TD	150 40
Thermal shrinkage	Innovia Films test	120°C, 5'	%	MD TD	2.0 2.0
Sealing range*	Innovia Films test	1"; 150N; 130°C	°C	105-140	
Heat seal strength (inner/inner)	Innovia Films test	1"; 150N; 130°C	N/15mm	3.5	6.0

*The selection of sealing temperatures depends on the characteristic of heat sealing bars and packaging process speed.

MD Machine Direction TD Transverse Direction
All properties are tested under standard laboratory conditions: 23 ± 2°C, 50 ± 5% RH, unless otherwise stated. Where relevant, tests are based on international testing standards.

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RayoForm™ IM

Technical Data Sheet

Reel Specifications

Nominal Reel Diameters

Film	Outside Diameter 570mm (metres) - core 152mm	Outside Diameter 770mm (metres) - core 152mm	Outside Diameter 980mm (metres) - core 152mm
IM60	3750	7050	11650
IM65	3450	6550	10750

ns= non standard.

Other reel lengths are available subject to negotiation.

Reel Labelling

Different films have various special surfaces; these are indicated on the reel labels.

Film Storage and Handling

Recommended processing conditions: 15-35°C, humidity below 75% RH. Before processing it is recommended to season the film in the processing conditions at temperature 20°C for a minimum of 24 hours.

In case of transporting or storing the film:

- below +15°C or above +35°C seasoning time should be extended to 48 hours;
- below + 5°C or above +40°C seasoning time should be extended to 72 hours.

Compliance with the above guarantees correct film processing.

Food Contact

RayoForm™ IM complies with the applicable EU legislation for most applications involving direct contact with foods. Full details are given on the Declaration of Compliance. Customers intending to use RayoForm™ IM 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 Innovia Poland's Quality documents.

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