

PRODUCT

Alluminium laminated to PP for coffee capsules

MATERIAL COMPOSITION

Primer for printing / Aluminium 30µm soft tempered / Film CT724 30µm sealing to PP/HDPE

Stratigraphy composition	Code	Thickness (µm)		Weight (g/m ²)		Chemical composition
		Value	Tol.	Value	Tol.	
Primer	CT185	-	-	1,2	± 0,2	Nitrocell-based
Aluminium soft tempered		30,0	± 2,4	81,0	± 6,5	DIN EN 573-3 EN AW 8079
Adhesive	CT307	-	-	3,0	± 0,5	Polyester polyurethane
PP/HDPE sealable Film		30,0	± 3,0	30,57	± 3,06	
Overall		64,2 (*)	± 6,1 (*)	115,8	± 10,3	

(*) Obtained from grammage

MATERIAL PROPERTIES

Residual solvent (IO 13)	<= 10 mg/m ²
Varnishes adhesion to the substrate (IO 06)	No detachment
Bonding to PP injection molding - average (IO 05)	>= 10 N/15mm (220°C - 3 bar - 1 second - 180°)
Bonding to PP injection molding - peak (IO 05)	>= 12 N/15mm (220°C - 3 bar - 1 second - 180°)
Control of the adhesion between film layers (IO 03)	>= 1 N/15mm

CLEARANCE CERTIFICATE

Plastic film	FDA 21 CFR § 177.1520 Directives 1935/2004/CE - 2023/2006/CE (GMP) CE Regulation n. 10/2011 and amendments Italian Ministerial Decree of 21/03/1973 and amendments
Product	Conformity of the product to the current norms is guaranteed by Aluberg according to the certifications issued by the suppliers of raw materials. The company assures not using heavy metals (Pb - Cd - Hg - CrVI) during the production process. It is however impossible to totally exclude the presence of heavy metal traces, which are directly issued of impurities coming from the raw materials used during the production cycle. The quantity is in any case lower than 100ppm, which matches with the limits fixed by the "94/62 EC Directive". The product is in compliance with Regulations (EC) No 1935/2004 and 2023/2006.

WARRANTY, STORAGE AND SHELF-LIFE

This warranty is only valid if the following conditions of storage are observed:

Condition of storage	Recommended storage conditions: - no direct sunlight - room temperature between 18°C - 30°C (optimum 18°C - 20°C) - relative humidity between 40% and 60% (optimum 40% - 50%)
Workability	Maximum 1 year from delivery date for printability and sealing.
Function	Maximum 5 years after processing on the packaging line.

LIABILITY EXCLUSION

Data mentioned in the technical specification, obtained in our laboratory or in our raw material supplier's laboratories, are valid as a general indication for the use of the product.

So, even if valid, they don't bind our Company that can not check the conditions of their use.