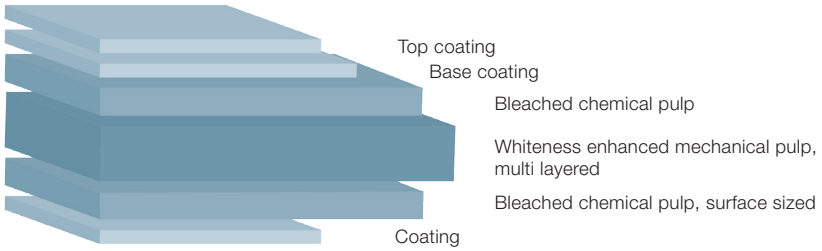
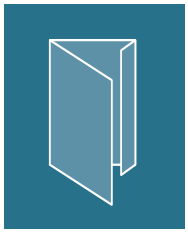
## Folding Box Board, GC1



# Product description

Incada Silk is designed for quality packaging and graphical applications which require outstanding visual impact. It is a fully coated white back folding box board finished to a matt level which gives excellent results in both solid print and half tone illustrations and it easily develops a high print and varnish gloss. The reverse side is single coated and finished to a matt level which gives an aesthetically pleasing appearance and provides improvements compared to an uncoated surface regarding smoothness and uniformity in ink absorption.

Incada Silk is a primary fibre paperboard comprising bleached chemical pulp outer plies, mechanical pulp middle plies and carefully chosen coating ingredients which together meet the requirements for high performance in quality printing and varnishing.

The fully coated finish gives a very smooth surface and meets the requirements for both demanding half tone gravure and offset litho processes, where smoothness and uniform ink absorption are of prime importance. The ink setting and drying properties also ensure good runnability in high speed offset litho processes. Incada Silk works well in most digital printing presses on the market today and is suitable for digital finishing technology.

| Grammage (g/m²) | 220 | 240 | 260 | 280 | 300 | 325 | 350 |
|---|---|---|---|---|---|---|---|
| Thickness (µm) | 325 | 365 | 405 | 445 | 485 | 540 | 590 |
| Caliper (pt) | 12.8 | 14.4 | 15.9 | 17.6 | 19.1 | 21.3 | 23.2 |
| Tolerances:<br>Grammage ± 4% (ISO 536)<br>Thickness ± 4% (ISO 534) | | | | | | | |

The range is further extended by Incada Duo, available in grammages 410–995 g/m².

| Certifications | | | | | |
|---|---|---|---|---|---|
| Product related | ECF | FSC® Mix | Food contact | Toy safety | Archiving |
| | | TT-COC-002067 | EC 1935/2004, EC 2023/2006[1)], American FDA, German BfR | EN 71 Part 3, ISO 8124-3:2010. | ISO 9706 |
| | All fibres from sustainable and controlled sources in compliance with the EU Timber Regulation EC 995/2010. | | | | |
| Mill related | ISO 14001 | FSC® C. o. C. | ISO 9001 | BS OHSAS 18001 | |
| [1)] the GMP regulation, extended with CEPI GMP | | | | | |

More information, application examples as well as environmental declarations and other certificates can be found at www.iggesund.com.

# Incada Silk

## Product properties

| Properties | Printing side | | Reverse side | | |
|---|---|---|---|---|---|
| | | Tolerances | | Tolerances | Methods/Remarks[1)] |
| Grammage (g/m²) | 220-350 | | 220-350 | ± 4% | ISO 536 |
| Colour | | | | | |
| L* (%) | 95.2 | ±0.8 | 96.0 | ±0.8 | ISO 5631-2 |
| a* | 1.4 | ±0.6 | 0.9 | ±0.6 | ISO 5631-2 |
| b* | -7.2 | ±1.0 | -5.2 | ±1.0 | ISO 5631-2 |
| Whiteness (%) | 120 | ±2.5 | 114 | ±5.0 | ISO 11475 |
| ISO brightness (%) | 91.5 | ±2.0 | 90.5 | ±2.0 | ISO 2470 |
| Surface roughness (µm) | 0.9 | ≤ 1.2 | 3.5 | ≤ 5.5 | ISO 8791-4 |
| Board gloss 75° (%) | 50 | -10 | - | - | ISO 8254-1 |
| Surface strength IGT (m/s) | | | | | |
| blister/pick | 1.0 | ≥ 0.85 | 1.3 | ≥ 0.85 | ISO 3783 |
| Cobb (g/m² 60 s) | 30 | - | 30 | - | ISO 535 |
| Ply Bond (J/m²) | 150 | | | ≥ 100 | TAPPI 569 |
| Robinson taint | Below the detection limit of 0.6 | | | - | EN 1230, DIN 10955 |

[1)] See section *General Technical Information*

| Grammage dependent properties | | | | | | | | Tolerances | Methods/Remarks[1)] |
|---|---|---|---|---|---|---|---|---|---|
| Grammage (g/m²) | 220 | 240 | 260 | 280 | 300 | 325 | 350 | ± 4% | ISO 536 |
| Thickness (µm) | 325 | 365 | 405 | 445 | 485 | 540 | 590 | ± 4% | ISO 534 |
| Moisture content (%) | 8.0 | 8.0 | 8.0 | 8.5 | 8.5 | 8.5 | 8.5 | ± 1.0 | ISO 287 |
| Bending stiffness L&W 5° (mNm) | | | | | | | | | |
| MD | 18.5 | 25.2 | 33.0 | 42.0 | 52.2 | 65.8 | 80.5 | - | ISO 5628 |
| CD | 7.7 | 10.5 | 14.2 | 18.3 | 23.0 | 29.1 | 35.6 | - | ISO 5628 |
| Bending resistance L&W 15° (mN) | | | | | | | | | |
| MD | 203 | 271 | 351 | 442 | 544 | 683 | 831 | -15% | ISO 2493 |
| CD | 93 | 122 | 159 | 201 | 248 | 311 | 377 | -15% | ISO 2493 |
| Bending moment Taber 15° (mNm) | | | | | | | | | |
| MD | 9.8 | 13.1 | 16.9 | 21.3 | 26.3 | 33.0 | 40.2 | -15% | ISO 2493 |
| CD | 4.5 | 5.9 | 7.7 | 9.7 | 12.0 | 15.0 | 18.2 | -15% | ISO 2493 |

[1)] See section *General Technical Information*

All properties are measured in test climate 23°C/50% RH at Workington mill. Tolerances and max/min levels, when stated, are based upon 95% confidence interval within each production run.

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