



ICM PLASTICS PVT.LTD., DAMAN  
Title  
TECHNICAL SPECIFICATION

Doc No	: ICM/SP/FG
Issue No.	:01
Revision No.	:00
Effective Date	:01.10.2013
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Review Date	:01.10.2015

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**TRIPLEX**  
**PVdC coated PVC-PE film**  
(Non Toxic Food/Pharma Grade Material)

**Color Range:** Clear & other colors upon request

**Complex :** 200/25 X 60 gsm

**Technical Data:**

Sr.No.	Properties	Test Method	Unit	Specification
1	Color & Appearance	In-house	---	As per standard sample
2	Total Thickness	DIN 53370	microns	260 ± 7%
3	Thickness of Rigid PVC film	DIN 53370	microns	200 ± 7%
4	Thickness of PE	DIN 53370	microns	25 ± 7%
5	Total GSM	DIN EN ISO 2286	gm/m <sup>2</sup>	355 ± 7%
6	GSM of Rigid PVC film	DIN EN ISO 2286	gm/m <sup>2</sup>	272 ± 7%
7	GSM PVdC coating	DIN EN ISO 2286	gm/m <sup>2</sup>	60 ± 3
8	Dimensional Changes Longitudinal (shrinkage) Transversal (expansion)	ASTM D1204	%	-7 max. +2 max.
9	Dart Impact Strength (from height of 1.52 mtrs)	ASTM D1709	gm	350 min.
10	Tensile Strength Longitudinal Transverse	ASTM D882	kg/Sq.cm	450 min. 450 min.
11	Elongation at Peak Load Longitudinal Transverse	ASTM D882	%	5 min. 5 min.
12	WVTR @ 90% RH & 38°C	ASTM F1249	gm/m <sup>2</sup> /24 hr.	0.4 max



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**(Non Toxic Food/Pharma Grade Material)**

Sr.No.	Properties	Test Method	Unit	Specification
13	Forming Temperature	In-house	°C	110 –170
14	Toxicity Test	USP Current Edition	-	Non-toxic
15	Identification - PVC Identification - PVdC	FTIR Morpholin	-	As per Standard FTIR spectrum Passes Color of PVdC layer should turn brown
16	Heat Seal Strength	In-house	Kg/cm	0.30 min.
17	Global migration	2005/79/EC	ppm	< 60
18	Inner Diameter of Core	In-house	mm	76 +/- 1
19	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/PE film.
- The additives used in these films comply with the quantitative and qualitative requirements of EC and 21 CFR Part 177.