

## Technical Informations of Classic Digital OPP 36 μm

Co-extruded, biaxially oriented, slippery and non-sealable polypropylene film pretreated with corona on both sides, with a matte, scratch-resistant special coating on the surface, designed for finishing high quality printing products using commercial laminating adhesives.

**Prior to each and any treatment or processing of the film, the customer is obliged to perform pre-tests under original production conditions in accordance with the form sheet Test and Processing Recommendations.** Damages resulting from the fact that the Customer did not or not properly carry out such mandatory pre-tests shall be borne by the Customer.

Properties	Test/Method/Standard	Value	Unit
Thickness	DINEN ISO 534	36	μm
Substance/Grammage	ISO 536	23,30	g/m <sup>2</sup>
Yield	DIN 53375	46,08	m <sup>2</sup> /kg
Tensile Strength at Break MD	ASTM D882	58,4	N/mm <sup>2</sup>
Tensile Strength at Break TD	ASTM D882	123,7	N/mm <sup>2</sup>
Elongation at Break MD	ASTM D882	186	%
Elongation at Break TD	ASTM D882	98	%
Gloss Angle of Incidence/Observation 60°/60°	ASTM D2457	7-8	GE
Haze	ASTM D1003	89,7	%
Surface Tension	DIN 55660-2	46	mN/m

MD = Main Direction

TD = Transverse Direction

DIN = Deutsche Industrie Norm [German Industry Norm]

GE = Gloss Units

DIN EN ISO

= German, European and International Standard

ASTM

= American Test Method

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# Test and Processing Recommendations

Due to the great variety of materials available today and the wide range of processing machines and their respective setting parameters, can only provide Recommendations here which must then, however, be tested in each individual case under original production conditions.

Prior to each and any treatment or processing of laminating film, for instance, without limitation, UV varnishing, hot foil stamping or cold foiling, adhesive bonding, creasing, grooving, blind embossing, die cutting, pocket sealing or pocket welding, the Customer has to perform an aptitude test using the original materials under original production conditions.

When laminating with film, the Customer has to ensure that in the event of any defects in the film (for instance, without limitation, wrinkling, stains or imperfections), the production will be stopped without delay in order to avoid damages or consequential costs.

Laminating film can be processed with a maximum Kalander temperature of not more than 115 degrees Celsius (239 degrees Fahrenheit), the storage temperature must never be less than 10 degrees Celsius (50 degrees Fahrenheit) and never be more than 45 degrees Celsius (113 degrees Fahrenheit).

When working with wet laminating film, the Customer has to use an adequate adhesive which ensures an always sufficient adhesion to the film.

When using thermal laminating film, the Customer has to verify throughout each job that a sufficient compound adhesion to the substrate to be laminated exists. If necessary, processing parameters, such as, for instance, temperature, contact pressure and speed must be varied from time to time. In the event that the surface wettability of the substrate to be laminated is particularly poor, the Customer might be required to use another laminating procedure or to improve the surface wettability beforehand, for instance, without limitation, by corona treatment or use of a primer.