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TECHNICAL DATA SHEET · 技术数据表

BOPP Printing & Laminating Film

双拉 **BOPP** 印刷复合膜 · 三个通用牌号

Doc. No. API-TDS-BOPP-LAM-2026 **Rev.** 1.0 **Date** 2026-11-20 **HS code** 3920209090 **Density** 0.91 g/cm³

01 Product family

产品系列

Biaxially oriented polypropylene (BOPP) film for printing and lamination. Transparent, non heat-sealable, with a corona-treated face for extrusion lamination, adhesive lamination and printing. Three grades cover the common converting routes.

双向拉伸聚丙烯（BOPP）印刷复合膜，透明、不可热封，电晕面适配挤出复合、胶复合与印刷。以下三个通用牌号覆盖常见复合工艺。

Grade 牌号	Description 说明	Treatment 电晕处理	Thickness 厚度	Typical use 典型用途
API-B11	BOPP general grade, one-side corona 通用级单面电晕	One side 单面	12–20 µm	Paper and book-cover lamination 纸张、书封复合
API-B21	BOPP book-surface lamination film, both-side corona 覆书膜双面电晕	Both sides 双面	12–20 µm	Paper and book-cover lamination 纸张、书封复合
API-B13	BOPP bag-grade (woven bag) lamination film 制袋膜/编织袋复合级	One side 单面	15–18 µm	Woven bag lamination 编织袋复合

Structure 结构**.** Three-layer co-extrusion: corona-treated surface layer, homopolymer core for stiffness and strength, second surface layer. In the one-side grades only the outer face is treated; API-B21 is treated on both faces. 三层共挤：电晕表层、均聚芯层与另一表层；单面牌号仅外面处理，API-B21 两面处理。

Common features 共同特点**.** General grade · transparent, non heat-sealable 透明不可热封 · excellent extrusion lamination 挤出复合性能优异 · corona-treated face for ink and adhesive anchoring 电晕面利于油墨与胶层附着.

02 Ordering information

订购信息

Item 项目	Terms 条款
Thickness 厚度	12, 15, 18, 20 µm (API-B13: 15, 18 µm)
Width / core 卷宽与纸芯	Slit to order; 3″ or 6″ core 按订单分切，3 英寸或 6 英寸纸芯
Roll length 卷长	To order, typical 4,000–12,000 m 按订单，常见 4,000–12,000 m
Packing 包装	Palletised, stretch-wrapped, strapped 上托、缠膜、打包带
Price terms 价格条款	FOB / CIF, per order 按订单

GRADE API-B11 · TECHNICAL DATA SHEET · 技术数据表

API-B11 — BOPP Printing & Laminating Film, one-side treated

API-B11 双拉 BOPP 印刷复合膜 · 单面电晕 · 通用级 · 12–20 μm

Treatment 处理 One side 单面电晕 **Grade** 等级 General 通用级 **Thickness** 厚度 12–20 μm **HS code** 3920209090

Application & features 应用与特点

- Widely used in lamination with paper and book covers. 广泛用于纸张、书封的复合加工。
- Transparent, non heat sealable 透明，不可热封
- One side corona treatment 单面电晕处理
- Excellent extrusion lamination 挤出复合性能优异

01 Typical values

典型值（按公称厚度，μm）

Property 性能	Test method 检验方法	Unit 单位	12	15	18	20
Thickness 厚度	—	μm	12	15	18	20
Thickness variation 厚度偏差	ASTM 252-78	%	±4.0	±3.5	±3.0	±3.0
Yield 得率	—	m²/kg	91.6	73.3	61.1	55.0
Tensile strength MD 拉伸强度 纵向	ASTM D882	MPa	150	150	155	160
Tensile strength TD 拉伸强度 横向	ASTM D882	MPa	280	280	280	280
Elongation at break MD 断裂伸长率 纵向	ASTM D882	%	160	160	160	160
Elongation at break TD 断裂伸长率 横向	ASTM D882	%	60	60	60	60
Friction coefficient T/T 摩擦系数 处理面/处理面	ASTM D1894	—	0.25	0.25	0.25	0.25
Friction coefficient T/O 处理面/非处理面	ASTM D1894	—	0.30	0.30	0.30	0.30
Heat shrinkage MD 热收缩率 纵向	ASTM D1204	%				4.0
Heat shrinkage TD 热收缩率 横向	ASTM D1204	%				1.0
Haze 雾度	ASTM D1003	%	1.2	1.2	1.2	1.2
Gloss 光泽度	ASTM D2457	—	92	92	92	92
Wetting tension 润湿张力	ASTM D2578	dyn/cm	38	38	38	38

The above values are typical data obtained in our laboratory tests. They are for information only and do not constitute a guarantee or warranty under any specific condition. Users are advised to carry out their own testing to determine the suitability of the product for their application.

