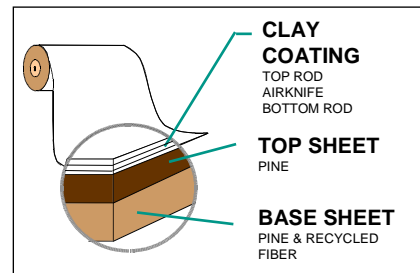


Description

A high wet-strength sheet used primarily for beverage packaging. Designed to provide package integrity in high humidity conditions in filling line production, distribution and usage.

Features

- ◆ Made from solid unbleached sulfate virgin kraft fiber, recycled pre-consumer fiber
- ◆ Wet strength
- ◆ Two plies
- ◆ Three layers of clay coating
- ◆ Naturally beautiful brown back
- ◆ High stiffness
- ◆ High resistance to tear, puncture and corner crush



Produced by Graphic Packaging International

Advantages

- ◆ Superior tear resistance when wet
- ◆ Excellent dry tear resistance
- ◆ Beautiful graphic reproduction for eye-catching packages
- ◆ Time proven for multiple packaging in wet environments
- ◆ Performs well on high-speed multiple packaging lines
- ◆ Made from renewable and renewed resource and recycled fiber
- ◆ SUS carrierboard technology developed by Graphic Packaging International
 - ❖ First wet-strength paperboard grade
 - ❖ First paperboard machine designed specifically for carrierboard (1966)

Inspection Standards

The following defects are not allowed: scabs, holes, unmarked splices, wrinkles, calendar cuts, shaving/scrap in rolls

Slitting and Winding Requirements

- ◆ Roll widths are cut and sold to the nearest 1/8"
- ◆ Roll width tolerance is +/- 1/16"
- ◆ Roll diameter tolerance is +/- 1/2"
- ◆ Splices - No closer than 1" of diameter, max 2 per roll
- ◆ Telescoping - Not to exceed 1/2", measured from core to top of roll
- ◆ Cores - Not to extend more than 1/4" from either side of roll
- ◆ Edges - Clean cut (dust free)

Machine Trim

| | | |
|---------|----------|--------|
| ◆ #2 GA | | 183.5" |
| ◆ #6 LA | 16-23 pt | 226.0" |
| | 24-28 pt | 227.0" |
| ◆ #7LA | | 234.0" |



Technical Specifications - North America

| | | TAPPI | | | | | | | | | | | |
|------------------------------------------------|---------|---------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| Caliper (0.001 ") | T411 | Nominal | .016 | .018 | .020 | .021 | .022 | .023 | .024 | .025 | .026 | .027 | .028 |
| | | Range | .015-.017 | .017-.019 | .019-.021 | .020-.022 | .021-.023 | .022-.024 | .023-.025 | .024-.026 | .025-.027 | .026-.028 | .027-.029 |
| Basis Weight (lbs/msf) | T410 | Nominal | 70 | 74 | 78 | 82 | 86 | 90 | 93 | 97 | 100 | 105 | 108 |
| | | Minimum | 66.5 | 70.3 | 75 | 78 | 81.7 | 85.5 | 88.4 | 92.2 | 95 | 99.8 | 102.6 |
| Taber Stiffness (g _r ·cm) | MD T489 | Nominal | 190 | 250 | 335 | 375 | 420 | 475 | 575 | 615 | 675 | 750 | 810 |
| | CD | Nominal | 90 | 130 | 165 | 180 | 195 | 215 | 240 | 255 | 275 | 300 | 345 |
| Elmendorf Wet Tear (g _r) | MD | Nominal | 400 | 450 | 485 | 520 | 550 | 575 | 600 | 630 | 655 | 685 | 710 |
| | | Minimum | 250 | 300 | 355 | 385 | 415 | 430 | 450 | 475 | 495 | 520 | 535 |
| | CD | Nominal | 425 | 490 | 540 | 565 | 585 | 610 | 630 | 655 | 675 | 695 | 715 |
| | | Minimum | 275 | 335 | 395 | 425 | 450 | 470 | 490 | 515 | 535 | 555 | 575 |
| Elmendorf Dry Tear (g _r) | MD T414 | Nominal | 430 | 490 | 540 | 570 | 600 | 625 | 655 | 680 | 720 | 740 | 765 |
| | | Minimum | 280 | 330 | 395 | 455 | 455 | 480 | 500 | 525 | 545 | 570 | 595 |
| | CD | Nominal | 475 | 535 | 590 | 620 | 650 | 680 | 705 | 735 | 765 | 790 | 820 |
| | | Minimum | 305 | 375 | 435 | 465 | 500 | 520 | 540 | 565 | 595 | 615 | 635 |

| Specs Common to All Calipers | Sheffield | | | | | |
|-----------------------------------------|-----------|-------------|---------------|--------------|----------------|----------|
| | | Smoothness | GE Brightness | Parker Print | Scott Ply Bond | Moisture |
| | Nominal | 140 | 81.2 | 2.0 | 65 | 7.0 |
| | Range | MAXIMUM 225 | MINIMUM 80.2 | MAXIMUM 3.0 | MINIMUM 45 | 5.5-8.5 |
| TAPPI | T538 | T452 | T555 | T833 | T412 | |

***SPECIFY: Rotogravure, Flexographic or Lithographic Process When Ordering**

All physical measurements done at 23°C 50% relative humidity.

Specifications are for quality control measures of paperboard samples from mill reels.

Measurements taken after sheeting or other conversion processes may not match these specifications.