



TECHNICAL DATA SHEET

US-15 is blown PE film, which the main material is linear low density polyethylene blend with high density polyethylene to get superior in stand up pouch and spout inserting.

FEATURE	1) High rigidity and good heat sealability. 2) Good resistance to chemical. 3) Film, 100-139 microns, is more suitable with stand up pouch. 4) Film, 140-180 microns, design for stiffness enhancement which is more suitable with PE spout inserting.
USE	Stand up pouch or Laminate as sealant layer with PE spout inserting packaging for liquid detergent and/or others.

General Physical property of PE Stand Up Pouch (Bag Form)

Description		Unit	Specification				Test Method
Width		mm	Order +5,-0				UPI Method
Length		m	Order 0,+3%				
Thickness		um	40-59 ±5%	60-99 ±4%	100-139 ±3%	140-180 ±3%	
Tensile Strength	MD	MPa	≥ 20	≥ 20		≥ 22	ASTM D 882 /JIS K 7127
	TD		≥ 15	≥ 15		≥ 20	
Elongation at Break	MD	%	≥ 400	≥ 500		≥ 700	
	TD		≥ 600	≥ 700		≥ 800	
Stiffness	MD	N/m	N/A	N/A		≥ 6000	
	TD		N/A	N/A		≥ 6000	
Haze		%	≤ 15	≤ 20	≤ 30	≤ 35	ASTM D 1003
Kinetic COF : Non Treated side		-	0.05 - 0.2				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 ²	10				
	Size Ø	mm	0.5-1.0				
Black spot	Number	pcs./m ²	5				
	Size Ø	mm	0.1-0.5				
Remark.*Refer to the table 1.							

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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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Page 1/2

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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 The change in color of film or appearance is not over six months. 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. No creasing , no swollen roll. No corrugation , no blocking. Misalignment is not over 2 mm.

Packaging.



A



B

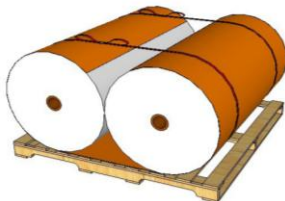


C



D

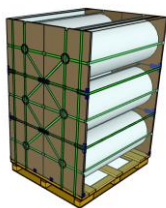
A . Horizontal for laminate film



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 :