



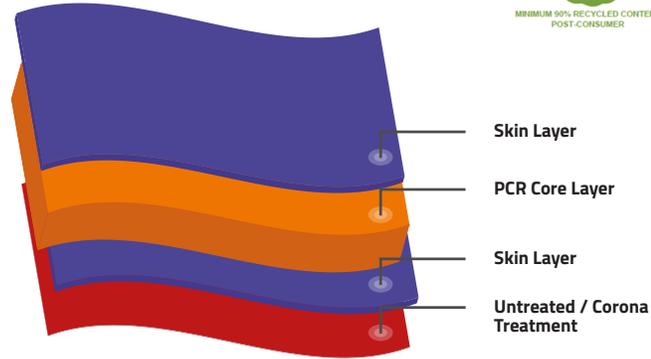
R-HTF HOT STAMPING BASE FILM

R-HTF is transparent BOPET film from our Asclepius branded PCR content products. The film is either both sides Untreated or one side Corona Treated with other side Untreated. This Data Sheet applies to all PCR content levels (30, 50, 90, and 100%).

KEY FEATURES:

- Post Consumer Recycle content for a low carbon footprint (all % PCR)
- Very high thermal stability
- Excellent machinability & handling properties
- High mechanical properties
- Good optical properties

FILM STRUCTURE



APPLICATION:

- This grade of film is ideal as a transfer foil to transfer designs on paper, textile, or plastics

PROPERTIES		TEST METHOD	UNIT	TYPICAL VALUES						
THICKNESS		Internal	Micron	12	15	19	23	36	45	50
			(Gauge)	48	60	76	92	144	180	200
YIELD		Internal	m ² / kg	59.52	47.62	37.59	31.05	19.84	15.87	14.28
			in ² /lb	41934	33550	26483	21876	13978	11181	10060
SURFACE TENSION (min) # (Corona Treated surface)		ASTM D-2578	dyne/cm	52						
COF (max) (Corona Treated to Untreated) (Untreated to Untreated)		ASTM D-1894	-	0.50	0.50	0.50	0.50	0.45	0.45	0.45
				0.45	0.45	0.40	0.40	0.40	0.40	0.40
HAZE (max)		ASTM D-1003	%	4.0	4.0	4.0	4.5	5.0	5.5	5.5
TENSILE STRENGTH AT BREAK (min)	MD	ASTM D-882	kg/cm ²	1900	1900	1900	1900	1750	1750	1750
	TD			2000	2000	2000	2000	2000	2000	2000
	MD		(Psi)	27000	27000	27000	27000	25000	25000	25000
	TD			28500	28500	28500	28500	28500	28500	28500
ELONGATION AT BREAK (min)	MD	ASTM D-882	%	105	105	110	115	120	125	125
	TD			85	85	90	90	90	90	95
LINEAR SHRINKAGE (max) (5 Minute at 190°C) (30 Minute at 150°C)	MD	ASTM D-1204	%	5.0	5.0	5.0	5.0	-	-	-
	TD			0.6	0.6	0.6	0.6	-	-	-
	MD			-	-	-	-	2.0	2.0	2.0
	TD			-	-	-	-	0.8	0.8	0.8
MVTR (38°C & 90% RH) (typical)		ASTM F-1249	gm/m ² /day	45	40	35	30	20	18	16
			(gm/100 in ² /day)	2.9	2.6	2.3	2.0	1.3	1.2	1.0
OTR (23°C & 0% RH) (typical)		ASTM D-3985	cc/m ² /day	130	110	90	80	70	55	45
			(cc/100 in ² /day)	8.5	7.1	5.8	5.2	4.5	3.5	2.9

The inherent surface tension of the untreated side of any PET film is a minimum of 42 dyne/cm.

STORAGE & HANDLING

FLEXPET™ needs to be stored in a warehouse below 35°C (95°F) and should not be exposed to direct sunlight, bright light sources, or high humidity. If the material is stored in the recommended conditions, FLEXPET™ is suitable for use within 270 days from the date of shipment.

FOOD CONTACT

FLEXPET™ complies with EU and FDA regulations on plastic materials used for food grade applications. Specific documents and SDS are available on request.

DISCLAIMER

It is the responsibility of our customer to determine that their use of our products is safe, lawful, and technically suitable in their intended applications. The technical data sheets are provided for discussion purposes only. The customer may not rely on the data provided for any manufacturing purpose. The values provided in the technical data sheet represent typical values based on the best of our knowledge as of the date when the data was compiled. The data is offered solely to provide possible suggestions for your own experimentation and not as a guarantee for the material supplied. The user is solely responsible for the end use of the product and needs to perform their own tests to confirm the product suitability/compatibility in all respects. Flex provides no warranty and accepts no liability for any loss or fitness of the product for any specific purpose based on the information contained in the technical data sheets. Flex reserves the right to change the technical data sheet at any time without prior notice.

Ref. No: QAD UFLI S/20 - F102/1

** TDS issued on 01-04-2020. All previous version of this grade are invalid.

FlexFilms

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