

TECHNICAL DATA SHEET

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 with an internal plastic core (min 50 mm – max 750 mm)

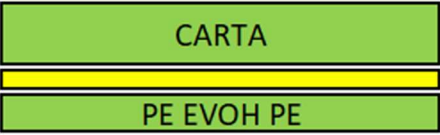
At the customer's request, the following can be added to the stand-up pouches/Doypacks and flat pouches:

- Hole/euro slot

Constituent materials:

Laminated paper/plastic film (PE on inside)

Composition of multi-layer film – PAPER + PE EVOH PE:

COMPONENTS	VALUES		
ONE-SIDE COATED PAPER	80 g		
Adhesive	4 g		
PE EVOH PE	30 µm		
TOTAL THICKNESS	110 µm		

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

The values have a tolerance of +/- 5%

Physical and chemical properties:

PROPERTY	METHOD	UNIT	VALUE (BONDED MATERIAL)
GRAMMAGE	In-house method	g/m ²	114 +/- 5%
INITIAL BONDING TEMPERATURE	In-house method	°C x sec	175-180 x 0.20-0.30
WATER VAPOUR PERMEABILITY	ASTM F1249-06	g/m ²	4.8 +/- 5%
OXYGEN PERMEABILITY	ASTM F2622-08	ml/m ² 24 hours 1 atm	0.80 +/- 5%
CARBON DIOXIDE PERMEABILITY	ASTM F2476-05	ml/m ² 24 hours 1 atm	2,5 +/- 5%

Permeability test conditions: OXYGEN 23°C/0% RH – WATER VAPOUR 38°C/90% RH

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).



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Table 1. Results: recyclability key parameters

Parameter	Unit	Result	Minimum value	Maximum value
Coarse reject	%	36.7	36.5	37.0
Flakes	%	12.3	11.8	12.8
Macrostickies $\phi < 2000 \mu\text{m}$	mm ² /kg	< 500	< 500	< 500
Adhesivity		Absent		
Optical inhomogeneities		level 3 on white base		

RECYCLABLE WITH PAPER - ATICELCA® 501 – level C

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



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11547-0001

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:

- Do not fill the bag more than 2/3 of the 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.

Forms of packaging and/or protection:

<i>Packaging:</i>	<i>Packing:</i>
Pouches: Plastic cable ties	Pouches: Cardboard box + plastic air cushions Rolls: Wooden pallet or cardboard box + bubble wrap if required

Applicable framework laws:
Food contact safety and compliance:

Regulation (EC) 1935/04
Regulation (EC) 2023/06
Regulation (EU) 10/2011
Italian Presidential Decree 777/1982
Ministerial Decree of 21 March 1973

Environmental compliance:

Directive 94/62/EC
Italian Legislative
Decree 152/2006



Follow the guidelines
of local waste disposal regulations