

PROPERTY	TEST METHOD	FREQUENCY ⁽¹⁾	UNIT Imperial	Solmax 430-1000	Solmax 440-1000	Solmax 460-1000	Solmax 480-1000	Solmax 500-1000
SPECIFICATIONS								
Thickness (min. avg.)	ASTM D-5199	Every roll	mils	30.0	40.0	60.0	80.0	100.0
Thickness (min.)	ASTM D-5199	Every roll	mils	27.0	36.0	54.0	72.0	90.0
Resin Density	ASTM D-1505	1/Batch	g/cc	> 0.932	> 0.932	> 0.932	> 0.932	> 0.932
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	≥ 0.940	≥ 0.940	≥ 0.940	≥ 0.940	≥ 0.940
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 Yield			ppi	66	84	130	177	210
Elongation at Yield			%	13	13	13	13	12
Strength at Break			ppi	122	162	243	326	380
Elongation at Break			%	700	700	700	700	700
Tear Resistance (min. avg.)	ASTM D-1004	Every 6 rolls	lbf	21	28	42	57	70
Puncture Resistance (min. avg.)	ASTM D-4833	Every 6 rolls	lbf	60	80	122	155	180
Dimensional Stability	ASTM D-1204	Certification	%	± 2	± 2	± 2	± 2	± 2
Stress Crack Resistance (SP-NCTL)	ASTM D-5397	1/Batch	hr	500	500	500	500	500
Oven Aging - % retained after 90 days	ASTM D-5721	Per formulation						
HP OIT (min. avg.)	ASTM D-5885		%	80	80	80	80	80
UV Resistance - % retained after 1600 hr	GRI-GM-11	Per formulation						
HP-OIT (min. avg.)	ASTM D-5885		%	50	50	50	50	50
SUPPLY SPECIFICATIONS (Roll dimensions may vary ±1%)								
Roll Dimension - Width	-		ft	22.3	22.3	22.3	22.3	22.3
Roll Dimension - Length	-		ft	1,000	780	520	400	320
Area (Surface/Roll)	-		sf	20,494	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.

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Tel.: (450) 929-1234 Fax: (450) 929-2550 www.solmax.com

PROPERTY	TEST METHOD	FREQUENCY ⁽¹⁾	UNIT Imperial	Solmax 430ST-1000	Solmax 440ST-1000	Solmax 460ST-1000	Solmax 480ST-1000	Solmax 500ST-1000
SPECIFICATIONS								
Nominal Thickness	-	-	mils	30.0	40.0	60.0	80.0	100.0
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	16	16	16	16	16
Resin Density	ASTM D-1505	1/Batch	g/cc	> 0.932	> 0.932	> 0.932	> 0.932	> 0.932
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	≥ 0.940	≥ 0.940	≥ 0.940	≥ 0.940	≥ 0.940
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 Yield			ppi	63	88	132	176	210
Elongation at Yield			%	12	13	13	13	12
Strength at Break			ppi	46	88	132	167	150
Elongation at Break			%	100	150	150	150	100
Tear Resistance (min. avg.)	ASTM D-1004	Every 6 rolls	lbf	21	30	45	60	70
Puncture Resistance (min. avg.)	ASTM D-4833	Every 6 rolls	lbf	45	90	120	150	150
Dimensional Stability	ASTM D-1204	Certification	%	± 2	± 2	± 2	± 2	± 2
Stress Crack Resistance (SP-NCTL)	ASTM D-5397	1/Batch	hr	500	500	500	500	500
Oven Aging - % retained after 90 days	ASTM D-5721	Per formulation						
HP OIT (min. avg.)	ASTM D-5885		%	80	80	80	80	80
UV Resistance - % retained after 1600 hr	GRI-GM-11	Per formulation						
HP-OIT (min. avg.)	ASTM D-5885		%	50	50	50	50	50
SUPPLY SPECIFICATIONS (Roll dimensions may vary ±1%)								
Roll Dimension - Width	-		ft	22.3	22.3	22.3	22.3	22.3
Roll Dimension - Length	-		ft	1,000	780	560	440	320
Area (Surface/Roll)	-		sf	22,300	17,394	12,488	9,812	7,136



TECHNICAL DATA SHEET

Solmax Single-Sided Textured - Imperial Values

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PROPERTY	TEST METHOD	FREQUENCY ⁽¹⁾	UNIT Imperial	Solmax 430ST-1000	Solmax 440ST-1000	Solmax 460ST-1000	Solmax 480ST-1000	Solmax 500ST-1000
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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. Lowest individual and 8 out of 10 readings as per GRI-GM13 / 17, latest version.
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 430T-1000	Solmax 440T-1000	Solmax 460T-1000	Solmax 480T-1000	Solmax 500T-1000
SPECIFICATIONS								
Nominal Thickness	-	-	mils	30.0	40.0	60.0	80.0	100.0
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	16	16	16	16	16
Resin Density	ASTM D-1505	1/Batch	g/cc	> 0.932	> 0.932	> 0.932	> 0.932	> 0.932
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	≥ 0.940	≥ 0.940	≥ 0.940	≥ 0.940	≥ 0.940
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 Yield			ppi	66	88	132	176	210
Elongation at Yield			%	12	12	13	13	12
Strength at Break			ppi	66	88	132	167	150
Elongation at Break			%	150	150	150	150	150
Tear Resistance (min. avg.)	ASTM D-1004	Every 6 rolls	lbf	23	30	45	60	70
Puncture Resistance (min. avg.)	ASTM D-4833	Every 6 rolls	lbf	60	90	120	150	150
Dimensional Stability	ASTM D-1204	Certification	%	± 2	± 2	± 2	± 2	± 2
Stress Crack Resistance (SP-NCTL)	ASTM D-5397	1/Batch	hr	500	500	500	500	500
Oven Aging - % retained after 90 days	ASTM D-5721	Per formulation						
HP OIT (min. avg.)	ASTM D-5885		%	80	80	80	80	80
UV Resistance - % retained after 1600 hr	GRI-GM-11	Per formulation						
HP-OIT (min. avg.)	ASTM D-5885		%	50	50	50	50	50
SUPPLY SPECIFICATIONS (Roll dimensions may vary ±1%)								
Roll Dimension - Width	-		ft	22.3	22.3	22.3	22.3	22.3
Roll Dimension - Length	-		ft	1,000	780	540	420	320
Area (Surface/Roll)	-		sf	22,300	17,394	12,042	9,366	7,136

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