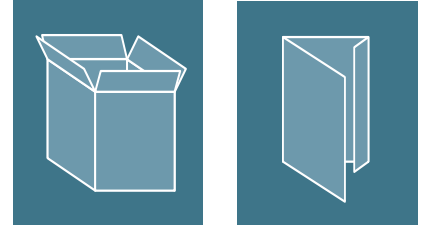
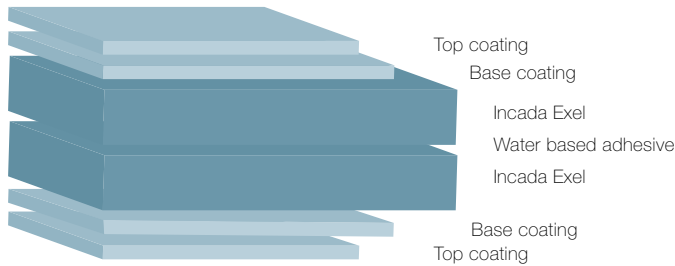


# Incada Duo

## Folding Box Board, GC1



## Product description

Incada Duo is designed for applications where outstanding stiffness properties in combination with visual impact are of importance. Incada Duo can be extrusion coated to add the barrier functions necessary under extreme conditions, e.g. outdoor displays or foil or film laminated for added sales appeal.

Incada Duo is a symmetrical fully coated folding box board with a medium gloss finish. It is made by back-to-back pasting of Incada Exel. The printing surfaces are therefore identical. Alternative versions are available, with e.g. front-to-back pasting to achieve special properties or appearances. An Iggesund representative would be happy to discuss further and give advice. Incada Duo has a medium gloss finish. Its whiteness ensures a good contrast against print.

Grammage (g/m <sup>2</sup> )	430	480	520	570	660	710	785	995
Thickness (µm)	670	790	890	970	1170	1290	1320	1740
Caliper (pt)	26.4	31.1	35.0	38.2	46.1	50.8	52.0	68.5
Tolerances: Grammage ± 6% (ISO 536) Thickness ± 6% (ISO 534)								

Certifications					
Product related	ECF	FSC® Mix	Food contact	Toy safety	
		FSC-C008588	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 Platinum 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 - both sides identical		
		Tolerances	Methods/Remarks <sup>1)</sup>
Grammage (g/m <sup>2</sup> )	430-995	± 6%	ISO 536
Colour			
L* (%)	95.2	±0.8	ISO 5631-2
a*	1.4	±0.6	ISO 5631-2
b*	-7.2	±1.0	ISO 5631-2
Whiteness (%)	120	±2.5	ISO 11475
ISO brightness (%)	91.5		
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) both sides	30	-	ISO 535
Ply Bond (J/m <sup>2</sup> )	140	≥ 80	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>
<b>Grammage (g/m<sup>2</sup>)</b>	<b>430</b>	<b>480</b>	<b>520</b>	<b>570</b>	<b>660</b>	<b>710</b>	<b>785</b>	<b>995</b>	± 6%	ISO 536
Thickness (µm)	670	790	890	970	1170	1290	1320	1740	± 6%	ISO 534
Moisture content (%)	8.0	8.0	8.0	8.5	8.5	8.5	8.5	8.5	±1.5	ISO 287
Bending stiffness L&W 5° (mNm) <sup>2)</sup>										
MD	145	250	340	405	490	605	735	1050	-	ISO 5628
CD	77	125	165	190	235	295	380	635	-	ISO 5628
Bending resistance L&W 15° (mN) <sup>2)</sup>										
MD	1600	2300	2700	3100	3600	4200	4900	7500	-	ISO 2493
CD	700	1100	1300	1600	2000	2400	3000	4300	-	ISO 2493
Bending moment Taber 15° (mNm) <sup>2)</sup>										
MD	77	111	130	150	174	203	237	362	-	ISO 2493
CD	34	53	63	77	97	116	154	208	-	ISO 2493

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

<sup>2)</sup> Typical values

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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.