



ICM PLASTICS PVT.LTD., DAMAN
Title
TECHNICAL DATA SHEET

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| Eff. Date | : 01.07.2015 |
| Rev. No. | : 01 |
| Issue No. | : 01 |
| Doc. No. | : ICMPL/QCC/05 |

RIGID PVC FILM (250 Mic.)
(Non Toxic Food/Pharma Grade Material)

Color Range: Clear, Amber, Blue, Green, Orange, Peach, Red, White Opaque, Yellow & other colors upon request

Technical Data:

| Sr.No. | Properties | Test Method | Unit | Specification |
|--------|--|---------------------|---------------------------|--------------------------------------|
| 1 | Color & Appearance | In-house | --- | As per standard sample |
| 2 | Thickness of Rigid PVC film | DIN 53370 | microns | 250 ± 10% |
| 3 | GSM of Rigid PVC film | DIN EN ISO 2286 | gm/m ² | 340 ± 10% |
| 4 | Dimensional Changes Longitudinal (shrinkage) Transversal (expansion) | ASTM D1204 | % | - 7.0 + 2.0 |
| 5 | Dart Impact Strength (from height of 1.52 mtrs) | ASTM D1709 | gm | 350 min. |
| 6 | Tensile Strength Longitudinal Transverse | ASTM D882 | kg/Sq.cm | 450 min. 450 min. |
| 7 | Elongation at Peak Load Longitudinal Transverse | ASTM D882 | % | 4 min. 4 min. |
| 8 | WVTR @ 38°C & 90% RH | ASTM F1249 | gm/m ² /24 hr. | 2.4 max |
| 9 | OTR @ 23°C & 0% RH | ASTM D 3985 | cc/m ² /24 hr. | 15 max. |
| 10 | Forming Temperature | In-house | °C | 110 -170 |
| 11 | Toxicity Test | USP Current Edition | - | Non-toxic |
| 12 | Residue VCM | ASTM D 3749 | ppm | 1 max |
| 13 | Identification - PVC | FTIR | - | As per Standard FTIR spectrum Passes |
| 14 | Heat Seal Strength | In-house | Kg/cm | 0.30 min. |
| 15 | Global migration | 2005/79/EC | ppm | < 60 |
| 16 | Inner Diameter of Core | In-house | mm | 76 +/- 1 |
| 17 | Width | In-house | mm | +/- 1 |



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Regulatory Compliances:

- Commission Directive 2005/79/EC (including amendment 2004/19/EC): Plastic material and articles in contact with Food Regulations.
- Commission Directive 94/63/EC (including amendment 2004/12/EC): Packaging and packaging waste (providing limits in the heavy metal content)
- Council Directive 78/142/EEC – Specifying limit of vinyl chloride monomer content.
- European Pharmacopoeia – 3.1.11 (Current Edition) – Containers for Dry Dosage Forms for Oral Administration
- European Pharmacopoeia – 3.2.2 (Current Edition) – Plastic Containers and Closures for Pharmaceutical Use
- USP 661 (Current Edition) – Containers for Non-Sterile Solid & Liquid Dosage Forms.
- 21CFR Part 177 – Indirect Food Additives: Polymers – Applicable for PVC film.
- The additives used in these films comply with the quantitative and qualitative requirements of EC and 21 CFR Part 177.