

PROPERTY	TEST METHOD	FREQUENCY ⁽¹⁾	UNIT Imperial	Solmax 820-1000	Solmax 830-1000	Solmax 840-1000	Solmax 860-1000	Solmax 880-1000	Solmax 900-1000
SPECIFICATIONS									
Thickness (min. avg.)	ASTM D-5199	Every roll	mils	20.0	30.0	40.0	60.0	80.0	100.0
Thickness (min.)	ASTM D-5199	Every roll	mils	18.0	27.0	36.0	54.0	72.0	90.0
Resin Density	ASTM D-1505	1/Batch	g/cc	< 0.926	< 0.926	< 0.926	< 0.926	< 0.926	< 0.926
Melt Index - 190/2.16 (max.)	ASTM D-1238	1/Batch	g/10 min	1.0	1.0	1.0	1.0	1.0	1.0
Sheet Density (8)	ASTM D-1505	Every 2 rolls	g/cc	≤ 0.939	≤ 0.939	≤ 0.939	≤ 0.939	≤ 0.939	≤ 0.939
Carbon Black Content (9)	ASTM D-4218	Every 2 rolls	%	2.0 - 3.0	2.0 - 3.0	2.0 - 3.0	2.0 - 3.0	2.0 - 3.0	2.0 - 3.0
Carbon Black Dispersion	ASTM D-5596	Every 6 rolls	Category	Cat. 1 & Cat. 2	Cat. 1 & Cat. 2	Cat. 1 & Cat. 2	Cat. 1 & Cat. 2	Cat. 1 & Cat. 2	Cat. 1 & Cat. 2
OIT - standard (avg.)	ASTM D-3895	1/Batch	min	100	100	100	100	100	100
Tensile Properties (min. avg) (2)	ASTM D-6693	Every 2 rolls							
Strength at Break			ppi	76	114	160	228	320	380
Elongation at Break			%	700	750	800	800	800	800
2% Modulus (max.)	ASTM D-5323	Per formulation	ppi	1,200	1,800	2,400	3,600	4,800	6,000
Tear Resistance (min. avg.)	ASTM D-1004	Every 6 rolls	lbf	11	16	22	34	45	55
Puncture Resistance (min. avg.)	ASTM D-4833	Every 6 rolls	lbf	28	46	62	92	123	140
Dimensional Stability	ASTM D-1204	Every 6 rolls	%	± 2	± 2	± 2	± 2	± 2	± 2
Multi-Axial Tensile (min.)	ASTM D-5617	Per formulation	%	30	30	30	30	30	30
Oven Aging - % retained after 90 days	ASTM D-5721	Per formulation							
STD OIT (min. avg.)	ASTM D-3895		%	35	35	35	35	35	35
HP OIT (min. avg.)	ASTM D-5885		%	60	60	60	60	60	60
UV Resistance - % retained after 1600 hr	GRI-GM-11	Per formulation							
HP-OIT (min. avg.)	ASTM D-5885		%	35	35	35	35	35	35
SUPPLY SPECIFICATIONS (Roll dimensions may vary ±1%)									
Roll Dimension - Width	-		ft	22.3	22.3	22.3	22.3	22.3	22.3
Roll Dimension - Length	-		ft	1,400	1,000	780	520	400	320
Area (Surface/Roll)	-		sf	31,220	22,300	17,394	11,596	8,920	7,136

NOTES

1. Testing frequency based on standard roll dimensions and one batch is approximately 180,000 lbs (or one railcar).
2. Machine Direction (MD) and Cross Machine Direction (XMD or TD) average values should be on the basis of 5 specimens each direction.
8. Correlation table is available for ASTM D792 vs ASTM D1505. Both methods give the same results.
9. Correlation table is available for ASTM D1603 vs ASTM D4218. Both methods give the same results.

* All values are nominal test results, except when specified as minimum or maximum.

* The information contained herein is provided for reference purposes only and is not intended as a warranty of guarantee. Final determination of suitability for use contemplated is the sole responsibility of the user. SOLMAX assumes no liability in connection with the use of this information.

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PROPERTY	TEST METHOD	FREQUENCY ⁽¹⁾	UNIT Imperial	Solmax 830ST-1000	Solmax 840ST-1000	Solmax 860ST-1000	Solmax 880ST-1000
SPECIFICATIONS							
Thickness (min. avg.)	ASTM D-5994	Every roll	mils	28.5	38.0	57.0	76.0
Lowest individual for 8 out of 10 values			mils	27.0	36.0	54.0	72.0
Lowest individual for 10 out of 10 values			mils	25.5	34.0	51.0	68.0
Asperity Height (min. avg.) (3)	ASTM D-7466	Every roll	mils	10	15	15	15
Resin Density	ASTM D-1505	1/Batch	g/cc	< 0.926	< 0.926	< 0.926	< 0.926
Melt Index - 190/2.16 (max.)	ASTM D-1238	1/Batch	g/10 min	1.0	1.0	1.0	1.0
Sheet Density (8)	ASTM D-1505	Every 2 rolls	g/cc	≤ 0.939	≤ 0.939	≤ 0.939	≤ 0.939
Carbon Black Content (9)	ASTM D-4218	Every 2 rolls	%	2.0 - 3.0	2.0 - 3.0	2.0 - 3.0	2.0 - 3.0
Carbon Black Dispersion	ASTM D-5596	Every 6 rolls	Category	Cat. 1 & Cat. 2	Cat. 1 & Cat. 2	Cat. 1 & Cat. 2	Cat. 1 / Cat.2
OIT - standard (avg.)	ASTM D-3895	1/Batch	min	100	100	100	100
Tensile Properties (min. avg) (2)	ASTM D-6693	Every 2 rolls					
Strength at Break			ppi	52	100	132	171
Elongation at Break			%	250	400	400	400
2% Modulus (max.)	ASTM D-5323	Per formulation	ppi	2,100	2,400	3,600	4,797
Tear Resistance (min. avg.)	ASTM D-1004	Every 6 rolls	lbf	16	26	36	49
Puncture Resistance (min. avg.)	ASTM D-4833	Every 6 rolls	lbf	34	56	84	111
Dimensional Stability	ASTM D-1204	Every 6 rolls	%	± 2	± 2	± 2	± 2
Multi-Axial Tensile (min.)	ASTM D-5617	Per formulation	%	30	30	30	30
Oven Aging - % retained after 90 days	ASTM D-5721	Per formulation					
STD OIT (min. avg.)	ASTM D-3895		%	35	35	35	35
HP OIT (min. avg.)	ASTM D-5885		%	60	60	60	60
UV Resistance - % retained after 1600 hr	GRI-GM-11	Per formulation					
HP-OIT (min. avg.)	ASTM D-5885		%	35	35	35	35
SUPPLY SPECIFICATIONS (Roll dimensions may vary ±1%)							
Roll Dimension - Width	-		ft	22.3	22.3	22.3	22.0
Roll Dimension - Length	-		ft	1,000	780	540	400
Area (Surface/Roll)	-		sf	22,300	17,394	12,042	8,800

