

Technical Specification MO 51-7 FOOD GRADE

Characteristic		Basic value	Tolerance
1	Raw Material	Structure ABA where: A (10%) = PET virgin B (90%) = 50% virgin + 50% internal regrind	+/-5% dosing tolerance
2	Thickness (µm)	According to the order	<ul style="list-style-type: none"> Thickness < 120 ±10% 120 < Thickness < 200 ±8% Thickness > 201 ±5%
3	Width (mm)	According to the order	+/- 1 mm
4	Length (mm)	According to the order	± 1mm (if sheets)
5	Rolls weight [Kg]	Maximum 800kg	
6	Quantity	According to the order	+/-10%
7	Core diameter (mm)	<ul style="list-style-type: none"> Diameter 76 / 152 	
8	Winding	<ul style="list-style-type: none"> Straight Edge Eventual external finishing No humps (oscillator only for low thicknesses and for special materials emphasized in the order) 	<ul style="list-style-type: none"> ±1 mm for FFS machines ±0.5 cm for other uses
9	Superficial appearance (Brightness/opacity, humidity/fish eyes, black spots, flow lines/, drying, coating)	<p>According to the standard sample</p> <ul style="list-style-type: none"> In case of control by camera 	<ul style="list-style-type: none"> Max fish eyes and equivalent: < of 0.2 mm² → 40/m² from 0.2 a 0.5 mm² → 8/m² > of 0.5 mm² → 2/m² Max black spots and equivalent: maximum of 0.6 mm² → 4/m² maximum of 1 mm² → 2/m² if embossed-roughness from 4 to 9 micron Rz see trial specifications "Black spots transparent film"
10	Viscosity (IV) (dl/g)	IV _{min} = 0.7	+/- 0,1
11	C.O.F.	<p>On standard material ≤0.25</p> <p>On MO51 HiPrint ≤0.30</p> <p>On corona treated material >0.30</p>	
12	Thermoforming	Typical of PET	
13	Opacity / Transparence	According to the standard sample	
14	Colour	According to the standard sample	<p>For transparent film (referred to the adjustment ceramic plate):</p> <p>For thicknesses up to 300 my</p> <p>Δa = 0±0.3</p> <p>Δb = 1,3±0,8</p> <p>from 301 to 600 my</p> <p>Δa = 0±0.4</p> <p>Δb = 1.7±0,8</p> <p>Over 600 my</p> <p>Δa = 0±0.6</p> <p>Δb = 2±0,8</p> <ul style="list-style-type: none"> For opaque films: ΔE = 2
15	Shrinkage	Method ASTM D-1204-54	<ul style="list-style-type: none"> For thicknesses up to 250my -15% longitudinal +1 ÷ -2% trasversal For higher thicknesses -7% longitudinal +1 ÷ -3% trasversal
16	Packing	<ul style="list-style-type: none"> Standard Vertical core Roll label inside the core and outside the roll Pallet external label Pallet wrap up with stretch PE For sheets, applied edges protection For sheets, strapping non extremely tight Material non sticking out of the pallet 	

NB: Any indications included in the notes of the order, are considered as effective and prevalent on the parameters of the Quality Manual.

NB: Since this material is composed by a high percentage of scraps, values mentioned as per spots and colour shade are to be considered as an indication .

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