



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

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

PVdC coated PVC FILM (DUPLEX)
(0.25 PVC X 90 GSM)
(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	Total Thickness	DIN 53370	microns	305 ±10%
3	Thickness of Rigid PVC film	DIN 53370	microns	250 ±10%
4	Total GSM	DIN EN ISO 2286	gm/m ²	430 ±10%
5	GSM of Rigid PVC film	DIN EN ISO 2286	gm/m ²	340 ±10%
6	GSM PVdC coating	DIN EN ISO 2286	gm/m ²	90 ±3
7	Dimensional Changes Longitudinal (shrinkage) Transversal (expansion)	ASTM D1204	%	-7 max. +2 max.
8	Dart Impact Strength (from height of 1.52 mtrs)	ASTM D1709	gm	350 min.
9	Tensile Strength Longitudinal Transverse	ASTM D882	kg/Sq.cm	450 min.
10	Elongation at Peak Load Longitudinal Transverse	ASTM D882	%	5 min.
11	WVTR @ 90% RH & 38°C	ASTM F1249	gm/m ² /24 hr.	0.40 max
12	OTR @ 23°C & 0% RH	ASTM D 3985	cc/m ² /24 hr.	1.5 max.
13	Forming Temperature	In-house	°C	110 -170
14	Toxicity Test	Current USP	-	Non-toxic



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15	Residue VCM	ASTM D 3749	ppm	1 max
16	Identification - PVC Identification - PVdC	FTIR Morpholin	-	As per Standard FTIR spectrum Passes Color of PVdC layer should turn brown
17	Heat Seal Strength	In-house	Kg/cm	0.30 min.
18	Global migration	2005/79/EC	ppm	< 60
19	Inner Diameter of Core	In-house	mm	76 +/- 1
20	Width	In-house	mm	+/- 1

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 PVdC coated PVC film.
- The additives used in these films comply with the quantitative and qualitative requirements of EC and 21 CFR Part 177.