

FOIL

I. PAPER TOP: - 4 PLY laminate:40 – 42 GSM GIP (GLASSINE) paper / 18 – 20 micron Polythene / 9 micron Aluminium / 6 - 8 GSM Heat seal coating(Equivalent sealant) or nucrel. Core (plastic) Seal strength of strips:400gmf/15mm min

Sl. No.	Sealant Type	Sealant Thickness	Reel Length (meter)	Width of foil (mm)	No. of colours	PFT
1	Heat seal coating	6-8 GSM	1000	30	Single colour Two colour Three colour Four colour Five colour Six Colour	
2	Heat seal coating	6-8 GSM	1000	55	Single colour Two colour Three colour Four colour Five colour Six colour	48800

PAPER TOP :-

Sl. No.	Sealant Type	Sealant Thickness	Reel Length (meter)	Width of foil (mm)	No. of colours	
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3	Heat seal coating	6-8 GSM	600	115	Single colour Two colour Three colour Four colour Five colour Six Colour	3000
4	Heat seal coating	6-8 GSM	600	170	Single colour Two colour Three colour Four colour Five colour Six Colour	48800

PET Foil :- 4 ply laminate: 11.9 – 12.1 micron PET with reverse printing / 18 - 20 micron Poly / 8.28 – 9.72 micron Aluminium / 25 micron Surlyn(min). Seal strength: A minimum of 1.3 Kgf/15 mm at all temperatures in the range of 90 degree 180 degree Celsius . Width: 170.5+0/-0.5 mm /185m m/115mm/60mm/55mm (as per the requirement) Peel strength : A minimum of 250 gmf/15mm between the Aluminium layer and the sealant (surlyn). PET– PE bond strength : 200 gmf / 15 mmwidth (min). PEAluminium bond strength : 150 gmf / 15 mm width (min). Seal strength of strips:1.3kgf/15mm(min)
Core (plastic)

Sl. No.	Sealant Type	Sealant Thickness	Reel Length (meter)	Width of foil (mm)	No. of colours	QUANTITY
1	Surlyn	25 micron	800	55 mm	Single colour Two colour Three colour Four colour	

					Five colour Six colour	17700
2	Surlyn	25 micron	600	115 mm	Single colour Two colour Three colour Four colour Five colour Six colour	4000
3	Surlyn	25 micron	600	170.5+0/- 0.5 mm	Single colour Two colour Three colour Four colour Five colour Six colour	51680

Sl. No.	Sealant Type	Sealant Thickness	Reel Length (meter)	Width of foil (mm)	No. of colours	QUANTITY
4	Surlyn	25 micron	800	60 mm	Single colour Two colour Three colour Four colour Five colour Six colour	3780
5	Surlyn	25 micron	600	185 mm	Single colour Two colour Three colour Four colour Five colour Six colour	2720

SPECIFICATION FOR KAKKANAD UNIT-FEMALE SACEHET PACKING FILM -SURLYN

11.9 - 12.1 micron PET with reverse printing / 18 - 20 micron Poly / 8.28-9.72 micron Aluminium / 30 micron Surlyn.Seal strength: A minimum of 1.3 Kgf/15 mm at all temperatures in the range of 90 degree Celsius to 180 degree Celsius.Peel strength: A minimum of 250 gmf/15mm between the Aluminium layer and the sealant (surlyn). width: 210 mm and print repetition 135mm Color of printing - as per approved artwork.(pantone colours given in the artwork need to be followed- P metallic 10183 ,Pmetallic 10127 ,Blanc etc) , with core ID of 76 mm.Eye mark distance shall be as per approved artwork.

