

## ESS DEE Rx SPECTRUM

### Technical Data Sheet

S.N.	Parameter	Method	Unit	PLAIN /PRINTED FOIL + HSL COATING	PLAIN /PRINTED FOIL + HSL COATING	PLAIN /PRINTED FOIL + HSL COATING
1	Temper	----	----	Hard (H18)	Hard (H18)	Hard (H18)
2	Foil alloy	----	----	AA 8011	AA 8011	AA 8011
3	Toxicity	USP		Non - Toxic	Non - Toxic	Non - Toxic
4	Thickness of Aluminium Foil	EN-546-3	Micron	20 ± 8%	25 ± 8%	30 ± 8%
5	Aluminium Weight	Industry Standard	Gms/sq. mtr.	54.20 (± 8%) 49.86 - 58.54	67.75 (± 8%) 62.33 - 73.17	81.3 (± 8%) 74.79 - 87.80
6	Type of Coating	----	----	HSL (Heat Seal Lacquer )	HSL (Heat Seal Lacquer )	HSL (Heat Seal Lacquer )
7	Average coating Weight	Industry Standard	Gms/sq. mtr	4 to 6 / 6 to 8	4 to 6 / 6 to 8	4 to 6 / 6 to 8
8	Total Weight of Plain foil	Industry Standard	Gms/sq. mtr.	4 - 6 (53.86 - 64.54)	4 - 6 (66.33 - 79.17)	4 - 6 (78.80 - 93.80)
				6 - 8 (55.86 - 66.54)	6 - 8 (68.33 - 81.17)	6 - 8 (80.80 - 95.80)
9	Ink coating Weight	Industry Standard	Gms/sq. mtr.	2 - 3 / As Per Design	2 - 3 / As Per Design	2 - 3 / As Per Design
10	Over coating Weight	Industry Standard	Gms/sq. mtr.	1.5	1.5	1.5
11	Total Weight of Printed foil	Industry Standard	Gms/sq. mtr.	4 - 6 (57.36 - 69.04)	4 - 6 (69.83 - 83.67)	4 - 6 (82.30 - 97.30)
				6 - 8 (59.36 - 71.04)	6 - 8 (71.83 - 85.67)	6 - 8 (84.3 - 99.30)
12	Printing surface	Industry Standard	Gms/sq. mtr	0.50 GSM Primer coated for printing with H R Inks	0.50 GSM Primer coated for printing with H R Inks	0.50 GSM Primer coated for printing with H R Inks
13	Sealing Surface	----	----	Foil To Foil / PVC / Cold Form Blister	Foil To Foil / PVC / Cold Form Blister	Foil To Foil / PVC / Cold Form Blister

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14	Sealing Strength	Industry Standard	Gms/15mm (min)	450	450	450
15	Heat saleability test	Industry Standard	Kg/cm (With Specified Polymer at 180°C for 1sec.)	0.3 min.	0.3 min.	0.3 min.

S.N.	Parameter	Method	Unit	0.020 mm	0.025 mm	0.03 mm
1	Heat Resistance Test (at 230°C)	Industry Standard	----	Complies to specification	Complies to specification	Complies to specification
2	Pinholes	EN-546-4	No./meter <sup>2</sup>	05	0	0
3	Elongation	EN-546-2	%	1 min.	1 min.	1 min.
4	Tensile strength	EN-546-2	Kg/cm <sup>2</sup>	1450 min.	1450 min.	1450 min.
5	Foil Finish			Matt / Bright	Matt / Bright	Matt / Bright
6	Colour shade	Industry Standard	ΔE/Visual	As per standard	As per standard	As per standard
7	Text & Design	----	----	As per design / artwork.	As per design / artwork.	As per design / artwork.
8	Repeat Length	Industry Standard	mm	As Per The Artwork	As Per The Artwork	As Per The Artwork
9	Ink Adhesion test	EDAL/ATM/08	----	As per acceptance test method	As per acceptance test method	As per acceptance test method
10	Odour test	EDAL/ATM/11	----	As per acceptance test method	As per acceptance test method	As per acceptance test method
11	Fume absence test at 200°C	Industry Standard	----	Complies to specification	Complies to specification	Complies to specification
12	Leak test after blister formation	Industry Standard	----	No. leakage	No. leakage	No. leakage
13	Scuff test	Industry Standard	50 Rubs at 2 Psi	Passes	Passes	Passes
14	Joints Per Reel	----	----	As Per Customer Specification	As Per Customer Specification	As Per Customer Specification

S.N.	Parameter	Method	Unit	0.020 mm	0.025 mm	0.03 mm
15	Type of Tape & colour used for Joint	----	----	Paper Tape / BOPP Tape (Colour as per requirement)	Paper Tape / BOPP Tape (Colour as per requirement)	Paper Tape / BOPP Tape (Colour as per requirement)
16	Core Type	----	----	As per requirement	As per requirement	As per requirement
17	Core ID	----	mm	76mm ± 0.5mm	76mm ± 0.5mm	76mm ± 0.5mm
18	Width Tolerance	----	mm	± 0.5mm	± 0.5mm	± 0.5mm
19	OD / Length Of Reel	----	mm/mtrs	As per works order	As per works order	As per works order
20	Type of packing	----	----	Corrugated cartons / wooden case / Pallets	Corrugated cartons / wooden case / Pallets	Corrugated cartons / wooden case / Pallets
21	Printed Designs	----	----	Customer to specify unwinding direction and supply artwork/design of printed designs with colour scheme		

- Storage and handling instructions are important to achieve best result in ambient room temperature. Avoid direct sunlight.
- Above-mentioned specifications are standard specifications. We also offer tailor made specifications as per customer's requirement i.e. different combinations of foil (thickness) and heat seal lacquer (GSM)