



# **BOPP FILMS**

## **TECHNICAL DATA SHEETS**

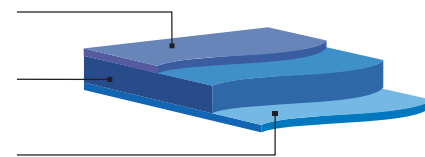
## Description

**BOPP film matte on one side and glossy on the other side,  
non-heat sealable,  
activated on one (glossy) side,  
for printing, lamination and packaging**

Matte untreated layer  
with a low coefficient of friction

Transparent layer

Glossy treated  
copolymer layer



Properties		Unit	Limit	Method	m			
Thickness		µm	±5%	ISO 4591, 4593 GOST 17035	15	20	30	35
Density		g/cm <sup>3</sup>	±10%	WATERFALL PRO	0,85			
Weight m <sup>2</sup>		g/m <sup>2</sup>	±5%	GOST 13199	12,75	17,00	25,50	29,75
Tensile strength	MD	N/mm <sup>2</sup> (Мпа)	not less	ASTM D882 ISO 527 GOST 14236	125			
	TD				240			
Elongation at break	MD	%	not more	ASTM D1894 GOST 27492	220			
	TD				80			
Kinetic coefficient of friction*		UT / UT	-	ASTM D1894 GOST 27492	0,25			
Shrinkage at 120°C, 5 мин	MD	%	not more	ASTM D1204	4			
	TD				2			
Heat sealing strength		-	N/15 mm	-	ASTM F88/F88M, D882 ISO 527			
Minimal heat sealing temperature		-	°C	-	WATERFALL PRO			
Haze		-	%	not less	ASTM D1003 GOST R 8.829			
Gloss		UT	%	not more	ASTM D2457			
Surface tension**		T	mN/m (dyn/cm)	not less	ASTM D2578 ISO 8296			

MD – machine direction  
TD – transverse direction

T – treated side  
UT – untreated side

\* these are typical values, guaranteed for the untreated side only. When processing on both sides, this value is not regulated  
\*\* with double-side treatment (if ordered), the activation of the second side (usually the inside of the roll) is not less than 36 mN/m

### Main characteristics

- one side: matte (rough) not activated
- the other side: gloss (smooth) activated for reverse printing
- high haze, low gloss
- low coefficient of friction

### Application

- as a face film of the package, to make the package matte – “silk” or “paper” kind

#### For packing

- on the high-speed HFFS and VFFS packaging machines
- with hot (heat sealing) seal formation, if it is necessary – “overlap”
- Flow-Pack and standing packet VFFS
- self using in decorative packaging
- possibility of application for wrap-around label

#### For lamination

- with other films and materials
- with method of the solvent or nonsolvent (extrusion) lamination

#### For printing

- high-quality rotogravure and flexographic print
- with the use of solvent paint

### Storage

- films should be stored on the pallets in a closed dry place and should not be exposed to direct sunlight, at a safe distance of not less than 1 m from heating devices or anything that can cause damage the package
- the film should be kept in workplace not less than 48 hours before being used
- guaranteed storage period – 6 months from production date

### Treatment

- the guaranteed period for maintaining the minimum permissible level of surface tension on the activated film surface from the date of manufacture, subject to proper storage conditions, is 6 months
- in the interests of minimizing the deterioration of surface dressing level, it is recommended to store the film at a temperature of no higher than 30°C and use it in a short time

### Recycling

- in the process of printing and lamination it is recommended to perform corona treatment

### Reeling

- maximum roll diameter 800 mm
- film width in a roll from 290 to 2000 mm
- diameter of paper cores (inside) 76, 152 mm

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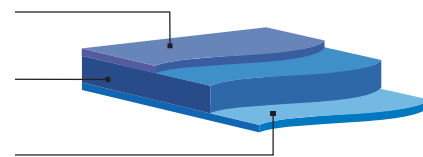
## Description

