

Ref. **OPALINE**Gamme **Opalescent**Embossing (Top/Underside) **Sand / Pearl**Aspect (Top/Underside) **Matt / Satin**

Composition

- Polypropylene sheet.
- Halogen free, no substances that can damage the ozone layer.
- Inert waste, nontoxic and 100% recyclable.
- Decomposition products by fire: carbon dioxide, vapor.

Chemical properties

- Resistant to water, fats, alcohols and detergents.

Physical properties

| Properties | Unité | Test | Valeur* | Tolérances |
|---------------------|-------------------|----------------------------------|-------------|----------------------------|
| Thickness | µm | ISO 4593 | 270 to 2000 | +0,02mm / -0,03mm |
| Density | g/cm ³ | In house water immersion testing | 0,91 | +/- 0,01 g/cm ³ |
| Tensile Impact test | KJ/m ² | ISO 8256 Tested on 500µm | 274 | |
| Elmendorf Tear | mN | ISO 1974 Tested on 500µm | 6003 | |

*These values are given as indicative for a standard quality and based on the standards mentioned.

The physical properties of the material will change with the temperature conditions. Near or below 0°C, the material will become brittle.

Therefore, for low temperature applications, please contact us for a specific product. As a thermoplastic, the material may lose stiffness, with increasing temperatures. It may also swell. These changes are noticeable around 70°C.

The Melting point of our product is around 140°C.

Sheets size tolerance

Sheet size: 0/+5mm (machine and cross direction)
option of guillotine trimming

Sheet flatness: 5mm recto/verso

Use conditions

- Acclimatization at room temperature 24 to 48h before use

Printing on Priplak®

Printing UV technology

- Priplak® is corona treated on both sides to enable it to be printed in UV offset, UV screen, and UV digital.
- At the time of production, the surface energy is above 46 dynes/cm - but this declines over time. We guarantee a minimum surface tension of 42 dynes for 12 months. We recommend that Priplak® is printed within 6 months from the date of production - for embossed grades, and 3 months for gloss products. (Exact production date is on the label). Keeping the material in its original wrappers and stored in a place without wide variations in temperature - or high humidity is very important. We recommend testing the suitability of the material prior to printing.
- Our products are treated with an antistatic agent to help with feeding and reduce dust.
- Priplak recommends special inks for polypropylene. Details can be obtained from your ink supplier. Preliminary trials/testing are advised.
- In order to protect the print and to prevent ink scratching, we recommend that you apply a protective varnish especially for UV offset.

Other printing technology

Conventional screen (1 pack or 2 packs inks.) Priplak® can be printed with a surface tension below 40 dyne/cm. It is recommended to test before printing.

Ref. OPALINE

Gamme Opalescent

Embossing (Top/Underside) Sand / Pearl

Aspect (Top/Underside) Matt / Satin

Cutting / Creasing on Priplak®

- Priplak recommends converting the material at temperature around 20°C.
- Cutting and creasing are possible on manual and auto-platens, as used in the cardboard industry. Creasing is mainly done "cold", i.e. normal working conditions. It can also be done with heat for high thickness or special cases.
- Use of semi-cutting blades for creasing is not advisable for Priplak® because they may generate an initial tear.
- In any case, the creasing process lengthens the material, and it is necessary to take this into account during the tooling design and manufacture.
- Cutting Priplak® in smaller sizes than delivered, especially A4 size and smaller, can release tension within the sheet, that can cause curl.

Assembling

- Priplak® can be glued, riveted, punched, perforated, sewn, ultrasonic / hot air welded...
- For glueing, we recommend 2 different types:
 - hot melt polyurethane reactive (PUR)
 - cyanoacrylates
- If Priplak® is in contact with printed surfaces (Priplak® used as cover) or laminating, we recommend that you test Priplak® compatibility with the other products involved. Indeed, some glue components, and inks containing a proportion of aliphatic or aromatic hydrocarbons, used in paper printing, can generate curl when in contact with Priplak®.

Compliance with legislation

| Colour | Toys standard EN 71/3 (2021) | Food regulation (EU) N°10/2011 | Coneg regulation Directive 1994/62/CE | RoHS Directive 2011/65/EU |
|----------------|---------------------------------|-----------------------------------|--|------------------------------|
| Natural 000 | ✓ | ✓ | ✓ | ✓ |
| Lemon 122 | ✓ | ✓ | ✓ | ✓ |
| Mandarin 219 | ✓ | ✓ | ✓ | ✓ |
| Raspberry 337 | ✓ | ✓ | ✓ | ✓ |
| Dark Blue 413 | ✓ | ✓ | ✓ | ✓ |
| Turquoise 415 | ✓ | ✓ | ✓ | ✓ |
| Light Blue 417 | ✓ | ✓ | ✓ | ✓ |
| Ocean Blue 437 | ✓ | ✓ | ✓ | ✓ |
| Violet 438 | ✓ | ✓ | ✓ | ✓ |
| Lime 509 | ✓ | ✓ | ✓ | ✓ |
| Other colours | please contact us | | | |

✓ Complies with the mentioned standard.

Toys standard: Norm NF EN 71-3 (2021)

Relating to safety of toys – Part 3 : migration of certain elements.

Food regulation: Regulation (EU) N°10/2011 relating to plastics materials and articles intended to come into contact with foodstuffs.

The concept of overall and specific migration is another aspect of the directive, which depends on the product's end-use conditions (type of foodstuffs, temperature, contact time, etc.). This compliance must therefore be tested on the finished product.

Coneg regulation (USA) & Directive 1994/62/CE: Relating to packaging and packaging waste Heavy metals (cadmium, lead, mercury, and chromium (VI)) content below 100ppm.

RoHS - Directive 2011/65/EU : Requirements on the restriction of use of certain hazardous substances in electrical and electronic equipment.

Storage conditions

Store in its original plastic wrapping, at a temperature around 20°C, away from light.

The information contained within this document are non contractual and are based on data given by our suppliers and on the present state of our knowledge. They are given in good faith and considered as correct. The manufacturer reserves the right to change the product, or its technical characteristics, without notice.

However, as we do not control post-processing techniques and conditions of use, this information may not be extended to end products and does not constitute a guarantee for any specific application. So, you are requested to check its validity and suitability for the intended method of converting and application.

PRIPLAK® OPALINE is a registered trademark of PRIPLAK.

Not under controlled distribution

