

FOLDING BOX BOARD GC2 OBA-FREE

Technical Data Sheet

PRODUCT	GRADE
Folding Box Board Gc2 Oba-Free	High bulk

KEY PERFORMANCE BY GRAMMAGE

Parameter / unit	200 gsm	215 gsm	220 gsm	235 gsm	240 gsm	250 gsm	270 gsm	295 gsm	325 gsm	350 gsm
Caliper (mm)	0.325	0.350	0.360	0.385	0.395	0.420	0.460	0.510	0.560	0.610
Stiffness MD target (mN·m)	8.18	9.95	11.9	13.2	13.9	16.6	21.9	30.8	33.8	42.0
Stiffness MD minimum (mN·m)	≥6.95	≥8.06	≥9.61	≥10.7	≥11.2	≥13.4	≥17.8	≥24.9	≥27.4	≥34.0
Stiffness CD target (mN·m)	3.95	5.59	5.96	7.40	7.95	8.73	11.3	16.0	18.7	25.7
Stiffness CD minimum (mN·m)	≥3.36	≥4.52	≥4.83	≥5.99	≥6.43	≥7.06	≥9.18	≥12.9	≥15.1	≥20.8

GENERAL QUALITY AND SURFACE REQUIREMENTS

Parameter	Unit	Specification
Basis weight deviation	%	± 3.0
Caliper deviation	%	± 3.0
Moisture	%	7.0 ± 1.5
PPS, top target / maximum	µm	1.50 / ≤ 1.70.
D65 brightness, top	%	≥ 80.0
Gloss 75°, top	gloss unit	≥ 40
Picking, top	m/s	≥ 1.20
Cobb 180 s, top / core / back	g/m ²	≤ 60.0
Internal bond	J/m ²	≥ 130