

FOLDING BOX BOARD GC1 HIGH BULK

Technical Data Sheet

PRODUCT	GRADE
Folding Box Board Gc1 High Bulk	C1S ivory board

KEY PERFORMANCE BY GRAMMAGE

Parameter / unit	195 gsm	205 gsm	210 gsm	225 gsm	245 gsm	255 gsm	275 gsm	290 gsm	305 gsm	330 gsm	345 gsm
Caliper (mm)	0.275	0.310	0.320	0.340	0.390	0.415	0.440	0.460	0.490	0.530	0.555
Stiffness CD (mN·m)	≥2.10	≥3.30	≥3.60	≥4.50	≥6.30	≥7.10	≥8.50	≥10.7	≥12.1	≥12.3	≥14.0
Stiffness MD (mN·m)	≥4.41	≥6.93	≥7.56	≥9.45	≥13.2	≥14.9	≥17.9	≥22.5	≥25.4	≥25.8	≥29.4
Moisture (%)	6.5±1.0	6.5±1.0	6.5±1.0	6.5±1.0	6.5±1.0	7.5±1.0	7.5±1.0	7.5±1.0	7.5±1.0	8.0±1.0	8.5±1.0

GENERAL QUALITY AND SURFACE REQUIREMENTS

Parameter	Unit	Specification
CD deviation of basis weight	g/m²	195 - 210: ≤ 6; 225 - 245: ≤ 7; 255 - 275: ≤ 8; 290 - 305: ≤ 9; 330 - 345: ≤ 10.
CD deviation of caliper	%	195 - 255: ≤ 3.0; 275 - 345: ≤ 4.0.
Folding, MD / CD	times	≥ 15
Internal bond	J/m²	195 - 255: ≥ 100; 275 - 345: ≥ 120.
D65 brightness, natural white top / back	%	80.0 ± 3.0 / 80.0 ± 3.0.
D65 brightness, high white top / back	%	90.0 ± 3.0 / 90.0 ± 3.0.
Gloss, top	gloss unit	≥ 40
Smoothness, top	s	≥ 100
PPS, top	µm	≤ 1.50
Ink absorption	%	3 - 14
Picking, top	m/s	≥ 1.20
Cobb 60 s, top / back	g/m²	≤ 45.0 / ≤ 60.0.
Dirt	spot/m²	0.2 - 1.0 mm²: ≤ 20; 1.0 - 1.5 mm²: None; > 1.5 mm²: None.