

NINGBO FOLD

C1S FOLDING BOX BOARD

Basis Weight		Thickness		Stiffness (Taber 15°)	
g/m ² ±3%	24"x36" 500 (lb)	μm	pt	mN·m	
				CD≥	MD≥
170	104	205±10	8.0±0.4	1.2	2.2
190	117	245±10	9.6±0.4	1.6	3.5
200	123	260±10	10.2±0.4	1.8	3.5
210	129	275±10	10.8±0.4	2.4	4.5
220	135	295±10	11.6±0.4	2.5	5.0
230	141	310±10	12.2±0.4	3.4	6.5
250	154	340±10	13.4±0.4	4.2	9.0
270	166	370±15	14.6±0.6	5.4	10.5
280	172	385±15	15.2±0.6	5.6	12.0
300	184	415±15	16.3±0.6	7.0	14.0
350	215	490±15	19.3±0.6	11.0	23.0
400	246	555±15	21.9±0.6	16.0	31.0

Property	Unit	Value
PPS (Top)	μm	1.4
Moisture	%	< 220gsm 6.0±1.0
		220-280gsm 6.5±1.0
		300-400gsm 7.5±1.0
Brightness	%	Top: 90.0±2.0 Back: 85.0±2.0
75°Gloss (Top)	%	≥45
IGT Blister (Top)	m/s	≥1.5
COBB Test (60s) (Top/Back)	g/m ²	40±15
PLY bonding	J/m ²	≥130
Squareness	mm	≤2.0
Size Deviation	mm	≤2.0

Test condition (ISO): temp (23±1)°C, relative humidity (50±2)%