



SHRIJAY FOILS LIMITED

E-Mail ID: shrijayfoils@gmail.com

Technical Data Sheet

Purpose:

This document is intended to specify the standards for the supply of Aluminium foil in thickness from 6μ up to 50μ.

Material Specifications:

Aluminium foil is supplied in accordance with EN 573-3, EN 546-2, EN 546-3, normative.

Chemical Composition:

Chemical composition of the alloys is in accordance with UNI EN 573-3 standard. The type of alloy is specified below and is in Compliance with the RoHS Directive.

Alloy	Si %	Fe %	Cu %	Mn %	Mg %	Zn %	Ti %	Others		Al %
								Each	total	
1235	0.13 -0.17	0.40-0.45	0.01	0.01	0.01	0.01	0.01	0.03	0.14	99.35
8079	0.05-0.20	1.00-1.30	0.05	0.005	0.003	0.10	0.05	0.05	0.015	98.00

Wettability:

Wettability is tested according to UNI EN 546-4 standard by distilled water process. The surface appears degreased and it corresponds to a degreasing Type A in soft temper foil.

Thickness:

Thickness measurement is made according to UNI EN 546-3 norm.

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Factory Address: Khata No. 389/850 Plot No. 7 & 249 Mundaamba, Khordha, Odisha, 752020.
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Single point thickness must have a tolerance = $\pm 8\%$ of the nominal thickness. Average thickness has a tolerance = $\pm 5\%$ of the nominal thickness.

Weight:

As Weight we consider weight per m². It is fixed using a specific weight of 2.71, and the average will be in a $\pm 5\%$ tolerance.

Following, a table of what above written about thickness tolerances:

Thickness (μ)	Grammage(g/m ²)
6	15.45 – 17.07
7	18.02 – 19.92
8	20.60 – 22.76
9	23.17 – 25.61
12	30.89 – 34.14
14	36.04 – 39.84
15	38.61 – 42.68
18	46.34 – 51.22
20	51.49 – 56.91
25	64.36 – 71.14
30	77.23 – 85.37
37	95.26 – 105.28
40	102.98 – 113.82
50	128.73 – 142.28

Width of Material:

± 1 mm. up to 1000 mm. foil, ± 2 mm for widths over 1000mm.

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Mechanical Properties:

Alloy	Gauge range (µm)	Temper: H00 Tensile strength (MPa)	Temper: H00 Elongation A100 (%)	Temper: H18 Tensile strength (MPa)
		Min. - Max	Min.	Min.
1235	6 – 10	40 - 95	1.0	-
	10 – 25	45 - 100	1.5	-
	25 – 40	50 - 105	3.5	-
	40 – 50	55 - 105	6.0	-
8079	6 – 10	45 - 100	1.0	150
	10 – 25	50 - 105	1.5	150
	25 – 40	55 - 110	4.0	150
	40 – 50	60 - 110	8.0	150

Tensile strength and Elongation will be tested according to ASTM D-882 with a distance between the jaws of 100 mm and speed of 2-5 mm/min, or according to UNI EN 546-2 standard.

Coil Dimension

Material used: Steel Core

Lengths of rolls and their tolerances or outside diameter will be as per customer requirement. Standard diameter is minimum 500mm. and maximum possible is 800mm.

We usually indicate the length of each coil in the COA and in coil label.

Splices

60% joint less, 30% one joint, & 10% two joints

Splices are properly marked and made by ultrasonic welding

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Core ID

152.4mm (+/-0.5mm)

Quality of slitting of the foil will be free of :

1. stuck edges
2. irregular edges
3. wrinkled edges
4. waved slitting
5. lateral cuts, which breaks during process
6. damaged edges.

The foil will be well fixed to the core, in order to avoid slippage of turns and telescoping during handling and usage.

Aluminium foil will be wound up with a tension suitable to avoid inside interference preventing turns slippage

Surface will be flat and with no corrugation or wrinkles.

Pin-holes - all the holes with diameter smaller than 0.2 mm shall be considered pinholes. Measures shall be done according to UNI EN 546-4 standard.

Thickness μ	Maximum n. of micro-holes/m ²
6 – 6.49	500
6.5 – 6.99	300
7 - 7.99	200
8 – 8.99	100
9 – 9.99	50
10 – 14.99	20
15 - 17.99	5
>18	0

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Coil Identification

All the coils are identified by a label with the following information:

1. alloy type
2. reel No
3. thickness in microns
4. Width in mm.
5. net weight in Kg
6. splice's number

Packing

Coils are carefully packed and perfectly blocked, Single hanging condition in wooden box

Certification

Certificate of Analysis to be providing at the time of material deliver.

Packing List

Packing list is filled in all of needed fields and usually sent to customer before the delivery via e-mail, for information.

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