

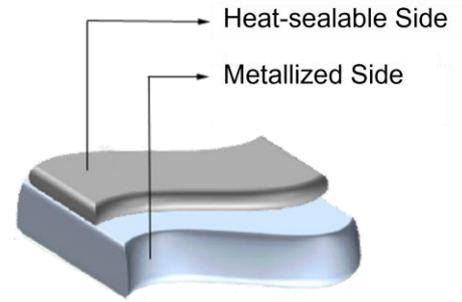


Trading Films

PRODUCT PLA. METALLIZED AND HEAT SEALABLE

REFERENCE 9004

DESCRIPTION



The **9004** reference is a bioriented polylactic acid film metallized on one side and heat-sealable on the side; with an initial sealing temperature of 82°C. Special for **printing and lamination** in flexible packaging applications in general. Thicknesses available in 20 and 30 microns.

VALUES

PROPERTIES	Unit	Test Method	20	30	
PHYSICAL PROPERTIES					
Unit weight	g/m ²	ASTM-D-4321	24.8	37.2	
Average Yield	m ² /Kg	ASTM-D-4321	40.3	26.9	
MECHANICAL PROPERTIES					
Tensile strength	MD TD	N/mm ²	ASTM-D-882	65.5 58.6	65.5 58.6
Modulus young	MD TD	N/mm ²	ASTM-D-882	2551 2413	2551 2413
SURFACE					
COF	Static Dynamic	-	ASTM D 1894	0.30 0.25	0.30 0.25
BARRIER PROPERTIES					
WVTR: 38°C, 90% RH OTR: 23°C, 0% RH	gr/m ² day Cc/m ² day	ASTM-F1249 ASTM-D3985	<1.3 <7.8	<1.3 <7.8	
OPTICAL PROPERTIES					
Target Optical Density	O.D	AIMCAL TP-101-78	2.5	2.5	
HEAT SEALING PROPERTIES					
sealing strength	Gf/cm	Internal	1100	1100	
Seal initiation	deg C	Internal	82	82	
Hot tack at 121°C	Gf/cm	Internal	390	390	



T r a d i n g F i l m s

KEY TRAITS

- PLA metallized on 1 side and heat-sealable on the side.
- Good mechanical properties
- Good stiffness
- Good barrier to oxygen
- Excellent transmission to water vapor
- Good sliding properties
- Resistant to oil, grease and alcohol
- Excellent twist retention properties.
- Biodegradable into carbon dioxide, water and biomass by digestion microbes.
- Complies with DIN EN 13432 (7H0052) for compostable products and with ASTM D6400
- In compliance with European food contact regulations and with the FDA

APPLICATIONS AND RECOMENDATIONS

The **9004** reference is a polylactic acid film specially designed for lamination and printing applications for the flexible packaging sector, a specific product for gravure and flexography printing. It can be used on both horizontal (HFFS) and vertical (VFFS) packaging machines.

Ethyl acetate solvents should be avoided because it can start a degradation process until the total disintegration of the PLA. It must be kept in the warehouse at temperatures below 30°C to minimize the deterioration of some of the properties of the film. The film must be conditioned in the operating environment at least 24 hours before use. The film must be used up to six months after the production date.