Sl. No.	Sealant Type	Width of foil (mm)	No. of colours	QUANTITY
1	Surlyn	210 mm	Single colour Two colour Three colour Four colour Five colour Six colour	3600
2	Surlyn	115 mm	Single colour Two colour Three colour Four colour Five colour Six colour	

SPECIFICATION ONLY FOR AKKULAM FACTORY

QUANTITY

<p style="text-align: center;">1. Aluminium foil for Surgical suture (Printed Paper Top, 4 layered) – Thera 450.</p> <p>1. Layer details a. ARSR Poster Paper top : 41.4 to 48.60 GSM b. LDPE: 16.56 to 19.44 GSM c. Aluminium foil : 99.73 to 117.07 GSM d. Nucrel sealant layer : 31.28 to 36.72 GSM e. Total GSM Not less than 188.97 2. Reel Width: 300 mm 3. Core diameter: 76mm(+2/-1) 4. Reel Maximum Diameter: 350 mm 5. Printing & colour: Printed , two colours as per HLL Artwork. 6. Photo Cell Mark: Required. 7. Bobbin material: Metal or good quality plastic. Printed Foil - General Conditions: - 1) Material must withstand ETO/Gamma sterilization. 2) Material should be heat sealable. 3) Suitable for clean room application. 4) Resistance to bacterial penetration. 5) Superior puncture resistance. 6) Low particulate generation. 8) Print must be smooth, clear and should not fade or peel off for minimum 5 years. 9) Should be free from dust particle, pinholes, foreign matter, un-dispersed raw-materials, tears, cuts and blisters. 10) Material must be suitable for medical/pharmaceutical applications.</p> <p>11) Packaging: One reel in a master carton. Each roll must be covered with a polyethylene sheet and the rolls must be packed in well-closed containers with edge protector and foils should not damage during transportation, handling & storage.</p> <p>12 Test Certificate: Supplier should provide test certificate (including layer wise GSM) with each consignment.</p>	4000
<p style="text-align: center;">1. Layer details</p> <p style="padding-left: 40px;">a. NC coating : 0.5 to 1.50 GSM</p> <p style="padding-left: 40px;">b. Aluminum foil : 124.66 to 146.34 GSM</p> <p style="padding-left: 40px;">c. Nucrel sealant layer : 31.28 to 36.72 GSM</p> <p style="padding-left: 40px;">d. Total GSM : 156.86 to 184.14 GSM</p> <p style="text-align: center;">2. Reel Width: 320 mm</p> <p style="padding-left: 40px;">3. Core Diameter: 76mm(+2/-1) 4. Reel Maximum diameter: 400mm.</p> <p style="padding-left: 40px;">5. Bobbin material: metal or good quality plastic.</p> <p>Unprinted foil - General conditions:1. Material must withstand ETO/GAMMA sterilization. 2. Material must be heat sealable. 3. Must be suitable for clean room applications. 4. Resistance to bacterial penetration. 5. Superior puncture resistance. 6. Low particulate generation. 7. Should be moisture resistant. 8. Material should be free from dust particles, holes, foreign matter; un-dispersed raw materials, tears, cuts and blisters. 9. Material must be suitable for medical /pharmaceutical application. 10. Packaging: One reel in a master carton. Each roll must be covered with a polyethylene sheet and the rolls must be packed in well-closed containers with edge protector and foils should not damage during transportation, handling & storage. 11. Supplier should provide test certificate (Including layer wise GSM) with each consignment.</p>	5000

3. Aluminium foil for Surgical suture (Un printed Paper Top, 4 layered) – Thera 450.

1. Layer details

- a. ARSR Poster Paper top : 41.4 to 48.60 GSM
- b. LDPE : 16.56 to 19.44 GSM
- c. Aluminium foil : 99.73 to 117.07 GSM
- d. Nucrel sealant layer : 31.28 to 36.72 GSM

e. Total GSM Not less than 188.97

2. Reel Width: 320 mm (+/-2)

3. Core diameter: 76mm(+2/-1)

4. Reel Maximum Diameter: 350 mm

5. Bobbin material: Metal or good quality plastic.

Printed Foil - General Conditions: -

- 1) Material must withstand ETO/Gamma sterilization.
- 2) Material should be heat sealable.
- 3) Suitable for clean room application.
- 4) Resistance to bacterial penetration.
- 5) Superior puncture resistance.
- 6) Low particulate generation.

7) Should be free from dust particle, pinholes, foreign matter, un-dispersed raw-materials, tears, cuts and blisters.

8) Material must be suitable for medical/pharmaceutical applications.

9) Packaging: One reel in a master carton. Each roll must be covered with a polyethylene sheet and the rolls must be packed in well-closed containers with edge protector and foils should not damage during transportation, handling & storage.

10) Test Certificate: Supplier should provide test certificate (including layer wise GSM) with each consignment.