



### Type: PR 315 4D

Calendered, rigid PVC film. The film complies with the guideline 2002/72 EC ("Clearance Certificate for items used in contact with foodstuffs") as well as with 94/62 EC ("Packaging and Packaging waste").

#### Characteristics

Opaque rigid PVC film, impact modified. Special grade for offset UV and digital\* printing. Also suitable for all other common printing methods.

\* upon request

Surface finish	gls/gls (2020)	gls/hgl (202E)	gls/smt (2030)	smt/cmt (3040)	mtt/gls (5020)	mtt/smt (5030)	mtt/cmt (5040)	mtt/mtt (505R)	xxm/xxm (6060)
Thickness range (mm)	0,100 - 0,700	0,150 - 0,700	0,100 - 0,300	0,150 - 0,300	0,120 - 0,500	0,120 - 0,300	0,120 - 0,300	0,120 - 0,700	0,200 - 0,800

#### Embossings \*\*

Fine Promatt Grob 1 Grob 2

Roughness (Rz µm)	3 - 6	6 - 9	10 -14	20 - 30

\*\* further embossings upon request

#### Colours

Standard : white 1522, white 1305 (extra opaque)  
Colours according to the colour swatch

Properties	Value		Unit	Test method
<b>Thickness tolerances</b> < 0,200 mm 0,200 – 0,400 mm > 0,400 mm	± 10 ± 7 ± 5		%	DIN 53370 (95% of all measurements)
<b>Density</b>	1,34 ± 0,01 (without pigments)		g/cm <sup>3</sup>	DIN 53479
<b>Tensile impact strength</b>	> 600 (surface gls/gls)		kJ/m <sup>2</sup>	DIN EN ISO 8256
<b>Tensile strength</b>	> 42		N/mm <sup>2</sup>	DIN EN ISO 527-1-3
<b>Vicat softening point</b>	77 ± 2		°C	DIN EN ISO 306 procedure VST/B50 as pressed sheet
<b>MD expansion due to heat ***</b> < 0,200 0,200 – 0,400 mm > 0,400 mm	(gls/gls) max.- 7 max.- 5 max.- 4	(mtt/mtt) max.-12 max.- 8 max.- 7	%	In accordance to DIN 53377 (140°C/10 min)
*** + 3% in case of embossed films				
<b>Surface tension</b>	gls/gls (2020) mtt/mtt (505R) mtt/mtt (505R)	≥ 32 both sides ≥ 38 roll-sides ≥ 36 air-side	mN/m (dynes/cm)	In accordance to DIN 53364 measured with inks (pens)

#### Processing advice:

To avoid static, the film should be processed at room temperature of 20 to 23° and a relative humidity between 50 – 60 %.

#### Storage condition

We recommend storing in original packaging at room temperature below 30°C not directly exposed to sun light and humidity. After transport and storage in cold temperature, acclimatisation of 1 hour per cm reel diameter or stacking height is necessary.