

INDUSTRIAL PACKAGING · GRADE KP-HDS

Heavy-Duty Sacks

Open-mouth co-extruded PE sacks for automatic and manual filling

Thickness	Width	Dart impact	Flexo print
90–200 µm	**30–65 cm**	**1,200–1,920 g**	**up to 6 colors**

PRODUCT DESCRIPTION

Heavy-duty shipping sacks (HDSS) in co-extruded PE, made on the roll and base-sealed before cutting, ready for automatic or manual filling of fertilizer, seed and feed, polymers, chemicals and building materials.

Our open-mouth sacks have a gusseted tubular design and flexo printing in up to six colors, up to 80 cm wide. They run on fully automatic baggers and at manual filling stations.

APPLICATIONS

- Polymers
- Fertilizers
- Compounding additives
- Salt, sugar and flour
- Pet food
- Building materials

KEY FEATURES

- **Any filling setup.** Supplied to suit automatic baggers or manual filling stations.
- **Co-extruded strength.** Multi-layer film built for heavy loads and rough handling.
- **Stable stacks.** The embossing option improves grip between bags on the pallet.
- **Printed in-house.** Flexo printing up to six colors per side.

TECHNICAL SPECIFICATIONS

Thickness	**90–200 µm**	Bag width	**30–65 cm**
Bag length	**To order**	Side gusset	**To order**
Color	**To order**	Printing	**Flexo, 1–6 colors per side, up to 80 cm wide**
Options	**Embossing, micro or macro perforation**		

TYPICAL PROPERTIES

Typical values on **150 µm** film at 23 °C and 50 % RH, unless stated otherwise.

Property	Test method	Unit	Typical value
MECHANICAL			
Tensile strength at break, MD / TD	ASTM D882	MPa	**30–40 / 24–35**
Elongation at break, MD / TD	ASTM D882	%	**750–1,000 / 900–1,100**
1 % secant modulus, MD / TD	ASTM D882	MPa	**150–200 / 200–250**
Dart drop impact, method B	ASTM D1709	g	**1,200–1,920**
WELD (BOTTOM SEAL)			
Tensile strength at the weld	ASTM D882	MPa	**10–18**
Elongation at the weld	ASTM D882	%	**400–700**
1 % secant modulus at the weld	ASTM D882	MPa	**150–210**
SURFACE			
Coefficient of friction, film to film (static)	ISO 8295	—	**0.30–0.50**
Surface tension, print side	ASTM D2578	mN/m	**≥ 38**

Typical results from production testing, not specification limits. Properties vary with thickness and grade; data for your gauge on request. MD = machine direction, TD = transverse direction.

Packaging

- **Packing:** Bundles on pallets
- **Bag size:** To your fill weight
- **Per 40’ container:** About 20–23 t
- Wrapped, labeled and stretch-wrapped on pallets

Storage

- Indoors, dry, away from direct sun, rain and heat
- Keep in the original packaging; first in, first out.

5–30 °C	≤ 65 %	12 mo.
Temperature	Humidity	Shelf life

Labeling

Every delivery comes with a Certificate of Analysis (CoA). Each label shows:

- Product, grade and dimensions
- Batch number and production date
- Net weight and customer PO

SUSTAINABILITY

Available with 30–100 % recycled polyethylene, certified OK Recycled (TÜV Austria, EN 15343). Mono-material PE, recyclable where PE film collection exists.

30–100 %
recycled PE content

CERTIFIED MANAGEMENT SYSTEMS

ISO 9001:2015 Quality management	**FSSC 22000 v6** Food safety for PE bags and films, food and non-food use	**OK Recycled** Recycled content to EN 15343
ISO 14001:2015 Environmental management	**ISO 45001:2018** Occupational health and safety	**EcoVadis Committed** Sustainability rating

Certificates and declarations of compliance for supplier approval on request.

The information in this data sheet is based on our current knowledge and production testing. It is a guide only and is not a specification or a warranty of fitness for a particular use; performance depends on processing, handling and use conditions. Specifications are agreed in writing per order. Karawia Pack may update this sheet without notice; the latest revision applies.