**BOPP film matte on one side and glossy on the other side, non-heat sealable, with a high coefficient of friction, activated on one (glossy) side, for printing, lamination and packaging, in cases requiring preservation of bags with products in a single group**

Matte untreated layer  
with increased coefficient of friction

Transparent layer

Glossy treated copolymer layer



Properties		Unit	Limit	Method	Value		
Thickness		µm	±5%	ISO 4591, 4593 GOST 17035	15	20	35
Density		g/cm <sup>3</sup>	±10%	WATERFALL PRO	0,85		
Weight m <sup>2</sup>		g/m <sup>2</sup>	±5%	GOST 13199	12,75	17,00	29,75
Tensile strength	MD	N/mm <sup>2</sup> (МПа)	not less	ASTM D882 ISO 527 GOST 14236	125		
	TD				240		
Elongation at break	MD	%	not more	ASTM D1894 GOST 27492	220		
	TD				80		
Kinetic coefficient of friction		UT / UT	-	ASTM D1894 GOST 27492	0,5		
Shrinkage at 120°C, 5 мин	MD	%	not more	ASTM D1204	4		
	TD				2		
Heat sealing strength		-	N/15 mm	ASTM F88/F88M, D882 ISO 527	non-heat sealable		
Minimal heat sealing temperature		-	°C	WATERFALL PRO	non-heat sealable		
Haze		-	%	ASTM D1003 GOST R 8.829	70		
Gloss		UT	%	ASTM D2457	12		
Surface tension		T	mN/m (dyn/cm)	ASTM D2578 ISO 8296	38		

MD – machine direction  
TD – transverse direction

T – treated side  
UT – untreated side

### Main characteristics

- one side: matte (rough) not activated
- other side: gloss (smooth) is activated for reverse printing
- high haze, low gloss
- stable high coefficient of friction

### Application

- as a face film of the package, to give matte "silk" or "paper" look to the package
- [For packing](#)
- on the high-speed HFFS and VFFS packaging machines
- with hot (heat sealable) seal formation, if it is necessary – "overlap", and cold (using cold glue) seal formation
- Flow-Pack and standing packet VFFS
- of multiple packs of packaged product with banding method
- in packs, which can stay in single group without sliding on each other
- [For lamination](#)
- with other films and materials, for decreasing influence of slip additives migration on the BOPP film side, which leads to significant reduction of coefficient of friction. In this case high coefficient of friction compensates that
- using solvent or non-solvent (extrusive) lamination method
- [For printing](#)
- high-quality rotogravure and flexographic print
- with the use of solvent paint

### Storage

- films should be stored on the pallets in a closed dry place and should not be exposed to direct sunlight, at a safe distance of not less than 1 m from heating devices or anything that can cause damage the package
- the film should be kept in workplace not less than 48 hours before being used
- guaranteed storage period – 6 months from production date

### Treatment

- the guaranteed period for maintaining the minimum permissible level of surface tension on the activated film surface from the date of manufacture, subject to proper storage conditions, is 6 months
- in the interests of minimizing the deterioration of surface dressing level, it is recommended to store the film at a temperature of no higher than 30°C and use it in a short time

### Recycling

- in the process of printing and lamination it is recommended to perform corona treatment

### Reeling

- maximum roll diameter 800 mm
- film width in a roll from 290 to 2000 mm
- diameter of paper cores (inside) 76, 152 mm

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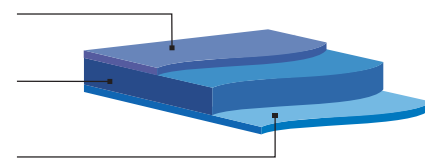
## Description

**BOPP film matte on one side and glossy on the other side, heat sealable with a standard seal threshold, activated on one (glossy) side, for printing, lamination and packaging, in cases requiring lower heat sealing temperatures**

