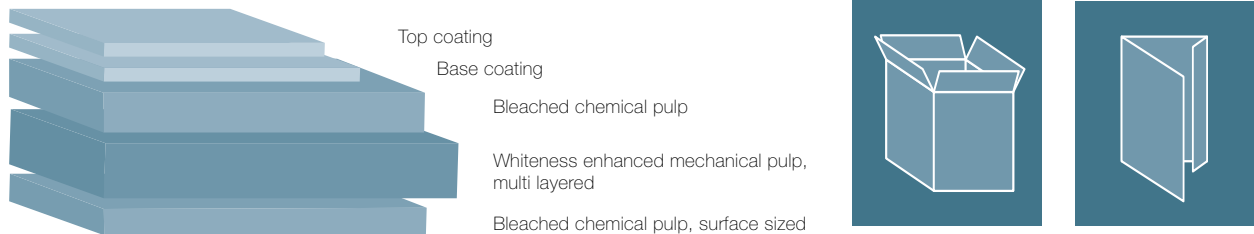


# Incada Exel

## Folding Box Board, GC2



## Product description

Incada Exel is designed for quality packaging applications where outstanding visual impact is of prime importance. Its stiffness characteristics in relation to grammage make it particularly suitable for large machine erected cartons. Incada Exel 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 on the printing side 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 characteristics are of prime importance. The reverse side is uncoated and can be printed for less demanding printing requirements. Incada Exel Hard Sized is available for end uses with higher water resistance demands. Incada Exel can be PE extrusion coated on both the print and reverse sides. Incada Exel works well in most digital printing presses on the market today and is suitable for digital finishing technology.

Grammage (g/m <sup>2</sup> )	210	225	235	255	280	300	325	350
Thickness (µm)	340	375	400	450	490	540	590	640
Caliper (pt)	13.4	14.8	15.7	17.7	19.3	21.3	23.2	25.2
Tolerances: Grammage ± 4% (ISO 536) Thickness ± 4%, max ± 20 µm (ISO 534)								

The range is further extended by Incada Duo, available in grammages 410–995 g/m<sup>2</sup>.

Certifications					
Product related	ECF	FSC® Mix	Food contact	Toy safety	
		FSC-C008588 TT-COC-002067	EC 1935/2004, EC 2023/2006 <sup>1)</sup> , American FDA, German BfR	EN 71 Part 3 EN 71 Part 9	
	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	ISO 50001
EcoVadis Gold Standard					
<sup>1)</sup> 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](http://www.iggesund.com).

Product properties

Properties					
	Printing side		Reverse side		Methods/Remarks <sup>1)</sup>
		Tolerances		Tolerances	
Grammage (g/m <sup>2</sup> )	210-350		210-350	± 4%	ISO 536
Colour					
L* (%)	95.2	±0.8	95.0	-	ISO 5631-2
a*	1.4	±0.6	0.5	-	ISO 5631-2
b*	-7.2	±1.0	-2.0	-	ISO 5631-2
Whiteness (%)	120	±2.5	97	-	ISO 11475
ISO brightness (%)	91.5	±2.0	86		ISO 2470
Surface roughness (µm)	0.9	≤ 1.3	-	-	ISO 8791-4
Board gloss 75° (%)	50	-10	-	-	ISO 8254-1
Surface strength IGT (m/s)					
blister/pick	1.0	≥ 0.85	-	-	ISO 3783
Cobb (g/m <sup>2</sup> 60 s)	30	-	30	-	ISO 535
Ply Bond (J/m <sup>2</sup> )	140			≥ 95	TAPPI 569
Robinson taint	Below the detection limit of 0.6			-	EN 1230, DIN 10955

<sup>1)</sup> See section *General Technical Information*

Grammage dependent properties									Tolerances	Methods/Remarks <sup>1)</sup>
Grammage (g/m <sup>2</sup> )	210	225	235	255	280	300	325	350		
Thickness (µm)	340	375	400	450	490	540	590	640	± 4%	ISO 536
Moisture content (%)	8.0	8.0	8.0	8.5	8.5	8.5	8.5	8.5	±1.0	ISO 287
Bending stiffness L&W 5° (mNm)										
MD	20.1	26.3	29.4	38.4	49.2	60.4	77.4	91.4	-	ISO 5628
CD	7.9	10.6	11.9	15.8	20.5	25.4	32.8	38.9	-	ISO 5628
Bending resistance L&W 15° (mN)										
MD	220	282	314	405	515	628	800	941	-15%	ISO 2493
CD	96	123	136	176	224	273	348	409	-15%	ISO 2493
Bending moment Taber 15° (mNm)										
MD	10.6	13.6	15.2	19.6	24.9	30.3	38.7	45.5	-15%	ISO 2493
CD	4.6	5.9	6.6	8.5	10.8	13.2	16.8	19.8	-15%	ISO 2493
Hard Sized Cobb (g/m <sup>2</sup> 180 s)										
printing side	40	40	40	40	40	40	40	40	≤ 50	ISO 535
middle layers	40	40	40	40	40	40	40	40	≤ 50	ISO 535
reverse side	45	45	45	45	40	40	40	40	≤ 50	ISO 535

<sup>1)</sup> See section *General Technical Information*

Issued 06..2019

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 limits within each production run.