

Peelable

PPL / PPLA

Data Sheet (November 2021)

Product family Introduction

Nuroll Peelable film is a bi-axially oriented polyester (BOPET) film with an amorphous polyester heat seal layer. It is specially designed for heat sealable lidding application on packaging refrigerated and frozen foods.

Nuroll Peelable film shows also an excellent hot-tack for hot filling process. It can be placed at temperature down to -60°C and up to 200°C , and it is designed for self opening during cooking, when temperature goes over 90°C .

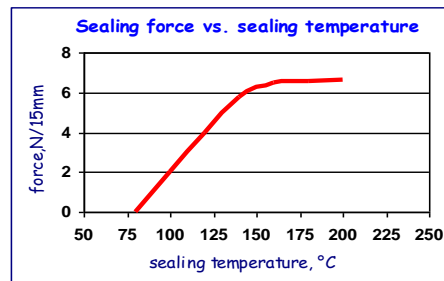
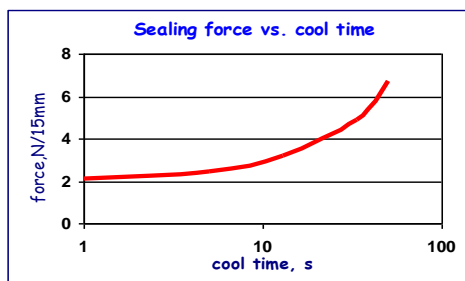
Nuroll Peelable film is dual ovenable, pasteurizable and provides strong, consistent peeling to substrates such as APET, CPET, PETG and PVC in all the usual conditions.

The heat seal layer is available in 2 different thicknesses, $2\mu\text{m}$ (**PPL** grade) and $3,5\mu\text{m}$ (**PPH** grade).

Nuroll Peelable is commercially available also with **anti-fogging** characteristics to assure more clarity and transparency when stored in refrigerators.

Sealing properties

Nuroll Peelable film shows a very good seal immediately after the sealing (hot tack properties), for this reason it represents the right choice for hot filling and MAP packaging applications. Its particular formulation guarantees a good seal without stress the shredding behavior.



Welding force of 23 PPH on different substrates

Welding conditions	Film/Film	Film/Film at 0°C	Film/ CPET (APET layer)	Film/ Cardboard	Film/ Cardboard at 0°C	Film/ 23 μ Film plain
140°C-4bar-1sec	> 6,5	5	5,5	2,5	2,5	2,5
140°C-4bar-2sec	> 6,5	5,5	6,5	3,5	2,5	2,5
140°C-4bar-4sec	> 6,5	5,5	7,5	3,5	2,5	2,5
160°C-4bar-1sec	> 7	6,5	7	3	3	3
160°C-4bar-2sec	> 7	6,5	7,5	3	3	3
160°C-4bar-4sec	> 7	6,5	7,5	4	3	3
190°C-4bar-1sec	> 7	> 7	7	3,5	3,5	4
190°C-4bar-2sec	> 7	> 7	8	4	3,5	4
190°C-4bar-4sec	> 7	> 7	8	4	3,5	4

Specimen structure	N/15 mm
Film/Film	> 6,5
Film/ 50 μ Film plain	5
Film/ Cardboard	3,5
Film/ APET	7,5
Film/ 100% CPET	5

FORCE is measured by INSTRON dynamometer in N Sample dimension is 15 mm width

Cardboard is laminated with BOPET film, cardboard polyester extrusion coated behavior is like CPET

