

Technical specification

Certified according to ISO 9001 / ISO 14001

Grade	ATELIER ATEL	Customer
Product description	Folding Boxboard (FBB1/GC1), topside double silk coated, reverse side light coated, offering a state of the art combination of superior brightness level, high board gloss and excellent bulk and stiffness. Suited for direct food contact in accordance with recommendation BfR XXXVI, FDA., Optionally available as PEFC and FSC.	
Conversion	Printing and varnishing - UV, water based and conventional, foil and film lamination, hot foil stamping, cold foil transfer, embossing (high, relief, structure, micro-), diecutting, creasing, grooving, perforating, slitting, flock coating, laser codeing.	
Application	High quality packaging and graphic applications	
Printing	Offset, screen and flexographic printing	

Test climate 23° C, 50 % relative humidity, DIN EN 20 187
All rights to improve quality due to technical modifications reserved

Form number: AA-PQM-029-01/A 09/2015

Revision: B / 09/2018 replaced A / 01/2018

Property	Unit	Standard	Target value							Tolerance
			220.0	240.0	260.0	280.0	300.0	325.0	350.0	
Basis weight	g/m ²	ISO 536	220.0	240.0	260.0	280.0	300.0	325.0	350.0	± 4.0%
Caliper PT	pt		12.5	14.0	16.0	17.5	19.5	21.0	23.5	± 4.0%
Thickness	µm	ISO 534	320.0	360.0	405.0	445.0	495.0	535.0	595.0	± 4.0%
Bending Resistance L&W 15° MD	mN	ISO 2493	174	233	301	379	465	582	720	± 15%
Bending Resistance L&W 15° CD	mN	ISO 2493	85	115	145	190	250	300	375	± 15%
Bending Moment Taber 15° MD	mNm	Taber T489-om-92	8.5	11.5	14.5	18.0	22.2	28.0	35.0	± 15.0%
Bending Moment Taber 15° CD	mNm	Taber T489-om-92	4.0	5.5	7.5	9.5	12.0	14.5	18.0	± 15.0%
Bending stiffness 5° MD	mNm	ISO 2493	15.5	20.4	25.2	31.1	41.7	53.3	67.9	± 15.0%
Bending stiffness 5° CD	mNm	ISO 2493	8.3	10.2	13.5	16.5	22.5	29.5	36.5	± 15.0%
Surface roughness PPS 10 TS	µm	ISO 8791/4	1.2		1.3		1.4			± 0.3
Gloss 75° top side	%	ISO 8254-1	50.00							± 5.00
Gloss 75° reverse side	%	ISO 8254-1	5.00							± 5.00
Water absorbtion Cobb (60) TS	g/m ²	ISO 535	60.00							± 20.00
Water absorbtion Cobb (60) RS	g/m ²	ISO 535	60.00							± 20.00
Internal Scott bond	J/m ²	Tappi T 569	125							± 25
Moisture content abs.	%	DIN EN ISO 287	6.0							± 1.0%
Whiteness (D65) TS	%	ISO 11475	125							± 2
ISO BrightnessC/2° (with UV; D65) TS	%	ISO 2470	100.0							± 1.5
L-value TS	%	ISO 5631	95.5							± 1.0
a-value TS	-	ISO 5631	1.2							± 0.3
b-value TS	-	ISO 5631	-8.6							± 1.0
Whiteness (D65) RS	%	ISO 11475	116							± 2
ISO BrightnessC/2° (with UV; D65) RS	%	ISO 2470	98.5							± 1.5
L-value RS	-	ISO 5631	95.5							± 1.0
a-value RS	-	ISO 5631	1.3							± 0.3
b-value RS	-	ISO 5631	-6.5							± 1.0