Matte untreated heat sealable layer with a very wide welding range

Transparent layer

Glossy treated copolymer layer



Properties		Unit	Limit	Method	Value			
Thickness		µm	±5%	ISO 4591, 4593 GOST 17035	15	18	20	35
Density		g/cm <sup>3</sup>	±10%	WATERFALL PRO	0,85			
Weight m <sup>2</sup>		g/m <sup>2</sup>	±5%	GOST 13199	12,75	15,30	17,00	29,75
Tensile strength	MD	N/mm <sup>2</sup> (МПа)	not less	ASTM D882 ISO 527 GOST 14236	125			
	TD				240			
Elongation at break	MD	%	not more	ASTM D1894 GOST 27492	220			
	TD				80			
Kinetic coefficient of friction		UT / UT	-	ASTM D1894 GOST 27492	0,25			
Shrinkage at 120°C, 5 мин	MD	%	not more	ASTM D1204	4			
	TD				2			
Heat sealing strength at 115°C, 1 bar, 1 sec.		UT / UT	N/15 mm	not less	ASTM F88/F88M, D882 ISO 527	2,0		
Minimal heat sealing temperature not less than 1H/15mm at 1 bar, sec.		UT / UT	°C	-	WATERFALL PRO	105		
Haze		-	%	not less	ASTM D1003 GOST R 8.829	70		
Gloss		UT	%	not more	ASTM D2457	12		
Surface tension		T	mN/m (dyn/cm)	not less	ASTM D2578 ISO 8296	38		
MD – machine direction TD – transverse direction		T – treated side UT – untreated side						

### Main characteristics

- one side: matte (rough) not activated with a low barrier of friction (from 110°C)
- the other side: gloss (smooth) activated for reverse printing
- high haze, low gloss
- low coefficient of friction

### Application

- as a face film of the package, to make the package matte – “silk” or “paper” kind
  - [For packing](#)
  - on the high-speed HFFS and VFFS packaging machines
  - with hot (heat sealing) seal formation, if it is necessary – “overlap” on lower temperatures of heat sealable (from 110°C)
  - Flow-Pack and standing packet VFFS
  - self using in decorative packaging
  - application for a wrap-around label
- [For lamination](#)
- with other films and materials
- with method of the solvent or nonsolvent (extrusion) lamination
- [For printing](#)
- high-quality rotogravure and flexographic print
- with the use of solvent paint

### Storage

- films should be stored on the pallets in a closed dry place and should not be exposed to direct sunlight, at a safe distance of not less than 1 m from heating devices or anything that can cause damage the package
- the film should be kept in workplace not less than 48 hours before being used
- guaranteed storage period – 6 months from production date

### Treatment

- the guaranteed period for maintaining the minimum permissible level of surface tension on the activated film surface from the date of manufacture, subject to proper storage conditions, is 6 months
- in the interests of minimizing the deterioration of surface dressing level, it is recommended to store the film at a temperature of no higher than 30°C and use it in a short time

### Recycling

- in the process of printing and lamination it is recommended to perform corona treatment

### Reeling

- maximum roll diameter 800 mm
- film width in a roll from 290 to 2000 mm
- diameter of paper cores (inside) 76, 152 mm

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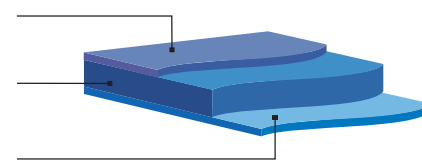
## Description

**BOPP film is matte on one side and glossy on the other side, non-heat sealable, activated on one (glossy) side, for printing, lamination and decorative packaging**

