

# Propafilm™ MLT80

Polypropylene Alloy

Innovia Films Ltd.

## Message:

High Speed Overwrapping Film

Biaxially oriented polypropylene (BOPP) film co-extruded on both sides with heat sealable polyolefinic copolymers.

MLT80 is generally used for high speed overwrapping of packets and cartons. Particularly suitable for use in the tobacco industry.

General Information			
Features	Flavor & Aroma Barrier		
	Food Contact Acceptable		
	Good Heat Seal		
	Good Processability		
	Moisture Barrier		
	Moisture Resistant		
	Pleasing Surface Appearance		
	Slip		
Uses	Bi-axially Oriented Film		
	Packaging		
Agency Ratings	FDA 21 CFR 177.1520		
Forms	Film		
Processing Method	Coextrusion		
Physical	Nominal Value	Unit	Test Method
Molding Shrinkage			Internal Method
Flow : 120°C, 1 min	5.0	%	
Flow : 130°C, 1 min	7.0	%	
Across Flow : 120°C, 1 min	4.0	%	
Across Flow : 130°C, 1 min	7.0	%	
Mechanical	Nominal Value	Unit	Test Method
Coefficient of Friction			ASTM D1894
vs. Itself - Dynamic, Outside/Outside	0.30		
vs. Itself - Static, Outside/Outside	0.40		
Films	Nominal Value	Unit	Test Method
Secant Modulus <sup>1</sup>			ASTM D882
1% Secant, MD	2900	MPa	
1% Secant, TD	2900	MPa	
Tensile Strength <sup>2</sup>			ASTM D882
MD : Yield	190	MPa	
TD : Yield	190	MPa	

Tensile Elongation <sup>3</sup>			ASTM D882
MD : Break	110	%	
TD : Break	100	%	
Seal Strength <sup>4</sup>	0.15	N/mm	Internal Method
Seal Initiation Temperature <sup>5</sup>	110 to 146	°C	Internal Method
Oxygen Permeability (23°C, 0% RH)	43	cm <sup>3</sup> ·mm/m <sup>2</sup> /atm/24 hr	ASTM F1927
Water Vapor Transmission Rate			ASTM F1770
23°C, 85% RH	1.1	g/m <sup>2</sup> /24 hr	
38°C, 90% RH	6.0	g/m <sup>2</sup> /24 hr	
Blocking Load <sup>6</sup>	6.0	g	Internal Method
Film Gauge	80.0		Internal Method
Yield	54.9	m <sup>2</sup> /kg	Internal Method
Optical	Nominal Value	Unit	Test Method
Gloss (20°)	130		ASTM D2457
Haze <sup>7</sup>	1.3	%	ASTM D1003
NOTE			
1.	10%/min		
2.	50%/min		
3.	50%/min		
4.	248°F; 2secs; 15lb/in <sup>2</sup>		
5.	2secs; 15lb/in <sup>2</sup>		
6.	158°F; 200g; 2hrs		
7.	Wide angle, 2.5°		

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