

TECHNICAL DATA SHEET

ALUMINIUM FOIL - A1235-O



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PRODUCT SPECIFICATION	
PROPERTY	SPECIFICATION
Product	Aluminium Foil
Alloy	A1235
Temper	O — Soft Temper
Application	Foils to be converted (print/laminate) for flexible packaging and insulation, suitable for heat sealing.
Thickness	5.0–60 µm
Width	70–1880 mm
Thickness tolerance — spot	±5%
Thickness tolerance — average per roll	±3%
Width tolerance	±1 mm when width is even; 0/+2 mm when width is odd
Core I/D	76 / 150 / 152 mm
Coil O/D	300–900 mm according to core configuration
Coil length	6,000–80,000 m according to core configuration

MECHANICAL PROPERTIES_A1235-O

THICKNESS (μm)	TENSILE STRENGTH	ELONGATION
5.0–5.5	Min. 70 MPa	Min. 1.4%
5.5–6.0	Min. 70 MPa	Min. 1.4%
6.0	Min. 70 MPa	Min. 1.6%
6.3–6.5	Min. 70 MPa	Min. 1.6%
7	Min. 70 MPa	Min. 1.6%
8	Min. 70 MPa	Min. 1.8%
9	Min. 70 MPa	Min. 2.0%
10–15	Min. 70 MPa	Min. 2.0%
15–20	Min. 70 MPa	Min. 3.0%
20–40	Min. 70 MPa	Min. 4.0%
41–60	Min. 75 MPa	Min. 10.0%

PINHOLE REQUIREMENTS_A1235-O

THICKNESS (μm)	MAXIMUM PINHOLES
≤5.5	≤1000 ph/m ²
5.5–6.0	≤600 ph/m ²
6.3–6.5	≤300 ph/m ²
7	≤100 ph/m ²
8–9	≤50 ph/m ²
10–15	≤10 ph/m ²
>15	0

For thickness 6–9 μm: maximum 1 hole (or roll mark) per metre; maximum hole area 0.09 mm².

CHEMICAL COMPOSITION_A1235-O	
ELEMENT	SPECIFICATION, %
Fe	≤0.65
Si	≤0.05
Cu	≤0.03
Zn	≤0.01
Mg	≤0.01
Mn	≤0.05
Ti	≤0.05
V	≤0.03
Other — individual	—
Other — total	—
Al	≥99.35

Heavy metals: Cd + Hg + Pb + Cr ... < 100 PPM

Light metals: Mg ≤20ppm.Na≤5ppm.Li≤2ppm

SURFACE PROPERTIES	
PROPERTY	SPECIFICATION
Finish	One side bright, the other side matt; bright side outside as normal.
Surface roughness	Ra 0.05–0.08 μm, based on work roll roughness.
Surface quality	Free from roll lines, bright/dull spots or other visible defects that may affect final application.

WETTABILITY	
PROPERTY	SPECIFICATION
Test medium	100% distilled water
Requirement	Water is distributed uniformly on foil surface; width does not shrink and no droplets form on the surface.

SPLICE REQUIREMENTS	
PROPERTY	SPECIFICATION
Method	Ultrasonic welding with 3 mm overlap; free from wrinkles and tears.
Splice tensile strength	Minimum 80% of normal foil value.
Maximum joints	Max. 2 for roll O/D <450 mm; max. 3 for coil O/D <800 mm.
Minimum spacing	4,000 m between splices; 1,000 m between a splice and either end of the roll.

UNWINDING PROPERTIES	
PROPERTY	SPECIFICATION
Whole width	Can unwind freely under its own gravity, maximum 0.5 m.
Most serious area (100 mm width)	Can unwind under its own gravity, maximum 1.0 m.
Full roll	Can unwind freely along the whole length to the core.

PACKAGING	
PROPERTY	SPECIFICATION
Label identification	Manufacturer, Order No., Lot No., Alloy & Temper, Net Weight, Gross Weight and Packing Date.
Reel marking	Arrow showing unwinding direction.
Protection	PE foam first layer, plastic bag second layer, with desiccant for corrosion protection.
Case	Roll suspended in wooden case with polyfoam edge protection against mechanical damage.

STORAGE & SHELF LIFE	
PROPERTY	SPECIFICATION
Shelf life	6 months with intact packaging.
Storage	Ventilated warehouse under appropriate temperature and humidity conditions.
After 6 months	Open packaging, re-check stickiness and corrosion, and re-pack with fresh drier/desiccant.

Product features:

- ✓ High purity aluminium foil
- ✓ Excellent printability
- ✓ Excellent lamination performance
- ✓ Low pinhole level
- ✓ Suitable for food packaging

Typical applications:

Snack • Coffee • Dairy • Chocolate • Pet Food Pharmaceutical • Retort Pouches