

Technical specification - standard requirements INNOVIA FILMS POLAND

Visual examination/Film appearance (in reel)

Material should be free from optical defects (within internal tolerance), properly packed (clean and undamaged packaging materials).

Defects such as:

Contaminations (dirt and dust between film layers - doesn't apply to the outer layers of the film*), creases/wrinkles/folds (machine/transverse direction), telescoping, dishing of the reel forehead, damaged edges (incisions, fraying, ripping), tight winding (blocking effect), loose winding, starring forming are unacceptable except for the cases described below.

Defects in form of starring on the film in reel not exceeding 30 mm are acceptable. They can appear at the outer ends of the reels and at the ends of the reels at a distance of no more than 30mm from the cardboard core, causing transverse direction wrinkles/creases of the material.

Transverse and longitudinal direction creases/wrinkles/folds on the film web are allowed up to inner 400lm of the film length from the cardboard core.

Discolorations within one color visible on the forehead of the film reel is allowed.

* As a precautionary measure to ensure food safety, supplier recommends that customer should discard the outermost and innermost circumferential turns of films on each reel during its subsequent conversion.

Winding

Dimensional requirements

Nominal reel Outside Diameter:

570mm (core 76 and 152mm); 770mm, 980mm, 1200mm (core 152mm).

Film width tolerance +/- 2mm.

Film (reel) Outside Diameter tolerance +/- 50mm.

Raised film layers (high edges) - not more than 3mm from the tangent layers.

Film layers shifting (in relation to the reel forehead) - not more than 2mm.

Single film layers protrusion - up to 10 layers, not more than 3mm.

Core width tolerance - 0/+5 mm; Cardboard core shifting/protrusion (in relation to the reel forehead) - not more than 3mm.

Core inside diameter:

nominal 152mm and 76mm +/-1mm

The reels will be wound to a sufficient internal hardness standard to prevent telescoping when handled or properly mounted on a machine.

Joins/ Splices;

Methods and tolerances

Permissible number of joins depending on the outer diameter of the reel:

- not more than 1 join for reel less-than or equal to 370mm outside diameter
- not more than 2 joins for reel less-than or equal to 570mm and 770mm outside diameter
- not more than 3 joins for reel greater-than or equal to 980mm outside diameter

Each join/splice of the film is marked. Marking of the connection is made by sticking to the edge of the film on both sides of the reel, the so-called flags.

The flag is placed between 10 and 100 lm from the join.

For purpose information number of joins/splices is printed on a reel label.

If there are more than 1 join, they shouldn't be located at a distance of less than 500m between them or on a radius of up to 5mm on the forehead of the reel

(depending on which of the above parameters is met).

Packing method

Reels packed on wooden pallets in a horizontal or vertical position, or without use of a pallet in a vertical position.

The method of packing and the type of packing materials used depend on the width of the reel, net weight and its outer diameter.

Please contact the supplier for more details.

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Labelling

In order to ensure full traceability of the reel, the labels contain the following information:

On the reel label

- manufactured date
- net weight (kg)
- film type
- film thickness (μm)
- width (mm)
- outside diameter (mm)
- core nominal diameter (mm)
- no. of joins/ splices
- length (m)
- reel (lot) number
- customer purchase/order/reference no.
- corona treatment side/printable side

Additionally on the pallet label

- pallet date
- gross weight (kg)
- total length (m)
- reels quantity

Shelf life

Guarantee is provided for 6 months from the production date for BOPP films and for 3 months from the production date for CPP films - not applicable to the corona treatment level.

The production date is indicated on the reel label. Detailed information can be found in the General Terms and Conditions of Sale, Chapter IX. Warranty and liability of the supplier.

Storage method and converting conditions

Reels should be stored in their original packing materials on pallets in dry closed sun protected place min 1m from heating units. Storage conditions should eliminate any risk of packing materials deterioration.

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.

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