



<p>QUALITY ASSURANCE</p>	<p><b>SUPPLIER SPECIFICATIONS</b></p>		<p>IML</p>
<p><b>SUPPLY OF « I.M.L. » CAST PP FILMS FOR PRINTING ON ROTARY MACHINES OR SHEET FED</b></p>		<p>Identification : 1/7</p>	<p>Updated <b>March, 12- 2010</b></p>

## EUROPEAN CUSTOMERS

<u>"PROPYPLAST" SUPPLIER</u>	<u>CUSTOMER:</u>
<p><u>Approved by :</u> G.LAURENT</p>	<p><u>Approved by :</u></p>
<p><u>Function :</u> Quality/R&amp;D Responsible</p>	<p><u>Function :</u></p>
<p><u>Date :</u> March,12- 2010</p>	<p><u>Date :</u></p>
<p><u>Signature :</u></p>	<p><u>Signature :</u></p>

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## 1. FIELD OF APPLICATION

The following specifications apply to the « IML » cast PP films supplied by PROPYPLAST :

- LMG C      LMG W12
- LME C      LME W
- SPC SC C    SPC SC W
- SPC MSA    SPC MSB

Application : « in mould labelling ».

These specifications concern :

- a)- the use of our film in reels on rotary printing machines ( equipped with «FIFE » system and with an on-line Corona treatment station )
- b)- the use in a « sheet-fed » printing machine ( equipped with Corona treatment )

The inks must be suitable for the polypropylene film printing.

## 2. CHARACTERISTICS OF THE POLYPROPYLENE FILM

### 2.1. Thickness :

Thickness tolerances : nominal thickness +/- 5%

### 2.2. Weight :

« LMG C 82 » : 73.9 gr/m <sup>2</sup> (+ / - 5% )	« LMG W12 82 » : 77.6 gr/m <sup>2</sup> (+ / - 5% )
« LME C 75 » : 67.6 gr/m <sup>2</sup> (+ / - 5% )	« LME W 75 » : 70.2 gr/m <sup>2</sup> (+ / - 5% )
« LMG C 100 » : 90.2 gr/m <sup>2</sup> (+ / - 5% )	« LMG W12 100 » : 94.7 gr/m <sup>2</sup> (+ / - 5% )
« SPC SC C 60 » : 54.1 gr/m <sup>2</sup> (+ / - 5% )	« SPC SC W 60 » : 56.8 gr/m <sup>2</sup> (+ / - 5% )
« SPC MSA 150 » : 137.7 gr/m <sup>2</sup> (+ / - 5% )	« SPC MSB 150 » : 141.1 gr/m <sup>2</sup> (+ / - 5% )

### 2.3. Appearance of film :

The film must not contain foreign bodies, perforations ( holes, film breaks ), scratches leading to a break in the continuity of the Corona treatment, soiling.No blocking ( welding ) on the reels.

### 2.4. Mechanical properties :

Refer to the product data sheets

### 2.5. Printability :

The « IML » film have only one printable side ( this side is marked with a red label )

An on-line Corona treatment is carried out in order to produce a printable film.

This treatment is checked after the extrusion and its value is minimum 48 dynes/cm.

This Corona treatment is not guaranteed on a long term basis and varies depending on the storage conditions.

For this reason, and before any use, the level of the Corona treatment on the printable side must be checked by the user.

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When « reverse printing » is used, PROPYPLAST's films are not guaranteed for « in-mould labelling ». For this application, the printer has the responsibility to check that the printing will not disturb the welding of the label during injection. The printer must also contact PROPYPLAST in order to determine which film could be used.

### **2.6. Coupling joints :**

Joints are made with a coloured adhesive tape ( minimum 5 cm wide )

These joints have the following characteristics :

- no extra thickness ( to avoid any blanket damage )
- reels with a diameter of 785 mm might have 2 connections maximum

### **2.7. Running meters per reel :**

	LMG C 82 LMG W12 82	LMG C 100 LMG W12 100	LME C 75 LME W 75	SPC SC 60 SPC SC W 60	SPC MSA 150 SPC MSB 150
External diameter about 785 mm	5500 ml	4600 ml	5900 ml	7660 ml	3000 ml
External diameter about 730 mm	4950 ml	3980 ml	5260 ml	6800 ml	2650 ml

### **2. 8. Electrostatic charging :**

The electric charge of the reel ( measured during unwinding ) is  $\leq 5$  kV/m


## **3. REEL PACKAGING**

### **3.1. Dimension of the reels :**

- Width : tolerance +1 mm – 2 mm
- Length of core : width +/- 1 mm
- Internal core diameter: 152 mm ( 6'' )
- External core diameter: 175 mm

### **3.2. Edges :**

Edge flatness: width +/- 2 mm.

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#### 4. IDENTIFICATION

##### 4.1. Reel :

Each reel has 2 types of label :

##### A- Identification label:

- 1 inside the core
- 1 on the reel itself

**The colour of the label depends on the product reference.**

Here below the informations on the labels:

- Reel number
- Extrusion date
- Product reference
- Thickness
- Width
- Running meters
- Customer's order number
- Customer's article number
- Propyplast's order number


Here below a standard reel label :

BOBINE :	
QUALITE :	
EPAISSEUR :	LAIZE :
CDE :	AR :
N°CODE :	
FACE IMPRIMABLE :	
QUANTITE :	
DATE :	

##### B- Label indicating the printable side:

Here below a standard label ( red colour )

<b>PRINTABLE SIDE</b>
<b>BEDRUCKBARE SETTE</b>
<b>FACE IMPRIMABLE</b>
<b>CARA IMPRIMIBILE</b>

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**4.2. Pallet :**

**Each pallet is identified with a label ( on each side of the pallet ).**


**This label, sticked on the right top of the pallet, contains :**

- Product reference
- thickness
- pallet number
- number of reels
- extrusion date
- width
- total running meters
- Customer's order number
- Propyplast's order number

**The colour of the label depends on the product reference.**

Here after a standard pallet label

DOCF033
<b>FICHE D'IDENTIFICATION</b>
N° COMMANDE : N° AR : REFERENCE : QUALITE : Epaisseur (microns) : Largeur (mm) : Face imprimable : Quantité : N° palette : Nombre de bobines : Date de fabrication :
<div style="border: 1px solid black; padding: 5px; display: inline-block; width: 80%;"> Produit conforme </div> <div style="border: 1px solid black; padding: 5px; display: inline-block; width: 15%; margin-left: 10px; vertical-align: middle;"> visa opérateur </div>

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### 5- PALLETIZATION

- 1 reel per pallet
- wood endplates + plastics cups ref. EMB-COU-01213
- 2 pallets wrapped together ( one pallet on the top of the other )

Pallet 800 x 1200 mm : « EUROPALLET » type

Pallet 800 x 1600 mm : see picture



The reels are packed on wood endplates with plastic cups.  
The pallet is wrapped with transparent film in order to enable the inspection at reception.

The palletization depends on the size of the reels. The maximum height of the pallets is 1.95 m