Matte untreated non-heat sealable layer

Transparent layer

Glossy treated non-heat sealable layer



Properties		Unit	Limit	Method	Value		
Thickness		µm	±5%	ISO 4591, 4593 GOST 17035	15	20	35
Density		g/cm <sup>3</sup>	±10%	WATERFALL PRO	0,85		
Weight m <sup>2</sup>		g/m <sup>2</sup>	±5%	GOST 13199	12,75	17,00	29,75
Tensile strength	MD	N/mm <sup>2</sup> (Мпа)	not less	ASTM D882 ISO 527 GOST 14236	125		
	TD				240		
Elongation at break	MD	%	not more	ASTM D1894 GOST 27492	220		
	TD				80		
Kinetic coefficient of friction		UT / UT	-	ASTM D1894 GOST 27492	0,25		
Shrinkage at 120°C, 5 мин	MD	%	not more	ASTM D1204	4		
	TD				2		
Heat sealing strength		-	N/15 mm	ASTM F88/F88M, D882 ISO 527	non-heat sealable		
Minimal heat sealing temperature		-	°C	WATERFALL PRO	non-heat sealable		
Haze		-	%	ASTM D1003 GOST R 8.829	70		
Gloss		UT	%	ASTM D2457	12		
Surface tension		T	mN/m (dyn/cm)	ASTM D2578 ISO 8296	38		

MD – machine direction  
TD – transverse direction

T – treated side  
UT – untreated side

## Main characteristics

- matte side has roughness and diffuses light. When filling the roughness (with water or laquer) the film in these places becomes glossy and transparent. It allows to highlight objects of reverse printing
- low coefficient of friction

## Application

- as a face film of the package, to give the package matte – “silk” or “paper” look
- for highlighting objects of reverse printing. When filling the roughness of the matte surface with water or laquer, the film in these places becomes glossy and transparent

### For packing

- on the high-speed HFFS and VFFS packaging machines
- use for decorative packaging

### For lamination

- with other films and materials
- for the solvent or nonsolvent (extrusion) lamination

### For printing

- high-quality rotogravure and flexographic print
- with the use of solvent paint

## Storage

- films should be stored on the pallets in a closed dry place and should not be exposed to direct sunlight, at a safe distance of not less than 1 m from heating devices or anything that can cause damage the package
- the film should be kept in workplace not less than 48 hours before being used
- guaranteed storage period – 6 months from production date

## Treatment

- the guaranteed period for maintaining the minimum permissible level of surface tension on the activated film surface from the date of manufacture, subject to proper storage conditions, is 6 months
- in the interests of minimizing the deterioration of surface dressing level, it is recommended to store the film at a temperature of no higher than 30°C and use it in a short time

## Recycling

- in the process of printing and lamination it is recommended to perform corona treatment

## Reeling

- maximum roll diameter 800 mm
- film width in a roll from 290 to 2000 mm
- diameter of paper cores (inside) 76, 152 mm

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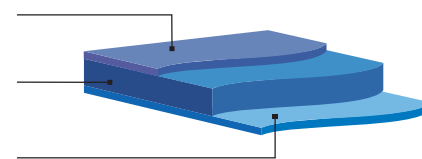
## Description

**BOPP film matt with a release effect on one side and glossy on the other side, non-heat sealable, activated on one (glossy) side, for printing, lamination and packaging with a cold seal glue frame**

Matte untreated non-heat sealable layer with release properties

Transparent layer

Glossy treated copolymer layer



Properties		Unit	Limit	Method	Value		
Thickness		µm	±5%	ISO 4591, 4593 GOST 17035	15	18	20
Density		g/cm <sup>3</sup>	±10%	WATERFALL PRO	0,85		
Weight m <sup>2</sup>		g/m <sup>2</sup>	±5%	GOST 13199	12,75	15,30	17,00
Tensile strength	MD	N/mm <sup>2</sup> (МПа)	not less	ASTM D882 ISO 527 GOST 14236	125		
	TD				240		
Elongation at break	MD	%	not more	ASTM D1894 GOST 27492	220		
	TD				80		
Kinetic coefficient of friction		UT / UT	-	ASTM D1894 GOST 27492	0,25		
Shrinkage at 120°C, 5 мин	MD	%	not more	ASTM D1204	4		
	TD				2		
Heat sealing strength		-	N/15 mm	ASTM F88/F88M, D882 ISO 527	non-heat sealable		
Minimal heat sealing temperature		-	°C	WATERFALL PRO	non-heat sealable		
Haze		-	%	ASTM D1003 GOST R 8.829	70		
Gloss		UT	%	ASTM D2457	12		
Surface tension		T	mN/m (dyn/cm)	ASTM D2578 ISO 8296	38		

