

CASCADES S.A.S - La Rochette mill

Folding boxboard, manilla back / **GC2**
High stiffness and high bulk

TECHNICAL STANDARD VALUES

IMPORTANT : please check which the standard grammages on the MANUFACTURING SPECIFICATIONS chart are.

Grammage g/m ²	Caliper µm	Bulk cm ³ /g	Bending stiffness by static methods			
			5 °Angle (L&W) Guaranteed Values mNm		15° Angle (Taber) No guaranteed indicative values (calculated from L&W at 5°) mNm	
			SM	ST	SM	ST
230	440	1.91	30,6	14,0	15,4	7,8
250	480	1.92	36,2	16,0	18,2	8,9
275	550	2.00	51,2	23,5	25,7	13,1
300	600	2.00	66,4	32,0	33,4	17,9

METHODS OF CONTROL / TOLERANCES

Conditioning: for reference 23 °C / 50 % HR

Properties		Testing methods	Tolerances
Grammage	g/m ²	ISO 536	+/- 3 %
Caliper	µm	ISO 534	+/- 5 %
Bending stiffness	mNm	DIN 53 121 5° (L&W)	-15 %

OTHER CHARACTERISTICS

Brightness	Top	%	ISO 2470	90 +/-2
Cobb 1mn	Top/Back	g/m ²	ISO 535	50 +/-20
Suitability for laser coding (Data Matrix)		%		100
Suitability for inkjet (Data Matrix)		%		100
Robinson test (taint)				<1 on a scale from 0 to 4

GUARANTY

- . The material is not guaranteed for blister packaging, lamination and reverse printing
- . The board is guaranteed for 12 months, in terms of its published specification
- . The mill specification is based upon 95% of the measured values being in tolerance

CERTIFICATIONS / ATTESTATIONS

- . PEFC Certified Board available only on demand
- . Food Contact - The board conforms to the German Recommendation BfR XXXVI
- . HACCP accredited, according to the AFNOR Regulation NF V01-006 : 2008