

**Polyethylene Film Specification for \_\_\_\_\_**

**Reference:** \_\_\_\_\_

**Date:** \_\_\_\_\_

**Description:** Polyethylene ( PE ) film for \_\_\_\_\_. Terminology is in accordance with definitions given in ASTM D 883 unless noted otherwise. Covers physical properties, test methods and workmanship. Spec sheets are for the protection of all parties.

**Materials:** Film shall be made of PE or combination of modified PE with copolymers and may contain additives or modifiers.

**Suitability:** User shall determine the suitability for any end use.

**Regulatory Compliance:** If for prolonged and direct contact with food, film must comply with US FDA 21 CFR 177.1520 (c) 3.2a. Supplier must produce FDA compliance letters from resin supplier on demand.

<b>Property</b>	<b>Test Method</b>	<b>Target Value</b>	<b>Range</b>
Secant Modulus	ASTM D 882	_____ psi	_____ - _____
Gloss 45°	ASTM D 2457	_____	_____ minimum
Haze / Opacity	ASTM D 1003	_____ %	_____ minimum
Dart Drop Impact	ASTM D 1709A	_____ grams	_____ minimum
Tear Strength	ASTM D 1922	_____ grams	
		MD _____	_____ minimum
		TD _____	_____ minimum
Tensile Elongation	ASTM D 882	_____ %	
		MD break _____	_____ minimum
		TD break _____	_____ minimum
Coefficient of Friction untreated to untreated	ASTM D 1894	0. _____	0. _____ to 0. _____

### Dimensions

Thickness	ASTM D 2103	____ . ____ mils	____ - ____ mils
Width	FPA TP-7	____ inches	+ <sup>3</sup> / <sub>16</sub> - zero

### Yield

Deviation from theoretical yield shall be within the following tolerances:

Any one roll up to 1,000 pounds	+/- 10%
1,000 to 2,500 pounds	+/- 5%
Over 2,500 pounds	+/- 3%
Over 5,500 pounds	+/- 2%
Over 10,000 pounds	+/- 1%

### Workmanship

Rolls which contribute to poor performance may be rejected by purchaser on a **roll-to-roll basis**. Material shall have workmanship qualities conforming with those produced by good commercial practice. General condition of roll edges must not interfere with unwind of rolls.

Material shall be as free as possible from gels, streaks, pinholes, particulates of foreign matter, undispersed raw materials, holes, nicks and cuts.

Cores upon which film is wound must not be recessed at either edge of roll, but may extend up to ¼" beyond end of roll. Rolls must be free as possible from edge weave.

Rolls having soft spots, ridges which result in bagginess are unacceptable.

### Identification

Rolls will be placed in the outer wrap with labels containing the following information:

Manufacturer name, film type, width, thickness, weight, length, customer's purchase order number and roll number.

### Packaging

Material will be packed in such a manner that normal handling by common carrier will ensure safe transportation without injury to the product.

### APPROVALS

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Date

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Date