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Asia Pacific Industry Group Co., Limited

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Printing-Grade BOPA Film, Grade OA, 12 – 25 µm
印刷级 BOPA 尼龙薄膜 OA 牌号，12 – 25 µm

TECHNICAL DATA SHEET 技术数据表 | APIG-TDS-BOPA-OA-2026 | Issue date 2026-07-01 Rev. 1.0

PRODUCT 产品说明

OA printing-grade BOPA film, manufactured by a high-speed two-step biaxial stretching process.
OA 印刷级 BOPA 尼龙薄膜，采用高速两步法双向拉伸工艺生产。

APPLICATIONS 应用

- 5 – 6 色高速印刷包装（封边宽度 ≤3 cm）
  5–6 colour high-speed printing lamination, seal width ≤ 3 cm
- 冷冻食品包装
  Frozen food packaging
- 水煮包装（≤100 ℃）
  Boiled packaging, up to 100 °C
- 真空包装
  Vacuum packaging

KEY PHYSICAL PROPERTIES 主要物理性能

性能 Property	测试方法 Test method	单位 Unit	12 µm	15 µm	20 µm	25 µm	规格限值 Spec. limits
厚度 Thickness	/	µm	12	15	20	25	/
厚度偏差 Thickness tolerance	/	%	±3	±2	±2	±2	/
拉伸强度 Tensile strength — MD	ASTM D882	MPa	212	208	210	221	≥ 180
		MPa	272	267	272	265	≥ 180
断裂伸长率 Elongation at break — MD	ASTM D882	%	143	145	150	142	≥ 100
		%	102	112	110	112	≥ 100
热收缩率（160 ℃，5 min）Heat shrinkage — MD	ASTM D1204	%	1.5	1.5	1.5	1.5	≤ 3.0
		%	1.0	1.0	1.0	1.0	≤ 2.0
摩擦系数 COF（静 / 动 Static / dynamic）	ASTM D1894	/	0.32 0.30	0.28 0.25	0.30 0.28	0.28 0.26	≤ 0.6
表面张力（内面电晕）Surface tension, inside corona — 内面 Inside		mN/m	54	54	54	54	≥ 50
	ASTM D2578	mN/m	38	38	38	38	/
表面张力（双面电晕）Surface tension, both sides corona — 内面 Inside		mN/m	54	54	54	54	≥ 50
		mN/m	50	50	50	50	≥ 50
雾度 Haze	ASTM D1003	%	3.5	3.7	4.2	5.0	≤ 7.0
氧气透过率 OTR（23 ℃，0 % RH）	ASTM D3985	cm3/(m2·d·Pa)	7.0×10^-4	5.0×10^-4	4.5×10^-4	4.0×10^-4	≤15 µm：≤10.0×10^-4 >15 µm：≤5.0×10^-4
卷长 Roll length	/	m	6000 12000 18000	6000 12000 18000 24000	6000 12000	4000 8000	/
幅宽 Width	/	mm	300 – 1700				

MD: machine direction; TD: transverse direction. For COF the upper figure is static and the lower dynamic. Figures under each thickness are typical values, not specifications; only the spec. limits column is binding.
MD 为纵向，TD 为横向；摩擦系数上行静摩擦、下行动摩擦。各厚度列下数值为典型值，不作为规格；仅「规格限值」一列为承诺值。

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海关注册编码 Customs Reg. Code: 3401961393

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SUPPLY FORM 供货形式

Roll length per thickness as listed above; roll width 300 – 1,700 mm as standard. Customized length and width available upon agreement.

卷长按上表各厚度对应的组合供货；标准幅宽范围 300 – 1,700 mm；长度与幅宽可按约定定制。

INSTRUCTIONS FOR USE 使用说明

序号 No.	说明 Instructions (ZH)	Instructions (EN)
1	使用前检查并确认铝塑包装完好无损。	Check and confirm the aluminium-plastic packaging is intact before use.
2	上机印刷前才打开铝塑包装，避免待机期间尼龙膜吸潮。	Open the packaging only when ready to print, so the film does not absorb moisture during standby.
3	加工过程中车间保持温度 ≤25 ℃、相对湿度 ≤60 %。	During processing keep the workshop at ≤25 °C and ≤60 % RH.
4	印刷后仍需用铝塑包装保护膜卷，防止受潮。	After printing, re-pack the roll in aluminium-plastic packaging to protect it from moisture.
5	运输中轻拿轻放并做好缓冲，防止铝塑包装与卷端面受损。	Handle rolls with care in transit and use cushioning to protect the packaging and roll end faces.
6	开包后出现轻微皱折可剥除后继续使用；严重皱折请连同卷标拍照留证并反馈供方，同时防潮并暂停使用该卷。	Slight wrinkles after opening can be peeled off and the roll used on; for serious wrinkles, photograph the roll with its label, report it to the supplier, keep the roll dry and suspend use.

STORAGE AND SHELF LIFE 储存与保质期

Store in a cool, dry place, away from direct sunlight, rain and moisture, and away from heat sources. Keep the original packaging sealed; use as soon as possible after opening. Shelf life 24 months.

阴凉干燥处存放，避免阳光直射、雨淋与潮湿，远离热源；原包装未开封，开封后尽快使用。保质期 24 个月。

DOCUMENT CONTROL 文件控制

项目 Item	内容 Detail
文件编号 Document no.	APIG-TDS-BOPA-OA-2026
版本 Revision	1.0
生效日期 Effective date	2026-07-01
产品 Product	印刷级 BOPA 尼龙薄膜 OA 牌号 / Printing-grade BOPA film, Grade OA
规格范围 Scope	12 / 15 / 20 / 25 μm，幅宽 300 – 1,700 mm
替代文件 Replaces	本站原有 BOPA 技术数据表（已下线）Previous BOPA data sheet on this site (withdrawn)

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