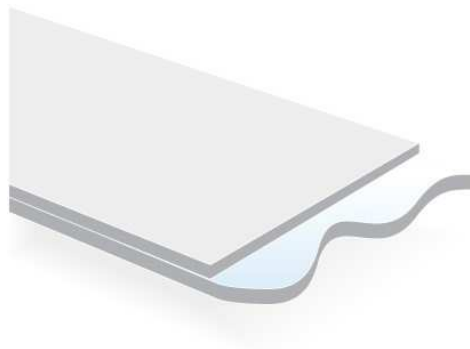


Paper based peelable lidding material C1S 90 paper/ multilayer coating 34gsm

- High quality printing paper and peelable barrier coating
- Soft and constant easy peel properties.
- Wide sealing temperature window
- Good mechanical properties
- Good aroma, grease, water vapour and gas barrier
- Suitable to be used in all the most common printing methods (flexo, offset, rotogravure, UV-flexo etc.)
- Enables use of metal detectors in product quality control
- Can be recycled or burned to produce energy



Applications

WALKI®Lid UNI is a paper based lidding material for packing of a wide range of products. Typical end-uses are dryfood, ice creams, salads, desserts, yoghurt and other dairy products in PS, PP, APET, HDPE and PE-carton cups.

Food Safety

All materials used in WALKI®Lid UNI are suitable for food packaging in accordance with BfR and / or EU requirements. The total content of heavy metals in the raw materials is in compliance with EU directive 94/62/EC (<100ppm).

PROPERTY	TEST METHOD	TEST CONDITIONS	UNITS		TYPICAL VALUES
Grammage	ISO 536	23°C 50% RH	g/m ²		124
Thickness	ISO 534	23°C 50% RH	µm		119
Tensile Strength	ISO 1924-2	23°C 50% RH	kN/m	MD	8,8
		23°C 50% RH	kN/m	CD	3,65
Tear Strength	ISO 1974	23°C 50% RH	mN	MD	820
		23°C 50% RH	mN	CD	915
Burst strength	ISO 2758	23°C 50% RH	kPa		345
WVTR	ISO 2528	23°C 50% RH	g/m ² *d		< 8
OTR	DIN 53380-S	23°C 50% RH	cm ³ /m ² *d		< 50

All technical values are measured in our laboratory in conditions of 23°C 50%RH and are indicative

Recommended to be used within one year after dispatch from our factory. Optimum storage conditions are +20°C, 50 – 60 % relative humidity and covered with the original packaging, which contains a moisture barrier. Concentration level of heavy metals present complies with the demands of the directive 94/62/EC.

Customers are responsible for their own product testing, evaluation and safety procedures. Customers should contact Walki if they have any queries regarding safety procedures or end use applications.

Walki Oy - Henri Torkkola

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Heat Sealing

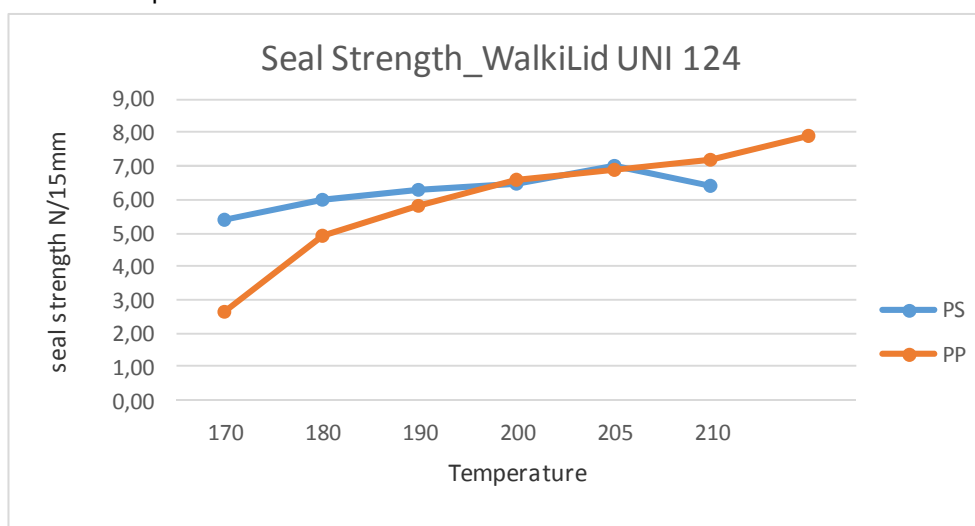
The main factors affecting the heat sealing and peeling performance is the heat sealing temperature, time and pressure, design and condition of the sealing heads and design of the cup.

Recommended heat sealing settings for the packaging line:

PS cups: 185°C / 0.6 s / 5 bar (Operating area: 170 – 230°C / 0.4–1.0 s / 4.0 – 6.0 bar)

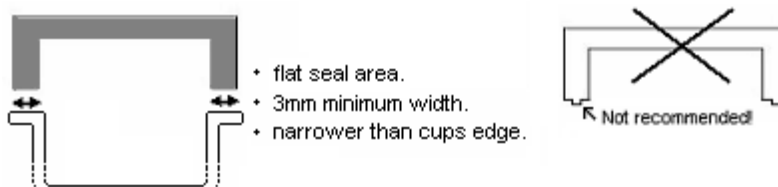
PP cups: 200°C / 0.6 s / 5 bar (Operating area: 185 – 235°C / 0.5–1.0 s / 4.0 – 6.0 bar)

PE-carton cups: 165°C / 0.6s / 5 bar



Sealing head design recommendations:

1. Flat sealing heads with minimum width of 3mm are recommended.
2. Width of the sealing area must be narrower than cup sealing area.



Note!

Use clean sealing heads with good temperature control and heat distribution properties. Poor heat sealing results may be caused because of too low or too high temperature settings, wrong temperature / time / pressure ratio, dirty or scratched sealing heads, poor designs of sealing head and/or cup, sticking of ink or lacquer onto sealing heads or droplets of foodstuff in the sealing area.

Storing

Proper storing conditions for WALKI®Lid are moisture resistance wrappings, controlled humidity conditions, RH 45 – 55%, temperature range 10 – 25°C. Prior to application lid piles to should be kept in vertical position, if stored at temperature colder than room temperature, lid piles should be brought into room temperature 1 – 2 days before application and pile packages not to be left open more than only some hours as variation in moisture balance may affect performance of the material.

Printing

Moisture and heat resistant overcoat lacquer is recommended on top of the printing inks in order to protect the printing inks during the heat sealing process and prevent moisture to be absorbed into the material. Too high drying temperatures and too fast cooling after the lacquering must be avoided in order to prevent curling of the material. Drying temperatures 60 – 70°C are recommended. Sharp knives should be used when die cutting the material.