TECHNICAL SPECIFICATIONS

19-10-2026 rel.31

General Tolerance except Prestretched film

These Technical Specifications define the general manufacturing tolerances applicable to HIPAC stretch films. The specific product characteristics, including film type, width, thickness, length and reel configuration, are defined according to the customer's order and/or specifications. The customer selects the product characteristics according to the intended application and the packaging to be produced.

Internal Ø (mm)	Core length (mm)	Core weight (g)	Film Thickness (µ)	** Film width (mm) [a]	Film length	Core weight	Internal Core Ø (mm)	Core length (mm)	Reel weight
50	520	200/300	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±8	±5%	±7%	±1,5	+6 -3	±5%
50	520	500	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±8	±5%	±10%	±1,5	+6 -3	±5%
50	520	600/700/800	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±8	±5%	±9%/±8%/±7%	±1,5	+6 -3	±5%
50	470	180/270/450	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±8	±5%	± 7%	±1,5	+6 -3	±5%
50	260	220	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±8	±5%	±7%	±1,5	+6 -3	±5%
50	73/153/128/103	128/267/224/180	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±3	±5%	±7%	±1,5	+6 -3	±5%
38	140/128/103	85/75/60	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±3	±5%	±8%	±1,5	+3 -2	±5%
38 R[b]	103/128/260	89/110/220	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±3	±5%	±7%	±1,5	+3 -2	±5%
76	520[c]	850	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±8	±5%	±5%	±1,5	+6 -3	±5%
76	510/510/1.010	1.000/1.700/3.367	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±8	±5%	±5%	±1,5	+6 -3	±5%
76	385/510/760	1.283/1.800/2.550	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±8	±5%	±5%	±1,5	+6 -3	±5%
76	1.260	4.200	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±8	±5%	±5%	±1,5	+6 -3	±5%
76[d]	510	1.860	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±8	±5%	±5%	±1,5	+6 -3	±5%
76	510	1.950	23-35 ±2	±8	±5%	±7%	±1,5	+6 -3	±5%
76	255/128/103	850/427/333	7-23 ±1 - 24-35 ±2 – 36-80 ±3	±8	±5%	±5%	±1,5	+6 -3	±5%

[a] During the first 20 meters of the coil ±25 mm. In case of reinforced edges the value of 8mm will be of 15mm.
[b] Reinforced core.
[c] To be used only in 5Kg total reel weight.
[d] Plastic core. To be used only for printed Films. Non-returnable plastic core.

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TECHNICAL SPECIFICATIONS

5-10-2026 rel.30

Prestretched film Tolerance.

Internal Ø (mm)	Core length	Film Thickness (µ)	Film width (mm)	Film length	Core weight	Internal Core Ø (mm)	Core length (mm)	Reel weight
76	**460 mm weight 1,533 Kg**	±1	±10	±7%	±5%	±1,5	+6 -3	± 7%
50	**470 mm weight 0,27 Kg**	±1	±10	±7%	±7%	±1,5	+6 -3	± 7%
50	**470 mm weight 0,45 Kg**	±1	±10	±7%	±7%	±1,5	+6 -3	± 7%

"Sun light Resistance" for printed film.

June-July-August	September-April-May	October-November-March	December-January-February
40 days	120 days	240 days	720 days

- The above mentioned values (tested with instrument XENOTEST 150 S) are considered with the sun light in the range of the Washington meridian; Exposure from 9:00 to 15:00.
- Although HIPAC uses colours with "Light Resistance" index 7 for printing but due to the fact that the film can be exposed under innumerable situations which mean uncontrolled solar radiation quantities absorbed, HIPAC does not guarantee the duration and appearance of the printing in printed films.

Printed film Tolerance.

For printed films the printing width and/or height can vary, depending on the thickness, by 5%.

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TECHNICAL SPECIFICATIONS

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NETROLL film tolerances (Prestretched and non Prestretched film)

Roll type	Film Thickness (µ)	Film width (mm)	Film length	Roll type	Internal Core Ø (mm)	Reel weight
Automatic	9-23 ±1 - 24-35 ±2	±8	±5%	Automatic	74±4	±5%
Manual	9-23 ±1 - 24-35 ±2	±8	±5%	Manual	45±5	±5%

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