



## TECHNICAL DATA SHEET

US-14 Film is blown clear PE film, the main material is linear low density polyethylene blend with high density polyethylene to improve rigidity and make the pouch get more standability which is suitable for detergent packaging bag.

### FEATURE

- 1) High rigidity and good heat sealability.
- 2) Good resistance to chemical.

### USE

Form fill to seal for stand up pouch liquid detergent and/or others.

### General Physical property of PE Standing Pouch (Roll Form)

| Description                    |                | Unit                | Specification |              |              |                | Test Method               |
|--------------------------------|----------------|---------------------|---------------|--------------|--------------|----------------|---------------------------|
| Width                          |                | mm                  | Order +5,-0   |              |              |                | UPI Method                |
| Length                         |                | m                   | Order 0,+3%   |              |              |                |                           |
| Thickness                      |                | um                  | 25-39<br>±7%  | 40-59<br>±5% | 60-99<br>±4% | 100-180<br>±3% |                           |
| Tensile Strength               | MD             | MPa                 | ≥ 20          |              |              |                | ASTM D 882<br>/JIS K 7127 |
|                                | TD             |                     | ≥ 15          |              |              |                |                           |
| Elongation at Break            | MD             | %                   | ≥ 400         |              |              |                |                           |
|                                | TD             |                     | ≥ 600         |              |              |                |                           |
| Haze                           |                | %                   | ≤ 20          |              | ≤ 30         |                | ASTM D 1003               |
| Kinetic COF : Non Treated side |                | -                   | 0.10 - 0.25   |              |              |                | ASTM D 1894/JIS K 7125    |
| Heat seal strength             |                | Kgf/15mm            | *             |              |              |                | UPI Method                |
| Corona Treated :               | Non-Treated    | Dynes               | None          |              |              |                |                           |
|                                | Inside-Treated |                     | 38-44         |              |              |                |                           |
| Color of Film                  |                | -                   | Clear         |              |              |                |                           |
| Gel                            | Number         | pcs./m <sup>2</sup> | 10            |              |              |                |                           |
|                                | Size Ø         | mm                  | 0.5-1.0       |              |              |                |                           |
| Black spot                     | Number         | pcs./m <sup>2</sup> | 5             |              |              |                |                           |
|                                | Size Ø         | mm                  | 0.1-0.5       |              |              |                |                           |
| Remark.*Refer to the table 1.  |                |                     |               |              |              |                |                           |

Remark.\*Refer to the table 1.

**Table 1 Heat seal strength**

| Thickness (um) | Temperature(C °) | Unit | Specification | Test Method |
|----------------|------------------|------|---------------|-------------|
| 25-30          | 150              |      | ≥ 0.7         | UPI Method  |
| 31-49          |                  |      | ≥ 0.8         |             |
| 50-70          |                  |      | ≥ 1.0         |             |
| 71-79          |                  |      | ≥ 1.5         |             |
| 80-99          | 170              |      | ≥ 2.0         |             |
| 100-120        |                  |      |               |             |
| 121-129        |                  |      |               |             |
| 130-140        | 180              |      | ≥ 2.5         |             |
| 141-200        |                  |      |               |             |

### Note :

Raw Material : Linear Low Density Polyethylene, Low Density Polyethylene, Slip agent, Antiblock agent, Processing aid

Statutory and regulatory : Complies with U.S. FDA : 21 CFR part 177.1520, RoHS, Commission Regulation (EU) No 10/2011.

The Notification of the Ministry of Public Health (No.435) B.E. 2565 (2022)

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**บริษัท ยูนิคพลาสติก อินดัสตรี จำกัด (มหาชน) | UNIQUE PLASTIC INDUSTRY PUBLIC COMPANY LIMITED**

323 หมู่ 2 ถ.พุทธธากา ต.แพรกษาใหม่ อ.เมืองสมุทรปราการ จ.สมุทรปราการ 10280 : Tel: +66 (0) 2 703 6471-6 | Fax: +66 (0) 2 703 6477, 7640

323 Moo 2, Phuttharaksa Rd., Phraek Sa Mai, Mueang Samut Prakan, Samut Prakan, Thailand 10280 : www.uniqueplastic.com

## TECHNICAL DATA SHEET

|                     |                                                                                                                                                                                                                                              |
|---------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Appearance :        | The film shall be uniform ; free of pin hole , foreign matter and streaks.                                                                                                                                                                   |
| Storage :           | Store in dry place, high temperature not over 40 °C, keep away from direct sunlight, high moisture and fuel gas from LPG gas.                                                                                                                |
| Product guarantee : | The physical properties is not over a year. The change in color of film<br>The change in color of film or appearance is not over six months.<br>The corona treatment and COF property is not over three months from the date of manufacture. |

### Roll Characteristics.

|                        |   |                                                                                                                                                                                 |
|------------------------|---|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Width tolerance        | : | ( +5, -0 )mm.( measure on film)                                                                                                                                                 |
| Internal Core diameter | : | 76 ( +3 , -0) mm.                                                                                                                                                               |
| Joint                  | : | 1 for 20% maximum of total delivery.                                                                                                                                            |
| Number of joint        | : | Maximum 1 joint/roll with red tape.                                                                                                                                             |
| Film Appearance        | : | The film shall be uniform ; free of pin hole , foreign matter and streaks.<br>No creasing , no swollen roll.<br>No corrugation , no blocking.<br>Misalignment is not over 2 mm. |

### Packaging.



A



B

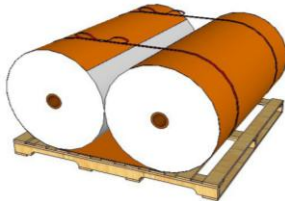


C



D

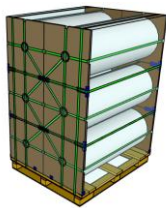
A . Horizontal for laminate film



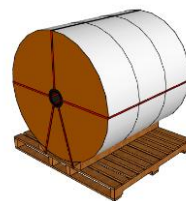
B. Vertical for laminate film



C. Hanging horizontal for shipping and airfreight



D. Horizontal for Heavy duty sack



### Roll Identification:

Each roll is identified with label stucked on the roll.

There is information including customer name , width , length , thickness , weight , corona treatment , etc.

The production history can monitor on batch number 15 digits described below;

|                    |                 |                  |                      |             |
|--------------------|-----------------|------------------|----------------------|-------------|
| AA                 | BB              | CC               | DDDDDD               | - EEE       |
| ↓                  | ↓               | ↓                | ↓                    | ↓           |
| Type of sale order | Production year | Production month | Number of sale order | Roll Number |

Approved by (Customer) :

Position :

Company :

Date :