

## TECHNICAL DATA SHEET

### Soft touch Transparent/White Recyclable Polypropylene

#### 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:

Plastic film (PP Cast inside)

#### Composition of recyclable film – BOPP + barrier PP + transparent or white PP cast:

COMPONENTS	VALUES		
BOPP	14 ± 5 % μm	BOPP	
EVA	20 ± 5 % μm	EVA	
Barrier PP	20 ± 8 % μm	Barrier PP	
Adhesive	2 ± 8 % g		Solvent-less Adhesive
PP Cast	80 ± 8 % μm		
TOTAL THICKNESS	134 ± 5 % μm	PP Cast	

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

#### Physical - chemical properties:

PROPERTY	METHOD	UNIT	VALUE (BONDED MATERIAL)
GRAMMAGE	In-house method	g/m <sup>2</sup>	123,43 ± 6%
INITIAL BONDING TEMPERATURE	In-house method	C° x sec.	150/170 x 0,35/0,45
WATER VAPOUR PERMEABILITY (38°C × 90% RHOUT × 0% RHIN)	ASTM F1249	g/m <sup>2</sup> x 24 ore 38°C - 90% RH	2,1 ± 5%
OXYGEN PERMEABILITY	ASTM D3985	cc/m <sup>2</sup> x 24h 23°C – 0% RH	<0,1 ± 5%
CARBON DIOXIDE PERMEABILITY	ASTM F2476	cm <sup>3</sup> /m <sup>2</sup> x 24h 23°C – 0% RH	0,8 ± 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).



Recyclable plastic packaging to be collected separately and disposed of following local guidelines. Recyclable in industrial facilities which may not exist in your area.



### 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:

<i>Packaging:</i>	<i>Packing:</i>
<b>Pouches:</b> Plastic cable ties (PP)	<b>Pouches:</b> Cardboard box + plastic air cushions (LDPE) <b>Rolls:</b> 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