



# Specification

KRONES Film Specifications  
Stretch film and cover film for stretch  
wrapper



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# 1 General information

This specification contains a broad range of packaging options. These possible combinations of material and material characteristics require a release by KRONES in all cases.

With standard equipment, in terms of packaging, customer materials that are already available can be checked and released for start-up by KRONES. If no packaging materials are provided yet by the customer, KRONES provides recommendations (pack-specific proposals), which must be confirmed by the customer. The drawings prepared by KRONES apply.

Following successful customer acceptance under production conditions on site, the packaging material used is logged, countersigned by both parties and approved for processing on this machine.

In the event of subsequent changes to the material and packaging, it is the customer's responsibility to inform KRONES AG about the matter and to obtain a release. KRONES reserves the right to perform tests under conditions closely simulating production if changes are made to material or packaging by the customer. The test materials required for this purpose must be provided by the customer.

The scopes used for this test are agreed in advance with KRONES AG and could comprise the following, for example:

- One reel of stretch film per size; for double-head machines two reels
- One reel of cover film per size

Test results are recorded and given to the customer. Manual samples and/or finished pallets are provided for examination. If the results reveal no defects for the customer, they are recorded in writing, signed by the customer and by KRONES and approved again for processing on the related machine. If the tests show that the defects which are the subject of the customer's complaint are caused not by the design of the machine, but rather by the material, which is outside of KRONES specifications, KRONES reserves the right to bill the customer for costs incurred at standard market rates.

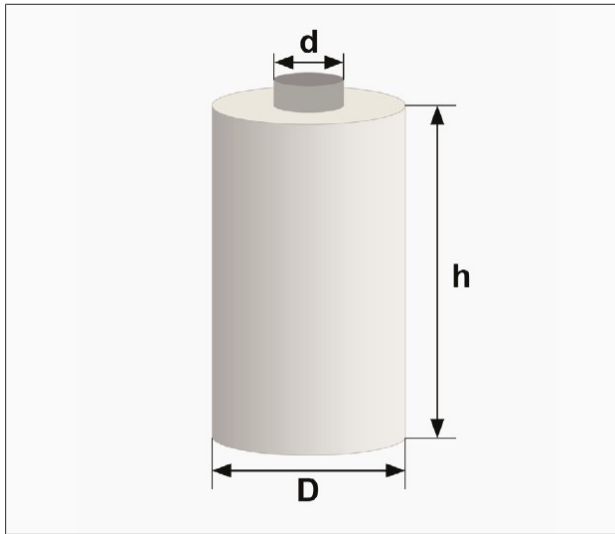
## 2 Delivery and storage of LDPE films

Characteristics	Requirements
Storage at the machine	At least 24 hours before processing
Relative humidity	40 - 70 %
General storage environment	Protection against direct sunlight, high temperatures (>30 °C), mechanical damage, dust and humidity.
Storage duration	Storage in original packaging Max. ½ year
Transport	On pallets with cartons, pallet cards and pallet straps (see illustration below)



Fig. 1: Pallet with stretch film

### 3 Dimensional properties and material parameters



All technical data (dimensions, production etc.) regarding the film reels are included in the supplier's documentation.

Fig. 2: Film reel

#### 3.1 Stretch film

Specification	500 mm/20"	750 mm/30"	1,000 mm/40"
Max. reel weight	20 kg	25 kg	25 kg
Maximum reel height	500 mm	750 mm	1,000 mm
Maximum outer diameter D	250 mm		
Inner diameter (d)	76 mm		
Film thickness	23-30 µm		
Film type	LLDPE polyethylene stretch film		
Adhesive side	Internal adhesive If the adhesive side is external, a clarification with the manufacturer of the stretch wrapper is necessary.		
Elongation in percent	150-400 %		
Unwinding speed (low)	Up to 20 rpm		
Unwinding speed (medium)	Up to 40 rpm		
Unwinding speed (high)	Up to 70 rpm		



**Important!**

Please only use stretch films of high quality in order to achieve good elongation values and to avoid film checks.



## 3.2 Cover film

Specification	Pallet: 600x800 mm	Pallet: 1,200x1,000 mm
Film width	1,200 mm (max. 2,000 mm)	1,800 mm (max. 2,000 mm)
Maximum outer diameter D	250 mm	
Inner diameter (d)	76 mm	
Film thickness	60-90 $\mu\text{m}$	
Film type	LLDPE polyethylene stretch film	