



1. PURPOSE

To establish definitive quality standards on foil rolls, thereby minimizing claims attributable to any lack of understanding between supplier and customer.

2. OBJECTIVE

This specification covers 1235 or 8011 alloy foil master rolls for flexible packaging foil and describes the quality attributes of the master foil rolls.

3. PHYSICAL REQUIREMENTS

3.1 ALLOY AND TEMPER

Alloy and temper should correspond to Table 1.

Table 1

Alloy	Temper
1235、8011	O

3.2 MECHANICAL PROPERTIES

Mechanical properties should correspond to Table 2.

Table 2

Alloy	Temper	Gauge, mm	Tensile Strength Mpa	Elongation, %
1235	O	0.006-0.007	60-80	≥ 0.5
		0.007-0.009	60-80	≥ 1.0
		0.009-0.02	60-80	≥ 1.0
8011	O	0.009-0.03	80-100	≥ 2.0

3.3 SPECIFICATION AND TOLERANCE

The specification is as below Table 3.

Table 3

Gauge mm	Gauge Tolerance mm	Width mm	Width Tolerance mm	ID mm	OD mm
0.006~0.030	±5%	40~ 1600	±1	Ø 76.2 Ø 150 Ø 152	600max to ID 76.2 900max to ID 150 & 152
Note: When the customer has special requirement, it has to be negotiated with supplier and demander.					

3.4 CHEMICAL COMPOSITION

The chemical composition should correspond to Table 4. (Unit: %)

Table 4

Alloy	Si	Fe	Cu	Mn	Mg	Zn	Ti	Remark	Others		Al
									Single	Total up	
1235	0.12~0.16	0.45~0.52	0.02	0.01	0.01	0.01	0.02	Fe/Si=2.5~4	0.03		>99.35
8011	0.30~1.1	0.40~1.0	0.10	0.10	0.05	0.10	0.08		0.05	0.15	Remainder

3.5 SURFACE CONDITION

3.5.1 The surface shall be cleaned and free from inclusions, scratches, wrinkles, cracks, overlapping or other internal defects.

3.5.2 Pin-holes

The pin-holes should correspond to Table 5.

Table 5

Gauge mm	0.006	0.0065	0.007	0.007~0.0075	0.009	>0.009~0.011	>0.011~0.015	>0.015~0.020	>0.020
Pinholes/m ²	≤800	≤400	≤200	≤100	≤50	≤20	≤5	≤1	0
Note: When the customer has special requirement, it has to be negotiated with supplier and demander.									

3.5.3 Splices

The splices are as below Table 6.

Table 6

Roll Diameter, mm	Splices
≤400	≤1
>400	≤2

a) All splices to be ultrasonic/tape.

- b) It is allowed one splice per roll. (Max. once per 2000m)
- c) Marked at the roll edge with a film, placed close to the splice.

3.5.4 Wettability

The wettability corresponds to A grade quality.

4. PACKING AND SHIPPING REQUIREMENTS

4.1 Quantities – As specified on the purchase order with a tolerance of +/- 10% unless otherwise stated on the order.

4.2 Packaging – Foil rolls are to be packed in collapsible aluminum racks or steel racks as specified in such a manner that normal handling by common carrier will ensure safe transportation without damage to the foil. This includes wrapping to protect the foil from water stain and corrosion.

4.3 Identification – Each roll shall be identified with the following:

- a) Order number (release number)
- b) Part number (from RMC Purchase Order)
- c) Gauge (mm)
- d) Width (mm)
- e) Net weight (kg)