上述数值为实验室测试所得的典型值，仅供参考，不构成对任何特定条件下的保证或担保。用户应自行测试以确认产品对其用途的适用性。

GRADE API-B21 · TECHNICAL DATA SHEET · 技术数据表

API-B21 — BOPP Book-Surface Lamination Film, both-side treated

API-B21 双拉 BOPP 覆书膜 · 双面电晕 · 通用级 · 12–20 μm

Treatment 处理 Both sides 双面电晕 **Grade** 等级 General 通用级 **Thickness** 厚度 12–20 μm **HS code** 3920209090

Application & features 应用与特点

- Widely used in lamination with paper and book covers. 广泛用于纸张、书封的复合加工。
- Transparent, non heat sealable 透明，不可热封
- Both side corona treatment 双面电晕处理
- Excellent extrusion lamination 挤出复合性能优异

01 Typical values

典型值（按公称厚度，μm）

Property 性能	Test method 检验方法	Unit 单位	12	15	18	20
Thickness 厚度	—	μm	12	15	18	20
Thickness variation 厚度偏差	ASTM 252-78	%	±4.0	±3.5	±3.0	±3.0
Yield 得率	—	m²/kg	91.6	73.3	61.1	55.0
Tensile strength MD 拉伸强度 纵向	ASTM D882	MPa	150	150	155	160
Tensile strength TD 拉伸强度 横向	ASTM D882	MPa	280	280	280	280
Elongation at break MD 断裂伸长率 纵向	ASTM D882	%	160	160	160	160
Elongation at break TD 断裂伸长率 横向	ASTM D882	%	60	60	60	60
Friction coefficient T/T 摩擦系数 处理面/处理面	ASTM D1894	—	0.25	0.25	0.25	0.25
Friction coefficient T/O 处理面/非处理面	ASTM D1894	—	0.25	0.25	0.25	0.25
Heat shrinkage MD 热收缩率 纵向	ASTM D1204	%				4.0
Heat shrinkage TD 热收缩率 横向	ASTM D1204	%				1.0
Haze 雾度	ASTM D1003	%	1.2	1.2	1.2	1.2
Gloss 光泽度	ASTM D2457	—	92	92	92	92
Wetting tension 润湿张力	ASTM D2578	dyn/cm	38/37	38/37	38/37	38/37

Both faces are corona treated, so either side can be laminated; the wetting tension is quoted face-in / face-out. Values are typical laboratory data, not a specification.

两面均做电晕处理，可任选一面复合；润湿张力按内面/外面分别给出。上述数值为实验室典型值，不构成产品规格。

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GRADE API-B13 · TECHNICAL DATA SHEET · 技术数据表

API-B13 — BOPP Bag-Grade Lamination Film

API-B13 双拉 BOPP 制袋膜 · 编织袋复合级 · 单面电晕 · 15–18 μm

Treatment 处理 One side 单面电晕 **Grade** 等级 Woven bag lamination 编织袋复合级 **Thickness** 厚度 15–18 μm **HS code** 3920209090

Application & features 应用与特点

- Widely used in lamination with woven bags. 广泛用于编织袋的复合加工。
- Transparent, non heat sealable 透明，不可热封
- One side corona treatment 单面电晕处理
- Excellent extrusion lamination 挤出复合性能优异

01 Typical values

典型值（按公称厚度，μm）

Property 性能	Test method 检验方法	Unit 单位	15	18
Thickness 厚度	—	μm	15	18
Thickness variation 厚度偏差	ASTM 252-78	%	±3.5	±3.0
Yield 得率	—	m²/kg	73.3	61.1
Tensile strength MD 拉伸强度 纵向	ASTM D882	MPa	155	155
Tensile strength TD 拉伸强度 横向	ASTM D882	MPa	280	280
Elongation at break MD 断裂伸长率 纵向	ASTM D882	%	160	160
Elongation at break TD 断裂伸长率 横向	ASTM D882	%	60	60
Friction coefficient T/T 摩擦系数 处理面/处理面	ASTM D1894	—	0.60	0.60
Friction coefficient T/O 处理面/非处理面	ASTM D1894	—	0.65	0.65
Heat shrinkage MD 热收缩率 纵向	ASTM D1204	%		4.0
Heat shrinkage TD 热收缩率 横向	ASTM D1204	%		1.0
Haze 雾度	ASTM D1003	%	1.0	1.0
Gloss 光泽度	ASTM D2457	—	94	94
Wetting tension 润湿张力	ASTM D2578	dyn/cm	39	39

The higher friction coefficient of this grade is intentional: it holds the laminated woven bag stack in register during bag making and stacking.

本牌号摩擦系数偏高是有意设计，便于复合后的编织袋在制袋与堆垛时保持定位。

上述数值为实验室测试所得的典型值，仅供参考，不构成对任何特定条件下的保证或担保。用户应自行测试以确认产品对其用途的适用性。