MD – machine direction  
TD – transverse direction

T – treated side  
UT – untreated side

### Main characteristics

- one side: matte (rough) with a high release effect
- the other side: gloss (smooth) activated for reverse printing
- high haze, low gloss
- low coefficient of friction

### Application

- as a face film of the package, to make the package matte – “silk” or “paper” kind
- for possibility of reopening/reclosing package

#### For packing

- on the HFFS packaging machines
- with cold (using cold glue) seal formation
- with cold glue for one-and reopening
- Flow-Pack

#### For lamination

- with other films and materials
- with method of the solvent or nonsolvent (extrusion) lamination

#### For printing

- high-quality rotogravure and flexographic print
- with the use of solvent paint

### Storage

- films should be stored on the pallets in a closed dry place and should not be exposed to direct sunlight, at a safe distance of not less than 1 m from heating devices or anything that can cause damage the package
- the film should be kept in workplace not less than 48 hours before being used
- guaranteed storage period – 6 months from production date

### Treatment

- the guaranteed period for maintaining the minimum permissible level of surface tension on the activated film surface from the date of manufacture, subject to proper storage conditions, is 3 months
- in the interests of minimizing the deterioration of surface dressing level, it is recommended to store the film at a temperature of no higher than 30°C and use it in a short time

### Recycling

- in the process of printing and lamination it is recommended to perform corona treatment

### Reeling

- maximum roll diameter 800 mm
- film width in a roll from 290 to 2000 mm
- diameter of paper cores (inside) 76, 152 mm

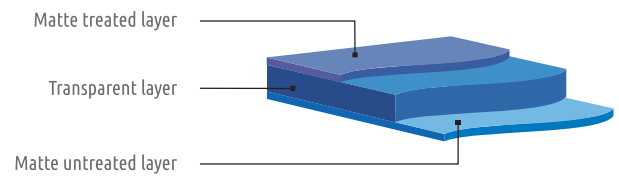
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## Description

**BOPP film matte on both sides,  
non-heat sealable, activated on one side,  
for printing and decorative packaging**



Properties		Unit	Limit	Method	Value		
Thickness		µm	±5%	ISO 4591, 4593 GOST 17035	30	35	40
Density		g/cm <sup>3</sup>	±10%	WATERFALL PRO	0,85		
Weight m <sup>2</sup>		g/m <sup>2</sup>	±5%	GOST 13199	25,50	29,75	34,00
Tensile strength	MD	N/mm <sup>2</sup> (Мпа)	not less	ASTM D882 ISO 527 GOST 14236	125		
	TD				240		
Elongation at break	MD	%	not more		220		
	TD				80		
Kinetic coefficient of friction*		UT / UT	-	ASTM D1894 GOST 27492	0,25		
Shrinkage at 120°C, 5 мин	MD	%	not more	ASTM D1204	4		
	TD				2		
Heat sealing strength		N/15 mm	-	ASTM F88/F88M, D882 ISO 527	non-heat sealable		
Minimal heat sealing temperature		°C	-	WATERFALL PRO	non-heat sealable		
Haze		%	not less	ASTM D1003 GOST R 8.829	70		
Gloss		UT	%	ASTM D2457	12		
Surface tension**		T	mN/m (dyn/cm)	ASTM D2578 ISO 8296	38		
MD – machine direction TD – transverse direction		T – treated side UT – untreated side		* these are typical values, guaranteed for the untreated side only. When processing on both sides, this value is not regulated ** with double-side treatment (if ordered), the activation of the second side (usually the inside of the roll) is not less than 36 mN/m			

### Main characteristics

- matte look from the both sides
- slip-antistatic additives

### Application

- for contact with food
- to give the package matte – “silk” or “paper” look
- for manual and machine product wrapping (flowers, gifts, textile products etc.)
- string heat sealing is possible

