

DUPLEX BOARD

Technical Data Sheet

PRODUCT	GRADE
Duplex Board	As supplied

KEY PERFORMANCE BY GRAMMAGE

Parameter / unit	200 gsm	230 gsm	250 gsm	270 gsm	300 gsm	350 gsm	400 gsm
Caliper (mm)	0.230	0.280	0.305	0.330	0.365	0.430	0.495
Basis weight tolerance (g/m²)	193–210	220–241	242–260	260–282	290–315	336–365	385–415
Moisture (%)	6.5±1.5	7.0±1.5	7.5±1.5	7.5±1.5	7.8±1.5	8.0±1.5	8.0±1.5
Stiffness CD (g·cm)	13	13	15	22	35	55	70
Stiffness MD (g·cm)	26	26	30	50	70	110	140

GENERAL QUALITY AND SURFACE REQUIREMENTS

Parameter	Unit	Specification
Caliper tolerance	µm	± 15 for all listed grammages.
Back Cobb value	g/m²	≤ 50
CD difference of grammage	%	≤ 300, as supplied.
CD difference of caliper	%	≤ 3.5
Roughness	µm	≤ 2.0
Brightness, top	%	≥ 76
Folding endurance, CD	times	≥ 12
Gloss, 75°	%	≥ 35
Printing gloss	%	≥ 80
Ply bonding	J/m²	≥ 130
Blister speed	m/s	> 0.9
K&N value	%	23 ± 5
Colour L* / a* / b*	-	≥ 86.5 / 0.0 ± 0.5 / -4.5 ± 0.5.
Dirt / RI printing	count/m² / times	Dirt: > 0.3 mm² ≤ 40; > 1.5 mm² ≤ 10. RI printing: ≥ 2 times.