



**TECHNICAL STANDARD VALUES**

*IMPORTANT: Please check which is the standard grammage on the MANUFACTURING SPECIFICATION chart*

Grammage	Caliper	Bulk	Bending stiffness by static methods							
			5° (L&W)				15° (Taber)			
			mNm		mNm (*)		gcm (*)		mN (*)	
			MD	CD	MD	CD	MD	CD	MD	CD
g / m <sup>2</sup>	µm	cm <sup>3</sup> / g								
180	200	1.11	4.1	1.9	2.1	1.0	21	10	41	19
210	237	1.13	7.1	3.3	3.6	1.7	36	17	71	33
230	262	1.14	9.0	4.1	4.5	2.1	46	21	90	41
250	288	1.15	11.0	5.0	5.5	2.5	56	25	110	50

(\*) calculated figures

**TECHNICAL STANDARD VALUES**

*Test climate (DIN 50 014) : 23° C / 50% rH*

Properties		Testing methods	Tolerances
Grammage	g / m <sup>2</sup>	DIN-EN-ISO 536	± 2 %
Caliper	µm	DIN-EN-ISO 534	± 5 %
Bending stiffness	mNm	DIN 53 121	5° (Lorentzen & Wettre) - 15 %
	mNm	ISO 2493	15° (Taber) - 15 %

Tolerances as agreed by the actual valid FFI (the association of the German carton makers)

**OTHER CHARACTERISTICS**

Brightness	Top	%	ISO 2470	84 ± 1
Cobb 180 s	Top	g / m <sup>2</sup>	DIN-EN-ISO 535	50 + 10
Cobb 180 s	Back	g / m <sup>2</sup>	DIN-EN-ISO 535	50 + 10
Wick - Test		g / m x mm		< 2.5
Gloss 60°	Top	%	( Dr. Lange )	> 14

FSC® - Certified Board is available by request





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			MD	CD	MD	CD	MD	CD	MD	CD
g / m <sup>2</sup>	µm	cm <sup>3</sup> / g								
280	380	1.36	19.0	9.5	10.0	5.0	102	51	201	100
300	410	1.36	23.4	11.7	12.4	6.2	126	63	248	124
320	435	1.36	28.2	14.1	14.7	7.4	150	75	294	147
350	485	1.38	36.6	18.3	18.7	9.3	190	95	373	187

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