

CUPSTOCK PAPER

Technical Data Sheet

PRODUCT	GRADE / FINISH
CUPSTOCK PAPER	160-330 gsm Standard Bulk

GRADE MATRIX 160-240 GSM

PARAMETER	160 gsm	170 gsm	190 gsm	210 gsm	230 gsm	240 gsm
Basis Weight (g/m²)	160±5	170±5	190±5	210±5	230±5	240±5
CD Basis Weight Deviation ≤ (g/m²)	5	5	6	6	7	7
Caliper (µm)	225	240	265	295	320	335
CD Stiffness ≥ (mN·m)	1.20	1.30	1.80	2.30	3.00	3.20

GRADE MATRIX 250-330 GSM

PARAMETER	250 gsm	260 gsm	280 gsm	300 gsm	310 gsm	330 gsm
Basis Weight (g/m²)	250±5	260±5	280±5	300±10	310±10	330±10
CD Basis Weight Deviation ≤ (g/m²)	7	8	8	8	9	10
Caliper (µm)	350	365	390	420	435	460
CD Stiffness ≥ (mN·m)	4.00	4.20	5.00	6.50	6.60	7.00

CUPSTOCK PAPER CONTINUED

COMMON TECHNICAL REQUIREMENTS

PARAMETER	UNIT	REQUIREMENT	TEST METHOD
Caliper Deviation	μm	±10	GB/T 451.3 / ISO 534
CD Caliper Deviation	%	≤3.0	GB/T 451.3 / ISO 534
Stiffness MD/CD Ratio	-	≤3.0	GB/T 22364 / ISO 2493, Taber 15°
Folding, MD and CD	times	≥20	GB/T 457 / ISO 5626
Moisture ≤250 gsm	%	6.5±1.0	GB/T 462 / ISO 287
Moisture >250 gsm	%	8.0±1.0	GB/T 462 / ISO 287
Internal Bond	J/m ²	≥100	GB/T 26203 / TAPPI T833
D65 Brightness, top	%	78.0-85.0	GB/T 7974 / ISO 2470
PPS Roughness H-10, top	μm	≤8.00	GB/T 22363 / ISO 8791-4
Cobb 60 s, top and back	g/m ²	≤40.0	GB/T 1540 / ISO 535
Edge Wick, H ₂ O ₂ 30%, 70°C, 10 min	kg/m ²	≤1.20	Not stated
Tensile Index, MD/CD average	N·m/g	≥29.0	GB/T 12914 / ISO 1924

DIRT LIMITS

SIZE CLASS	LIMIT
0.1-0.3 mm ²	≤80 spots/m ²
≥0.3-1.5 mm ²	≤80 spots/m ²
≥1.5-2.5 mm ²	≤5 spots/m ²
≥2.5 mm ²	None permitted
Black dirt ≥1.5 mm ²	None permitted

Basis weight method: GB/T 451.2 / ISO 536. The MD/CD stiffness ratio is marked in the source as not used for sheet classification.