NOTES

1. Testing frequency based on standard roll dimensions and one batch is approximately 180,000 lbs (or one railcar).
2. Machine Direction (MD) and Cross Machine Direction (XMD or TD) average values should be on the basis of 5 specimens each direction.
3. Of 10 readings; 8 out of 10 must be >7 mils (0.18 mm), and lowest individual reading must be >5 mils (0.13 mm). ASTM D7466 is identical to GRI-GM12.
8. Correlation table is available for ASTM D792 vs ASTM D1505. Both methods give the same results.
9. Correlation table is available for ASTM D1603 vs ASTM D4218. Both methods give the same results.

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PROPERTY	TEST METHOD	FREQUENCY ⁽¹⁾	UNIT Imperial	Solmax 830T-1000	Solmax 840T-1000	Solmax 860T-1000	Solmax 880T-1000	Solmax 900T-1000
SPECIFICATIONS								
Thickness (min. avg.)	ASTM D-5994	Every roll	mils	28.5	38.0	57.0	76.0	95.0
Lowest individual for 8 out of 10 values			mils	27.0	36.0	54.0	72.0	90.0
Lowest individual for 10 out of 10 values			mils	26.0	34.0	51.0	68.0	85.0
Asperity Height (min. avg.) (3)	ASTM D-7466	Every roll	mils	10	15	15	15	15
Resin Density	ASTM D-1505	1/Batch	g/cc	< 0.926	< 0.926	< 0.926	< 0.926	< 0.926
Melt Index - 190/2.16 (max.)	ASTM D-1238	1/Batch	g/10 min	1.0	1.0	1.0	1.0	1.0
Sheet Density (8)	ASTM D-1505	Every 2 rolls	g/cc	≤ 0.939	≤ 0.939	≤ 0.939	≤ 0.939	≤ 0.939
Carbon Black Content (9)	ASTM D-4218	Every 2 rolls	%	2.0 - 3.0	2.0 - 3.0	2.0 - 3.0	2.0 - 3.0	2.0 - 3.0
Carbon Black Dispersion	ASTM D-5596	Every 6 rolls	Category	Cat. 1 & Cat. 2	Cat. 1 & Cat. 2	Cat. 1 & Cat. 2	Cat. 1 & Cat. 2	Cat. 1 & Cat. 2
OIT - standard (avg.)	ASTM D-3895	1/Batch	min	100	100	100	100	100
Tensile Properties (min. avg) (2)	ASTM D-6693	Every 2 rolls						
Strength at Break			ppi	45	100	132	176	150
Elongation at Break			%	250	400	400	400	250
2% Modulus (max.)	ASTM D-5323	Per formulation	ppi		2,400	3,600	4,800	6,000
Tear Resistance (min. avg.)	ASTM D-1004	Every 6 rolls	lbf	16	26	36	50	55
Puncture Resistance (min. avg.)	ASTM D-4833	Every 6 rolls	lbf	33	56	84	112	110
Dimensional Stability	ASTM D-1204	Every 6 rolls	%	± 2	± 2	± 2	± 2	
Multi-Axial Tensile (min.)	ASTM D-5617	Per formulation	%	30	30	30	30	30
Oven Aging - % retained after 90 days	ASTM D-5721	Per formulation						
STD OIT (min. avg.)	ASTM D-3895		%	35	35	35	35	35
HP OIT (min. avg.)	ASTM D-5885		%	60	60	60	60	60
UV Resistance - % retained after 1600 hr	GRI-GM-11	Per formulation						
HP-OIT (min. avg.)	ASTM D-5885		%	35	35	35	35	35
SUPPLY SPECIFICATIONS (Roll dimensions may vary ±1%)								
Roll Dimension - Width	-		ft	22.3	22.3	22.3	22.0	22.0
Roll Dimension - Length	-		ft	1,000	780	540	400	265
Area (Surface/Roll)	-		sf	22,300	17,394	12,042	8,800	5,830

NOTES

1. Testing frequency based on standard roll dimensions and one batch is approximately 180,000 lbs (or one railcar).
2. Machine Direction (MD) and Cross Machine Direction (XMD or TD) average values should be on the basis of 5 specimens each direction.
3. Of 10 readings; 8 out of 10 must be >7 mils (0.18 mm), and lowest individual reading must be >5 mils (0.13 mm). ASTM D7466 is identical to GRI-GM12.
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