

# EVACAST®

# TECHNICAL DATA SHEET

Translucent Sand / pearl

## Composition

- Polypropylene sheet
- Halogen free, no substances that can damage the ozone layer
- Inert waste, non toxic and 100% recyclable
- Decomposition products by fire : carbon dioxide CO<sub>2</sub>, vapour H<sub>2</sub>O

## Chemical properties

- Resistant to water, fats, alcohols and some solvents.
- Polypropylene can swell if exposed to certain solvents.
- Polypropylene along with several other plastics, can be distorted by some conventional litho inks. If the Evacast® is to be used within a litho printed job, avoid litho inks with mineral oil distillate. Vegetable / Soya based inks or similar are known to work well. Check with your ink supplier. Perform trials if in any doubt.

## Physical properties

Properties	Units	Test method**	Values**	Tolerances
Thickness	µm	ISO 4593	280 à 2000	+0,02mm / -0,03mm
Density	g/cm <sup>3</sup>		0,91	+/- 0,01 g/cm <sup>3</sup>
Flexural Elastic Modulus	MPa	ASTM D 790 tested on 500µm sample	760	+/-5%
Tensile strength at failure	N/mm <sup>2</sup>		> 20	
Elongation at failure	%		> 100	
Tensile Impact test	KJ/m <sup>2</sup>	ISO 8256 tested on 500µm sample	230	
Elmendorf Tear resistance	mN	ISO 1974 tested on 500µm sample	5400	+/-3%

\*\* These values are given as indicative for a standard quality and based on the standards mentioned.

The physical properties of the material will change with the temperature conditions.

Near or below 0°C, the material will become brittle. Therefore, for low temperature applications, please contact us for a specific product.

As a thermoplastic, the material may lose stiffness, with increasing temperatures. It may also swell. These changes are noticeable around 70°C. The Melting point of our product is around 140°C.

## Sheets size tolerance

Sheet size : 0/+5mm ( machine and cross direction )  
option of guillotine trimming

Sheet flatness : 5mm on both sides

## Use conditions

- Acclimatisation at room temperature 24 to 48h after delivery
- Pallets not to be stacked.

## Printing on Evacast®

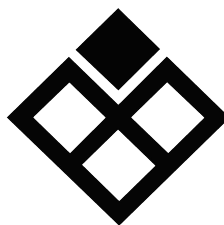
### Printing UV technology

• Evacast is corona treated on both sides to enable it to be printed in UV offset, UV screen, and UV digital. At the time of production, the surface energy is above 46 dynes/cm - but this declines over time. We recommend that Evacast is printed within 6 months from the date of production- for embossed grades, and 3 months for gloss products. (Exact production date is on the label). Keeping the material in its original wrappers and stored in a place without wide variations in temperature - or high humidity is very important. We recommend testing the suitability of the material prior to printing.

- Evacast suggest 4 sides trimmed material for automatic feeding. Our products are treated with an antistatic agent to help with feeding and reduce dust.
- Evacast recommend using inks that are specifically formulated for polypropylene. For more information please contact your ink supplier. Trial / test runs are always advised.
- A UV varnish or sealer is suggested to help protect the image and reduce scratching.

### Other printing technology

Conventional screen (1 pack or 2 packs inks.) Evacast® can be printed with a surface tension below 40 dyne/cm. It is recommended to test before printing.



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### Cutting / Creasing on Evacast®

- Evacast recommend converting the material at temperature around 20°C.
- Cutting and creasing are possible on manual and auto-platens, as used in the cardboard industry. Creasing is mainly done "cold", i.e. normal working conditions. It can also be done with heat for high thickness or special cases.
- Use of semi-cutting blades for creasing is not advisable for Evacast® because they may generate an initial tear.
- In any case, the creasing process lengthens the material, and it is necessary to take this into account during the tooling design and manufacture.
- Cutting Evacast® in smaller sizes than delivered, especially A4 size and smaller, can release tension within the sheet, that can cause curl.

### Assembling

- Evacast® can be glued, screwed, punched, perforated, sewn, ultrasonic /hot air welded...
- For glueing, we recommend 2 different types :
  - hot melt polyurethane reactive ( PUR )
  - cyanoacrylates
- If Evacast® is in contact with printed surfaces (Evacast® used as cover) or laminating, we recommend that you test Evacast® compatibility with the other products involved. Indeed, some glue components, and inks containing a proportion of distillates, used in paper printing, can generate curl when in contact with Evacast®.

### Compliance with legislation

Colour	toy norm EN 71/3	food regulation Directive 2002/72/EC	Coneg norm Directive 1994/62/EC	RoHS Directive 2002/95/CE
Natural 0010	✓	✓	✓	✓
Lemon zest 0024	✓	✓	✓	✓
Raspberry 0029	✓	✓	✓	✓
Dark blue 0014	✓	✓	✓	✓
Pale blue 0028	✓	✓	✓	✓
Pacificblue 0031	✓	✓	✓	✓
Lime zest 0032	✓	✓	✓	✓
Other colours	Please contact us			

✓ complies with the mentioned standard.

**Toys norm** : NF EN 71-3 (March 1995)  
relating to safety of toys – Part 3 : migration of certain elements.

**Food regulation** : comply with Directive 2002/72/EC (Commission of 6 August 2002)  
relating to plastics materials and articles intended to come into contact with foodstuffs as well as its successive amendments  
Nota bene : When legislation specifies maximum migration levels, these must always be checked on the finished product using the recognized test methods of the country concerned.

**Coneg norm (USA) & Directive 94/62/EC** :  
relating to packaging and packaging waste  
Heavy metals (cadmium, lead, mercury, and chromium (VI)) content below 100ppm.

**RoHS Directive 2002/95/EC (European Parliament and the Council of 27 January 2003)** :

comply with requirements on the restriction of use of certain hazardous substances in electrical and electronic equipment. Compounds of heavy metals (Cadmium, Lead, Mercury and Chromium VI) and flame retardants (polybrominated biphenyls (PBB), polybrominated diphenyl ethers (PBDE)) have not been intentionally added in our formulation while manufacturing. Therefore, our Evacast products do not contain any of these compounds with the exception of traces

### Storage conditions

Store in its original plastic wrapping, at a temperature around 20°C, away from light.

*The information contained within this document are non contractual and are based on data given by our suppliers and on the present state of our knowledge. They are given in good faith and considered as correct. The manufacturer reserves the right to change the product, or its technical characteristics, without notice. However, as we do not control post-processing techniques and conditions of use, this information may not be extended to end products and does not constitute a guarantee for any specific application. So, you are requested to check its validity and suitability for the intended method of converting and application.*

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