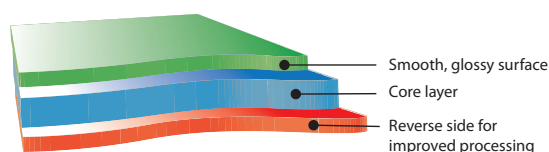


Hostaphan® DOKO/DOKI

Transparent polyester film with one very smooth surface

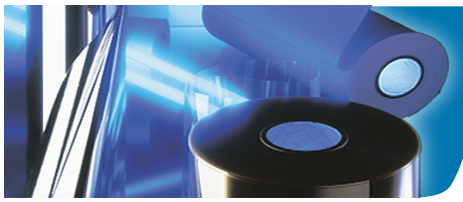
Hostaphan® DOKO/DOKI are biaxially oriented, coextruded films made of polyethylene terephthalate (PET). One surface is extremely smooth and glossy. This side is designed for gloss transfer processes. The 2nd surface provides the roughness required for good handling and winding.

Layer structure of Hostaphan® DOKO/DOKI



Typical properties

Property	Thickness μm	Units	Value		Test Method	Test Conditions
			MD	TD		
MECHANICAL						
Tensile strength	36 50, 75	N/mm ²	240 200	300 280	ISO 527-1 and ISO 527-3 Sample type 2	Test speed 100 %/min.; 23 °C, 50 % r.h.
Elongation at break	36 50 75	%	185 190 210	125 115 115	ISO 527-1 and ISO 527-3 Sample type 2	Test speed 100 %/min.; 23 °C, 50 % r.h.
Young's Modulus	36 50 75	N/mm ²	4400 4100 4000	5100 5300 5400	ISO 527-1 and ISO 527-3 Sample type 2	Test speed 1 %/min.; 23 °C, 50 % r.h.
F5-value (stress to obtain 5% elongation)	36, 50 75	N/mm ²	110 110	105 110	ISO 527-1 and ISO 527-3 Sample type 2	Test speed 100 %/min.; 23 °C, 50 % r.h.
THERMAL						
Shrinkage	36-75	%	1.2	0.3	DIN 40634	150°C, 15 min.
OPTICAL						
Haze	36, 50 75	%	3 4		ASTM-D 1003-61 method A	Enlarged measurement angle



Property	Thickness µm	Units	Value		Test Method	Test Conditions
			MD	TD		
SURFACE						
Coefficient of friction (static)	36-75	-			DIN53375 or ASTM-D 1894	-
Reverse surface/ Reverse surface				0.4		
Reverse surface/ Smooth surface				0.4		
Smooth surface/ Smooth surface				blocks		
Gloss	36, 50 75	-		200 200	DIN 67530	Measuring angle 20°
Roughness Ra Smooth surface Reverse surface	36-75	nm		3 18	ISO 25178	Cut off 0.25 mm
PHYSICAL/CHEMICAL						
Density	36-75	g/cm ³		1.4	ASTM-D 1505-68 method C	23°C

MD = Machine direction, TD = Transverse direction

Winding direction:

DOKO: smooth surface wound **out**

DOKI: smooth surface wound **in**

Delivery program Hostaphan® DOKO/DOKI

Thickness µm	Yield		Roll length m	Roll-diameter mm
	g/m ²	m ² /kg		
36	50	20	8 000	635
50	70	14.3	6 400	670
75	105	9.5	4 000	650

Other roll lengths on request. Core diameter: 152.4 mm (6")

This data sheet reflects our state of knowledge at the time this was prepared. The purpose is to provide an overview of the characteristics of our products and their potential uses. The values given reflect the typical characteristics of the film. They are not specification limits. They are neither a guarantee of specific properties nor the suitability of products in specific applications. The user must observe industrial property rights, such as patents or trademarks. The quality of our products is covered by the terms of the General Conditions of Sale of MITSUBISHI POLYESTER FILM GmbH.