

# INTEGRAL™ D305

Polyolefin Adhesive Film

The Dow Chemical Company

## Message:

INTEGRAL™ D305 Packaging Film is a multi-layer film designed for liquid pouch packaging. The liquid contact layer is specifically designed to provide an attractive combination of excellent sealing characteristics with low taste and odor contribution when using ozone purification methods. It is available as 2 - 3 mil, medium slip, natural color, TX (untreated) in widths of 20 - 38 in and 52 - 70 in.

General Characteristics:

Heat Activation Temperature: 210°F (99°C)

Yield: 207 sq ft./lb/mil (42.4 m²/kg/25 µm)

Thickness: 2.0 - 3.0 mil (51 - 76 µm)

Width: 20 - 38 in; 52 - 70 in (508 - 965 mm; 1320 - 1780 mm )

Color: Clear

Treat: TX (untreated)

General Information			
Additive	Medium Slip		
Appearance	Clear/Transparent		
Forms	Film		
Films	Nominal Value	Unit	Test Method
Film Thickness - Tested	61	µm	
Film Thickness - Recommended / Available	2.0-3.0 mil (51-76 µ)		
Secant Modulus			ASTM D882
2% Secant, MD : 61 µm	400	MPa	
2% Secant, TD : 61 µm	386	MPa	
Tensile Strength			ASTM D882
MD : Yield,61 µm	17.2	MPa	
TD : Yield,61 µm	18.6	MPa	
MD : Break, 61 µm	28.3	MPa	
TD : Break, 61 µm	26.2	MPa	
Tensile Elongation			ASTM D882
MD : Break, 61 µm	600	%	
TD : Break, 61 µm	700	%	
Dart Drop Impact (61 µm)	100	g	ASTM D1709
Elmendorf Tear Strength			ASTM D1922
MD : 61 µm	220	g	
TD : 61 µm	1300	g	
	132.08 to 177.80		
Film Width	50.80 to 96.52	cm	
Heat Seal Strength <sup>1</sup>			ASTM F88
MD : 61.0 µm	860	N/m	

TD : 61.0 $\mu\text{m}$	740	N/m
Yield (25.0 $\mu\text{m}$ )	42.4	$\text{m}^2/\text{kg}$
Heat Activation Temperature	99	$^{\circ}\text{C}$
Optical	Nominal Value	Test Method
Gloss		ASTM D2457
60°, 61.0 $\mu\text{m}^2$	80	
60°, 61.0 $\mu\text{m}^3$	70	
Clarity (61.0 $\mu\text{m}$ )	12.0	ASTM D1746
NOTE		
1.	Heat seal conditions of 350°F (177°C), 30 psi (207 kPa), 1 second dwell time.	
2.	Inside skin	
3.	Outside adhesive skin	

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