

# Pharma Pack™

## Pharma Pack Aclar composite

Sr. No.	Particulars	Test method reference	Specifications
1	Thickness of PVC	DIN 53370	190 +/- 10 % 200 +/- 10% 250 +/- 5%
2	Thickness of Aclar Film	DIN 53 370	15 μ ± 12% 20 μ ± 12% 23 μ ± 12% 51 μ ± 10 % 76 μ ± 10 % 102 μ ± 7.5%
3	Total thickness of Composite	DIN 53370	(PVC film thickness + Aclar Film thickness) +/- 7 %
4	GSM of PVC film	DIN 53352	(PVC thickness X 1.35*) * density of PVC in gm/cc
5	GSM of Aclar	DIN 53370	(Aclar film thickness X 2.1*) * density of Aclar in gm/cc
6	Adhesive GSM	In house	2 to 3 gm/m2
7	Total GSM (Composite)	DIN 53352	GSM of PVC + GSM of Aclar + Adhesive GSM
8	Dimensional Stability	DIN 53377	LD – 5 % max

			<b>TD + 2% max</b>
<b>9</b>	<b>Tensile strength</b>	<b>ASTM – D 882</b>	<b>LD &amp; TD 450 kg/m<sup>2</sup> min</b>
<b>10</b>	<b>Elongation</b>	<b>ASTM – D 882</b>	<b>LD &amp; TD 30%</b>
<b>11</b>	<b>Toxicity</b>	<b>USP - 31</b>	<b>Non toxic</b>
<b>12</b>	<b>Interlayer bond strength</b>	<b>In house</b>	<b>Min 4 N / 15 mm</b>
<b>13</b>	<b>WVTR at 38 Deg.C. &amp; 90 % RH</b>	<b>DIN 53122</b>	<b>With 250 μ PVC / Aclar WVTR value</b> 15 μ     0.29 to 0.38 20 μ     0.23 to 0.28 23 μ     0.20 to 0.26 51 μ     0.09 to 0.12 76 μ     0.06 to 0.08 102 μ    0.05 to 0.06
<b>14</b>	<b>OTR at 25 Deg.C. &amp; 85 % RH</b>	<b>Oxtran carrier gas method</b>	<b>With 250 μ PVC / Aclar OTR value</b> 15 μ    10.90 to 12.60 20 μ    10.70 to 12.35 23 μ    10.60 to 12.25 51 μ    9.6 to 11.10 76 μ    8.80 to 10.30 102 μ   8.20 to 9.54
<b>15</b>	<b>Winding quality</b>		<b>Should not be telescopic</b>

**Physiological properties are in accordance with FDA & EC recommendations.**