



QUALITY ASSURANCE	SUPPLIER SPECIFICATIONS		IML
SUPPLY OF « I.M.L. » CAST PP FILMS FOR PRINTING ON ROTARY MACHINES OR SHEET FED		Identification : 1/6	Updated Feb. 1 st -2011

CUSTOMERS OUTSIDE EUROPE

<u>"PROPYPLAST" SUPPLIER</u>	<u>CUSTOMER:</u>
<u>Approved by :</u> G.LAURENT	<u>Approved by :</u>
<u>Function :</u> Quality/R&D Responsible	<u>Function :</u>
<u>Date :</u> February, 1 st -2011	<u>Date :</u>
<u>Signature :</u>	<u>Signature :</u>

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<p>SUPPLY OF « I.M.L. » CAST PP FILMS FOR PRINTING ON ROTARY MACHINES OR SHEET FED</p>		<p>Identification : 2/6</p>	<p>Updated Feb. 1st-2011</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
- LMG® C DIG LMG® W DIG
- 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 ² (+ / - 5%)	« LMG® W12 82 » : 77.6 gr/m ² (+ / - 5%)
« LMG® C DIG 82 » : 73.9 gr/m ² (+ / - 5%)	« LMG® W DIG 82 » : 77.6 gr/m ² (+ / - 5%)
« LME C 75 » : 67.6 gr/m ² (+ / - 5%)	« LME W 75 » : 70.2 gr/m ² (+ / - 5%)
« LMG® C 100 » : 90.2 gr/m ² (+ / - 5%)	« LMG® W12 100 » : 94.7 gr/m ² (+ / - 5%)
« LMG® C DIG 100 » : 90.2 gr/m ² (+ / - 5%)	« LMG® W DIG 100 » : 94.7 gr/m ² (+ / - 5%)
« SPC SC C 60 » : 54.1 gr/m ² (+ / - 5%)	« SPC SC W 60 » : 56.8 gr/m ² (+ / - 5%)
« SPC MSA 150 » : 137.7 gr/m ² (+ / - 5%)	« SPC MSB 150 » : 141.1 gr/m ² (+ / - 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.

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

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 might have 2 connections maximum

2.7. Running meters per reel : External reel diameter about 730 mm (28,7 inches)

LMG® C 82 LMG® W12 82 LMG® C DIG 82 LMG® W DIG 82	LMG® C 100 LMG® W12 100 LMG® C DIG 100 LMG® W DIG 100	LME C 75 LME W 75	SPC SC 60 SPC SC W 60	SPC MSA 150 SPC MSB 150
4950 ml (16240 lineal feet)	3980 ml (13058 lineal feet)	5260 ml (17257 lineal feet)	6800 ml (22310 lineal feet)	2650 ml (8694 lineal feet)

2. 8. Electrostatic charging :

The electric charge of the reel (measured during unwinding) is ≤ 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
excepted LMG® C DIG and LMG® W DIG : 76 mm (3'') External core diameter : 81 mm


3.2. Edges :

Edge flatness: width +/- 2 mm.

4. IDENTIFICATION

4.1. Reel :

Each reel has 2 types of label :

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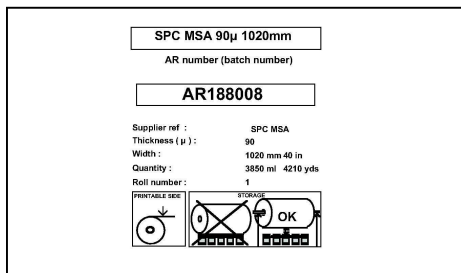
A- Identification label:

- 1 inside the core
- 1 on the reel itself

Here below the informations on the labels:

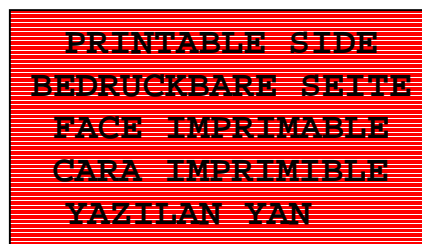
- Reel number
- Product reference
- Thickness
- Width
- Running meters
- Propyplast's order number

Here below a standard reel label :



B- Label indicating the printable side:

Here below a standard label (red colour)



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

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- width
- total running meters
- Propyplast's order number

Here after a standard pallet label

DOCF091 A

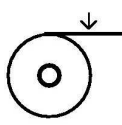
SPC MSA 90 μ 1020mm

AR number (batch number)

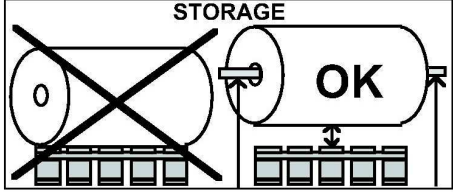
AR188008

Supplier ref :	SPC MSA	
Thickness (μ) :	90	
Width :	1020 mm	40 in
Quantity :	3850 ml	4210 yd
Pallet number :	1	
Number of rolls :	1	

PRINTABLE SIDE



STORAGE



Extrusion date : 05/11/2008

Conformity checked by : Signatory

5- PALLETIZATION

- Fumigated pallet (according « NIMP15 ») : dimensions 770 mm x 1170 mm
- wood endplates 750 x 750 mm
- plastics cups ref. EMB-COU-01213