#### For packing

- decorative packaging

#### For printing

- high-quality flexographic print
- with the use of solvent paint

### Storage

- films should be stored on the pallets in a closed dry place and should not be exposed to direct sunlight, at a safe distance of not less than 1 m from heating devices or anything that can cause damage the package
- the film should be kept in workplace not less than 48 hours before being used
- guaranteed storage period – 6 months from production date

### Treatment

- the guaranteed period for maintaining the minimum permissible level of surface tension on the activated film surface from the date of manufacture, subject to proper storage conditions, is 6 months
- in the interests of minimizing the deterioration of surface dressing level, it is recommended to store the film at a temperature of no higher than 30°C and use it in a short time

### Recycling

- in the process of printing and lamination it is recommended to perform corona treatment

### Reeling

- maximum roll diameter 800 mm
- film width in a roll from 290 to 2000 mm
- diameter of paper cores (inside) 76, 152 mm

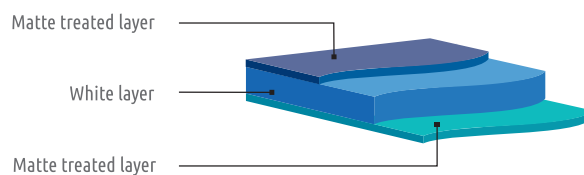
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## Description

**BOPP film matte on both sides, filled,  
non-heat sealable,  
with double-sided activation,  
for printing and decorative packaging**



Properties		Unit	Limit	Method	Value		
Thickness		µm	±5%	ISO 4591, 4593 GOST 17035	30	35	40
Density		g/cm <sup>3</sup>	±10%	WATERFALL PRO	0,91		
Weight m <sup>2</sup>		g/m <sup>2</sup>	±5%	GOST 13199	27,30	31,85	36,40
Tensile strength	MD	N/mm <sup>2</sup> (МПа)	not less	ASTM D882 ISO 527 GOST 14236	125		
	TD				240		
Elongation at break	MD	%	not more	ASTM D1894 GOST 27492	220		
	TD				80		
Kinetic coefficient of friction		T/T	-	ASTM D1894 GOST 27492	0,4		
Shrinkage at 120°C, 5 мин	MD	%	not more	ASTM D1204	4		
	TD				2		
Heat sealing strength		-	N/15 mm	-	ASTM F88/F88M, D882 ISO 527 non-heat sealable		
Minimal heat sealing temperature		-	°C	-	WATERFALL PRO non-heat sealable		
Haze		-	%	not less	ASTM D1003 GOST R 8.829 80		
Gloss		T	%	not more	ASTM D2457 12		
Surface tension		T	mN/m (dyn/cm)	not less	ASTM D2578 ISO 8296 38		

MD – machine direction  
TD – transverse direction

T – treated side

### Main characteristics

- completely white, matt (rough) and activated on both sides
- high opacity, low gloss
- very high UV protection of packaged products

### Application

- to give the packaging a matte “silk” / “papery” look
- for manual and machine wrapping of products (flowers, gifts, stationery, textile products, etc.)
- for the production of flexible packaging for products requiring UV protection

#### For packing

- on high-speed HFFS and VFFS packaging machines
- with cold (using cold glue) seam formation
- flow-pack
- independent use in decorative packaging

#### For printing

- high quality rotogravure and flexographic
- using solvent paints

### Storage

- films should be stored on the pallets in a closed dry place and should not be exposed to direct sunlight, at a safe distance of not less than 1 m from heating devices or anything that can cause damage the package
- the film should be kept in workplace not less than 48 hours before being used
- guaranteed storage period – 6 months from production date

### Treatment

- the guaranteed period for maintaining the minimum permissible level of surface tension on the activated film surface from the date of manufacture, subject to proper storage conditions, is 6 months
- in the interests of minimizing the deterioration of surface dressing level, it is recommended to store the film at a temperature of no higher than 30°C and use it in a short time

### Recycling

- in the process of printing and lamination it is recommended to perform corona treatment

### Reeling

- maximum roll diameter 800 mm
- film width in a roll from 290 to 2000 mm
- diameter of paper cores (inside) 76, 152 mm

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