

## TECHNICAL DATA SHEET

### PP Soft Touch Aluminium

**Product name:**

Film customised with the client's branding, and produced in rolls or in pouches:

- Stand-up pouches/Doypacks
- Flat pouches
- Rolls of different lengths with an internal plastic core  
(min 50 mm – max 750 mm)

At the customer's request, the following can be added to the stand-up pouches/Doypacks and flat pouches:

- Plastic (PP) aroma protection/pressure relief valve for ground coffee or coffee beans
- Plastic zip fastening (PP)
- Hole/euro slot
- Spout (PP)

**Constituent materials:**

Laminated aluminium and plastic film (PP inside)

**Composition of multi-layer film – BOPP + Aluminium + PP CAST:**

COMPONENTS	VALUES		
BOPP	14 ± 5 % µm	BOPP	Solvent-less Adhesive
EVA	20 ± 5 % µm	EVA	
AL	9 ± 5 % µm	ALU	
Adhesive	2 ± 5 % g		
PP CAST	80 ± 5 % µm		
TOTAL THICKNESS	123 ± 5 % µm	PP Cast	

\*The thickness and weight of the ink vary depending on the customer's artwork.

**Physical and chemical properties**

PROPERTY	METHOD	UNIT	VALUE (BONDED MATERIAL)
GRAMMAGE	In-house method	g/m <sup>2</sup>	129,62
INITIAL BONDING TEMPERATURE	In-house method	°C x sec	180-190 x 0.20-0.30
WATER VAPOUR PERMEABILITY	ASTM F1249-06	g/m <sup>2</sup> x24h <sub>xatm</sub> 38°C – 90% RH	< 0,05
OXYGEN PERMEABILITY	ASTM F2622-08	cc/m <sup>2</sup> x24h <sub>xatm</sub> 23°C – 0% RH	< 0,05
CO <sub>2</sub> PERMEABILITY	ASTM F2476-05	cc/m <sup>2</sup> x24h <sub>xatm</sub> 23°C – 0% RH	1,8

The values have a tolerance of +/- 5%

**General conditions of use:**

Flexible packaging suitable for contact with food.  
(See declaration of compliance for food contact materials supplied with the product, under general conditions of use).



Recoverable plastic packaging to be collected separately and disposed of following local guidelines.


**Storage:**

- Store the product in a dry, protected, clean place and in closed packages to prevent contamination.
- Store out of direct sunlight and at a temperature not exceeding 30°C and not less than 15°C.

**Filling:**

- Filling capacities are given on the website in the "MARKETS" section ([www.packstyle.com](http://www.packstyle.com)).
- Despite the values reported on the site, it is recommended not to fill the pouches beyond 2/3 of their capacity.
- Allow air to exit before closing and sealing

**Transport:**

- Pack your product carefully. We recommend the use of shock-protective material on the bottom of boxes and sides of envelopes (e.g., bubble wrap or air cushions)

**Forms of packaging and/or protection:**
**Packaging:**

**Pouches:** Plastic cable ties (PP)

**Packing:**

**Pouches:** Cardboard box + plastic air cushions (LDPE)

**Rolls:** Wooden pallet + extensible film (LLDPE) or cardboard box + plastic air cushions (LDPE)

**Applicable framework laws:**
**Food Contact Safety and Compliance**

Reg. (EC) No. 1935/2004, as amended  
Reg. (EC) No. 2023/2006, as amended  
Reg. (EU) No. 10/2011, as amended  
Reg. (EU) No. 351/2025, as amended – updating and modifying Reg. 10/2011/EU  
DPR 777/1982, as amended  
Ministerial Decree (MD) 21 March 1973, as amended  
Legislative Decree (L.D.) 29/2017, as amended

**Environmental Compliance Requirements**

Directive 94/62/EC, as amended  
Legislative Decree (L.D.) 152/2006, as amended  
Legislative Decree (L.D.) 116/2020, as amended  
Reg. (EU) No. 40/2025, as amended