

NINGBO FOLD C1S FOLDING BOX BOARD

NINGBO
FOLD

TECHNICAL INFORMATION

Property	Unit	Standard	Tolerance	Values												
Grammage	g/m ²	ISO 536	±3%	170	190	200	210	220	230	250	270	280	300	325	350	400
Caliper	pt	ISO 534	±0.4	8.0	9.6	10.2	10.8	11.6	12.2	13.3						
			±0.6									14.5	15.1	16.3	18.1	19.2
Thickness	μ m	ISO 534	±10	205	245	260	275	295	310	340						
			±15									370	385	415	460	490
Stiffness CD	mNm	ISO 2493	target	1.20	1.60	1.80	2.40	2.50	3.40	4.20	5.40	5.60	7.00	9.50	11.00	16.00
			min	1.08	1.44	1.62	2.16	2.25	3.06	3.78	4.86	5.04	6.30	8.55	9.90	14.40
Stiffness MD	mNm	ISO 2493	target	2.20	3.50	3.50	4.50	5.00	6.50	9.00	10.50	12.00	14.00	19.00	23.00	31.00
			min	1.98	3.15	3.15	4.05	4.50	5.85	8.10	9.45	10.80	12.60	17.10	20.70	27.90
Moisture	%	ISO 287	±1.0	6.0	6.0	6.0	6.0	6.5	6.5	6.5	6.5	6.5	7.0	7.0	7.0	7.0
PPS Top	μ m	ISO 8791-4	≤	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40
Brightness Top	%	ISO 2470-2	±2.0	90.0	90.0	90.0	90.0	90.0	90.0	90.0	90.0	90.0	90.0	90.0	90.0	90.0
Brightness Back	%	ISO 2470-2	±2.0	85.0	85.0	85.0	85.0	85.0	85.0	85.0	85.0	85.0	85.0	85.0	85.0	85.0
Gloss 75° Top	%	ISO 8254-1	≥	45	45	45	45	45	45	45	45	45	45	45	45	45
IGT Blister top	m/s	ISO 3783	≥	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5
IGT Blister back	m/s	ISO 3783	≥	40	40	40	40	40	40	40	40	40	40	40	40	40
COBB 60s Top&Back	g/m ²	ISO 535	±15	130	130	130	130	130	130	130	130	130	130	130	130	130
PLY Bonding	J/m ²	GB/T 26203	≥	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0
Squareness	mm	GB/T 451.1		0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0	0 ~ 2.0
Size Deviation	mm	GB/T 451.1		1.20	1.60	1.80	2.40	2.50	3.40	4.20	5.40	5.60	7.00	9.50	11.00	16.00

Test Condition:(50±2)%RH, (23±1)°C

Version: A-D Date of Issue: 201707(In the case of any changed or revision in the standard, the latest version shall prevail)

Manufactured by: Ningbo Asia Pulp and Paper Co.,Ltd