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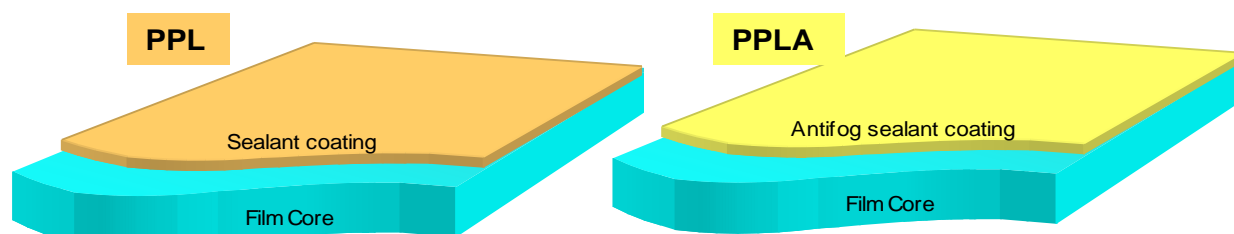
PPL / PPLA

Product description

Nuroll PPL is widely used when good sealability is requested but the tray substrate is not complex and the filling process does not dirt the sealing area (by powder, fats or liquids).

Nuroll PPL is commercially available in nominal thicknesses (plain film) of 23, 36 microns. For different thicknesses it is necessary to agree a minimum order and to full chart the mother roll width.

Nuroll PPL is commercially available also with anti-fogging characteristics (**PPLA**) to assure more clarity and transparency when stored in refrigerators



Main Applications

Cheeses, salted meats, dried food

Technical details

Nuroll PPL/PPLA is usually supplied with following characteristics:

- **Core diameter:** 6 inches (152.76 mm)
- **Film width:** min 400 mm, max 1400mm
- **Film length:** According with film thickness and max external reel diameter 640mm

Film Thickness (microns)	23	36
Standard reel length (m)	8000	4000
		8000

- **Packing presentation** suspended reel; wooden endboards, lid and pallet; stretchable PE film

Different characteristics than the above on request

Storage conditions

Nuroll PPL/PPLA need to be stocked in a close warehouse and preserved from the light and from the humidity.

Reels must be not stacked.

Nuroll will not accept any responsibility for material older than 1 year from the delivery.

Compliance with regulations

Polyester Film produced by Nuroll SpA, complies with EEC, Italian and FDA requirements on packaging for direct contact with foodstuffs

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Properties		Unit	Test Method	Typical values PPLgrade		Typical values PPLA grade	
Base film thickness		Microns	ASTME 252	23	36	23	36
Coating thickness		Microns	ASTME 252	2	2	2	2
Total thickness		Microns	ASTME 252	25	38	25	38
Yield (nominal)		m ² /kg	ASTME 252	29,2	19	29,2	19
		g/m ²		34,2	52,6	34,2	52,6
Tensile strength	MD	N/mm ²	ASTMD 882	230	230	230	230
	TD	kg/inch		13,5	20,5	13,5	20,5
	MD	N/mm ²		240	240	240	240
	TD	kg/inch		14,3	21,8	14,3	21,8
Elongation at Break	MD	%	ASTMD 882	130	140	130	140
	TD			120	130	120	130
Thermal Shrinkage 150°C-30'	MD	%	ASTM 1204	2	2	2	2
	TD			0,5	0,5	0,5	0,5
Haze		%	ASTMD1003	7	8	7	8
MVTR (38°C, 90%RH)		g/m ² *day	ASTME398	25	15	25	15
OTR (20°C, 0%RH)		cc/m ² *day	ASTMD3985	50	35	50	35
Welding force (on itself) 140°C; 4 bar; 4 s		N/15mm	Internal method	5,5	5,5	3,5	3,5

⇒ For thicknesses different than those reported above it is necessary to agree a minimum order and to full chart the mother roll width

1. This information is the best currently available on product and it is subject to revision as additional knowledge and experience is gained.
2. The results obtained and the above properties refer to average value of laboratory tests. Therefore, such results have only to be considered as an indicative general guide to material properties and not as an implied guarantee that the product actually has said properties and/or a warranty of fitness for a particular purposes and/or suggestion for infringement of any existing patents.
3. Due to many factors which may affect customer production process, including but not limited by different equipments and techniques used, PPL-PPLA film must be qualified before being used in any application.