

# FOLDING BOX BOARD GC1 REGULAR BULK

Technical Data Sheet

| PRODUCT                            | GRADE           |
|------------------------------------|-----------------|
| Folding Box Board Gc1 Regular Bulk | C1S ivory board |

## KEY PERFORMANCE BY GRAMMAGE

| Parameter / unit    | 170 gsm | 180 gsm | 190 gsm | 205 gsm | 210 gsm | 215 gsm | 220 gsm | 225 gsm | 230 gsm | 245 gsm | 250 gsm | 285 gsm | 300 gsm | 350 gsm | 400 gsm |
|---------------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| Caliper (mm)        | 0.215   | 0.230   | 0.245   | 0.275   | 0.280   | 0.285   | 0.300   | 0.310   | 0.315   | 0.330   | 0.345   | 0.385   | 0.415   | 0.490   | 0.555   |
| Stiffness CD (mN·m) | ≥1.20   | ≥1.40   | ≥1.70   | ≥2.00   | ≥2.10   | ≥2.20   | ≥3.00   | ≥3.10   | ≥3.30   | ≥3.65   | ≥3.80   | ≥5.40   | ≥6.50   | ≥10.0   | ≥14.0   |
| Stiffness MD (mN·m) | ≥2.52   | ≥2.94   | ≥3.57   | ≥4.20   | ≥4.41   | ≥4.62   | ≥6.30   | ≥6.51   | ≥6.93   | ≥7.67   | ≥7.98   | ≥11.3   | ≥13.7   | ≥21.0   | ≥29.4   |
| Moisture (%)        | 6.5±1.0 | 6.5±1.0 | 6.5±1.0 | 6.5±1.0 | 6.5±1.0 | 6.5±1.0 | 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 | 8.5±1.0 |

## GENERAL QUALITY AND SURFACE REQUIREMENTS

| Parameter                  | Unit                | Specification                                                                                     |
|----------------------------|---------------------|---------------------------------------------------------------------------------------------------|
| Basis weight deviation     | g/m <sup>2</sup>    | 170 - 215: ± 6; 220 - 245: ± 7; 250: ± 8; 285 - 300: ± 9; 350: ± 10; 400: ± 12.                   |
| Caliper deviation          | μm                  | 170 - 250: ± 10; 285 - 400: ± 15.                                                                 |
| CD deviation               | %                   | 170 - 300: ≤ 3.0; 350 - 400: ≤ 4.0.                                                               |
| Internal bond              | J/m <sup>2</sup>    | 170 - 250: ≥ 100; 285 - 400: ≥ 120.                                                               |
| D65 brightness, top / back | %                   | 90.0 ± 3.0 / 90.0 ± 3.0.                                                                          |
| Smoothness, top            | s                   | ≥ 100                                                                                             |
| PPS, top                   | μm                  | ≤ 1.10                                                                                            |
| Picking, top               | m/s                 | ≥ 1.20                                                                                            |
| Cobb 60 s, top / back      | g/m <sup>2</sup>    | ≤ 45.0 / ≤ 55.0.                                                                                  |
| Gloss, top                 | gloss unit          | ≥ 45                                                                                              |
| Folding, CD / MD           | times               | ≥ 15                                                                                              |
| Dirt                       | spot/m <sup>2</sup> | 0.2 - 1.0 mm <sup>2</sup> : ≤ 20; 1.0 - 1.5 mm <sup>2</sup> : None; > 1.5 mm <sup>2</sup> : None. |