



## Technical Bulletin

Polyvinyl Alcohol (PVOH) Film is sensitive to temperature and relative humidity (RH). Users should monitor and control room conditions during storage and film conversion.

### Storage

Polyvinyl Alcohol Films are sensitive to ambient temperature and relative humidity. The film should be stored in its original air-tight protective wrap. Ideal storage conditions are 5 - 25°C (41 - 77°F) and 20 - 50%RH. Temperature excursions above 40°C/104°F for long periods should be avoided. The film should be conditioned in the protective wrap at the temperature of the converting environment for 48 hours prior to use. For additional information, contact MonoSol Technical Service.

### Conversion

The ideal conversion room conditions are 23±3°C (73±5°F) with the below listed relative humidity (±5%). Once removed from the moisture barrier wrapping, the film will gain moisture when exposed to air of higher relative humidity. Similarly, the film will lose moisture when exposed to air of lower relative humidity. The change in film moisture will depend on difference in RH, exposure time and air flow.

However, it's often impractical to maintain RH below 35%, and the best strategy is to control to an RH and temperature that demonstrates consistent conversion success during process validation. All conversion operations are unique, and performance depends on many factors, including the film type, exposure conditions, and exposure time in the conversion environment. Please consult the MonoSol Technical Service team for more information.

If the film is not completely used during conversion, the film should be repackaged in the air tight moisture barrier wrapping (typically HDPE) and stored properly until resuming conversion.

### Typical Equilibrium Relative Humidity for Film @ 23°C (73°F)

Film	RH (%)	Film	RH (%)	Film	RH (%)
A127	27	M1030	38	M8310	39
A200	31	M2000	46	M8312	39
E6030	32	M2631A	35	M8440	41
L330	30	M3030	38	M8534	38
L336	28	M7030	36	M8630	38
L337	30	M7031	36	M8720	38
L711	24	M7062	32	M8900	30
L713	21	M8045	38	M9500	38
L830	26	M8075	32		

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