

Folding boxboard (GC1), 100% virgin fibres, multilayered with a white top and a white back, triple coated top and pigmented rear side, with high bulk

Basis weight	ISO 536	g/m ²	180	200	215	230	245	260	280	300	320	345
Thickness / Caliper	ISO 534	µm	255	305	330	360	390	415	455	495	535	585
Specific Volume / Bulk	ISO 534	cm ³ /g	1,42	1,53	1,53	1,57	1,59	1,60	1,63	1,65	1,67	1,70
CIE Whiteness D/65	ISO 11475	%	122	122	122	122	122	122	122	122	122	122
CIE Whiteness D/65 (reverse)	ISO 11475	%	120	120	120	120	120	120	120	120	120	120
ISO Brightness	ISO 2470-1	%	92	92	92	92	92	92	92	92	92	92
ISO Brightness (reverse)	ISO 2470-1	%	90	90	90	90	90	90	90	90	90	90
Gloss (Tappi 75°)	ISO 8254-1	%	45	45	45	45	45	45	45	45	45	45
Bending resistance (L&W 15° MD)	ISO 2493-1	m/N	108	147	186	224	286	343	430	515	618	765
Bending resistance (L&W 15° CD)	ISO 2493-1	m/N	53	72	91	110	140	167	210	250	303	375
Bending moment (Taber 15° MD)	ISO 2493-2	mNm	5,2	7,1	9,0	10,8	13,8	16,6	20,8	24,9	29,8	36,9
Bending moment (Taber 15° CD)	ISO 2493-2	mNm	2,6	3,5	4,4	5,3	6,8	8,1	10,1	12,1	14,6	18,1
Moisture (absolute)	ISO 287	%	6,2	6,8	7,2	7,8	8,0	8,1	8,3	8,6	8,7	8,8
Cobb value 60 sec.	ISO 535	g/m ²	30	30	30	30	30	30	30	30	30	30
Cobb value 60 sec. (reverse)	ISO 535	g/m ²	30	30	30	30	30	30	30	30	30	30
Smoothness (PPS)	ISO 8791-4	µm	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0
Smoothness (PPS, reverse)	ISO 8791-4	µm	5,5	5,5	5,5	5,5	5,5	5,5	5,5	5,5	5,5	5,5
L* (topside)	ISO 5631 - 2		95,5	95,5	95,5	95,5	95,5	95,5	95,5	95,5	95,5	95,5
a* (topside)	ISO 5631 - 2		1,9	1,9	1,9	1,9	1,9	1,9	1,9	1,9	1,9	1,9
b* (topside)	ISO 5631 - 2		-7,5	-7,5	-7,5	-7,5	-7,5	-7,5	-7,5	-7,5	-7,5	-7,5
Scott Bond	ISO 535	J/m ²	145	145	145	145	145	145	145	145	145	145

All properties are according to mill measurements that may be subject to fluctuations which are customary within the industry.

Applications

- Folding boxes, Food packaging, Luxury packaging, Tags, Covers for books and brochures, Folders, Desktop calendars, Desktop displays, Greeting cards

Technical product certificates and information

- Aging resistance (DIN 6738)
- Toy Safety: Migration of elements (DIN EN 71/3)
- Food safety (EC 1935/2004)
- Food safety (FSSC 22000)
- Food safety (BfR recommendation XXXVI)
- Free from heavy metals according to EU packaging directive (94/62/EC)
- Inkjet coding (FFPI – SP 08/2016)

Environmental product certificates and information

- EU Ecolabel
- Elemental chlorine free (ECF)



Supplier certificates

- FSC®
- PEFC™
- Environmental Management System (ISO 14001)
- Quality Management System (ISO 9001)
- Energy management (ISO 50001)
- Occupational Health and Safety Management System (OHSAS 18001)

Technical capability

Printing technologies:	Absorbent substrate that is suitable for offset, UV-offset and screen printing. A sufficient quantity of printing powder with an appropriate particle size has to be considered.
Screen ruling:	All conventional screen rulings up to 80 l/cm (200 lpi) are applicable. When using other screen technologies, tests are recommended before print production.
Printing inks:	Suitable for inks that dry by absorption and oxidation (Offset), for UV-inks and screen printing inks.
Ink drying:	The drying process of the conventional offset ink is entirely completed within 24 to 48 hours, depending on the thickness of the ink film.
Printing pressure:	Standard pressure
Finishing:	All types of varnishing such as overprint-, water-based and UV varnishes, as well as cold foil transfer, hot foil stamping, embossing and die-cutting are possible.
Hot foil stamping:	suitable
Laminating:	suitable
Creasing & folding:	For the substances of 150 g/m ² and higher, the folding process has to be prepared via creasing. In order to obtain the best possible folding results, the common standard values for creasing have to be considered.
Handling information:	The flatness of this paper is guaranteed at a relative humidity between 45 and 55% at a temperature between 20 and 23°C. It is recommended that the printing room has comparable climatic conditions. The paper should be kept as long as possible in the mill-wrapper before use. Extreme changes in temperature and humidity should be avoided.

For all printing and processing techniques, the recommendations of the manufacturers of machines, inks, adhesives, laminating and embossing foils, etc. are to be followed. For damages caused by faulty implementation of printing and processing, Papyrus cannot accept any liability.