

## TECHNICAL DATA SHEET

### PP Recyclable paper

**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 (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 zip fastening (PP)
- Hole/euro slot

**Constituent materials:**

Laminated paper/plastic film (PP inside)

**Composition of multi-layer film – PAPER + BOPP:**

COMPONENTS	VALUES
PAPER	80 g
Adhesive	2 g
BOPP	15 µm
TOTAL THICKNESS	95 µm
Tolerances	±5%



\*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>	93,65
INITIAL BONDING TEMPERATURE	In-house method	°C x sec	150/160 x 0,20-0,30
WATER VAPOUR PERMEABILITY	ASTM F1249-06	g/m <sup>2</sup> x24h <sub>x</sub> atm 38°C – 90% RH	9,3
OXYGEN PERMEABILITY	ASTM F2622-08	cc/m <sup>2</sup> x24h <sub>x</sub> atm 23°C – 0% RH	0,37
CARBON DIOXIDE PERMEABILITY	ASTM F2476-05	cc/m <sup>2</sup> x24h <sub>x</sub> atm 23°C – 0% RH	1,5

The values have a tolerance of +/- 5%

**General conditions of use:**

Flexible packaging suitable for contact with all types of food, except for fatty foods or foods with fatty substances on the surface.

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



Table 1. Results: recyclability key parameters

Parameter	Unit	Result	Minimum value	Maximum value
Coarse reject	%	23.0	23.0	23.1
Flakes	%	25.4	25.4	25.4
Macrostickies $\varnothing < 2000 \mu\text{m}$	mm <sup>2</sup> /kg	700	700	700
Optical inhomogeneities		level 2 on white base		
Adhesivity		Absent		

**RECYCLABLE WITH PAPER - ATICELCA® 501 – level C**

The values given above were assessed in accordance with UNI 11743:2019.



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11547-0002

**Storage**

Store in a dry place, away from direct sunlight and atmospheric agents, at a temperature not exceeding 30°C and not below 15°C.

**Shelf life:**

24 months from the date of manufacture, if stored in the original, unopened packaging and under the recommended storage conditions. It is the responsibility of the end user to verify the suitability of the packaging in the actual conditions of use, depending on the type of food contained, the filling and processing methods, the storage conditions, and the shelf life of the packaged product.

Beyond the indicated shelf life, the material must be re-evaluated before use to verify that it maintains its technical performance and conformity to its intended use.

**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)

**WARNING!**

- The printed colour may differ from what you see on the screen: this is normal and depends on several technical factors such as the calibration of your monitor, the colour gamut of the inks, the material being printed on, the finish applied.
- Colour fading may occur on the welds.

*Environmental label:*


Recyclable paper packaging to be collected separately and disposed of following local guidelines.

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

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

*Packing:*

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

**Rolls:** Wooden pallet + food bags + 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