

# Pharma pack™

## Pharma pack DUPAC

Sr. No.	Particulars	Test method reference	Specifications
1	Thickness	DIN 53370	180 +/- 10 % 200 +/- 10% 250 +/- 5% 300 +/- 5% 350 +/- 5% 400 +/- 5% 450 +/- 5% 500 +/- 5% 600 +/- 5 %
2	GSM of PVDC (Dry)	DIN 53352	40 GSM +/- 5% 60 GSM +/- 5% 90 GSM +/- 5% 120 GSM +/- 5%
3	Total Thickness (Composite)	DIN 53370	= PVC thickness + (PVDC GSM/ 1.65*) * density of PVDC in g/cc
4	Total GSM (Composite)	DIN 53352	= (PVC thickness X 1.35*)+PVDC GSM * density of PVC in g/cc
3	Dimensional Stability	DIN 53377	LD – 5 % max TD + 2% max

<b>4</b>	<b>Tensile strength</b>	<b>ASTM – D 882</b>	<b>LD &amp; TD 450 kg/m<sup>2</sup> min</b>
<b>5</b>	<b>Elongation</b>	<b>ASTM – D 882</b>	<b>LD &amp; TD 30%</b>
<b>6</b>	<b>Toxicity</b>	<b>USP - 31</b>	<b>Non toxic</b>
<b>7</b>	<b>Softening point</b>	<b>Din 53460</b>	<b>76 to 77 Deg. C.</b>
<b>8</b>	<b>Scotch tape test</b>	<b>In house</b>	<b>Coating should not come out</b>
<b>9</b>	<b>Impact Strength</b>	<b>DIN 53448</b>	<b>≥ 450 Kj/in<sup>2</sup></b>
<b>10</b>	<b>VCM content</b>	<b>2002/72/EC</b>	<b>&lt; 1 ppm</b>
<b>11</b>	<b>Global migration</b>	<b>2002/72/EC</b>	<b>&lt; 10 ppm</b>
<b>12</b>	<b>WVTR at 38 Deg.C. &amp; 90 % RH</b>	<b>DIN 53122</b>	<b>With 250 μ PVC WVTR value 40 GSM ≤ 0.6 60 GSM ≤ 0.5 90 GSM ≤ 0.3 120 GSM ≤ 0.15</b>
<b>13</b>	<b>OTR at 23 Deg.C. &amp; 85 % RH</b>	<b>Oxtran carrier gas method</b>	<b>With 250 μ PVC OTR value 40 GSM ≤ 1.15 60 GSM ≤ 1.0 90 GSM ≤ 0.7 120 GSM ≤ 0.16</b>

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