



ITC PAPERBOARDS & SPECIALTY PAPERS DIVISION

UNIT BHADRACHALAM



PRODUCT SPECIFICATION SHEET

Grade Name : FILO SERVE
Grade Id : S08R/S011R/S08F/S11F

Issued On: 01/04/2020
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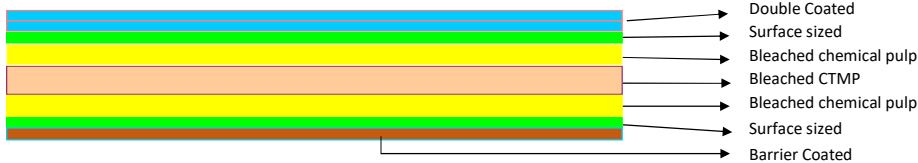
SUBSTANCE (GSM) (Avg) QS/TM/55 Tappi T 410	CALIPER (μM) (Avg) QS/TM/06 Tappi T 411	CALIPER (Pts)	BENDING RESISTANCE (L&W) mN QS/TM/33 Tappi T 556			BENDING MOMENT (Taber 15°) mNm QS/TM/33 Tappi T 489			TABER STIFFNESS (Taber 15°) gf.cm Tappi T 489		
			MD	CD	GM	MD	CD	GM	MD	CD	GM
200	310	12.2	138	71	99	6.7	3.4	4.8	68	35	49
210	326	12.8	160	85	117	7.7	4.1	5.7	79	42	58
220	342	13.5	187	103	139	9.0	5.0	6.7	92	51	68
230	357	14.0	203	112	151	9.8	5.4	7.3	100	55	74
240	372	14.6	244	126	175	11.8	6.1	8.5	120	62	86
250	388	15.3	280	146	202	13.5	7.1	9.8	138	72	100
260	408	16.1	299	155	215	14.5	7.5	10.4	147	76	106
270	424	16.7	331	168	236	16.0	8.1	11.4	163	83	116
280	440	17.3	379	186	266	18.3	9.0	12.8	187	92	131
290	460	18.1	431	211	302	20.8	10.2	14.6	212	104	149
300	486	19.1	483	227	331	23.3	11.0	16.0	238	112	163
320	518	20.4	597	293	418	28.8	14.1	20.2	294	144	206
TOL : ± 3%	± 5%	± 5%			-15%			-15%			-15%

PARAMETER	UNITS	VALUE
PLY BOND (Avg.) QS/TM/40 , Tappi T 569	J/m ²	150 MIN
ROUGHNESS PPS (Avg.) TOP	μm	1.50 MAX 1.80 MAX 2.00 MAX
GSM ≤ 250 250 < GSM ≤ 340 GSM > 340 QS/TM/49 , Tappi T 555		
BRIGHTNESS ISO TOP	%	85 MIN
QS/TM/77 , Tappi T 452		
WHITENESS CIE TOP	%	85 MIN
QS/TM/78 , Tappi T 560		
COBB 1MIN BOTTOM	GSM	50 MAX
QS/TM/81, Tappi T 441		
SURFACE STRENGTH IGT PICK (MED.VISCOSITY) TOP	m/s	0.7 MIN
QS/TM/31 , ISO 3782 & 3783		
GLOSS AT 75° (Avg.) TOP	%	35 (-5)
QS/TM/27 , Tappi T 480		
MOISTURE GSM ≤ 300 GSM > 300 QS/TM/35 , Tappi T 412	%	7.0 ± 1.0 8.0 ± 1.0

MILL CERTIFICATIONS	
Manufacturing	ISO 9001: 2015, ISO 14001: 2015, BRC Global Standard, Issue-5
Environmental & Safety	FSC® CoC, Light ECF, CII GreenCo Platinum, OHSAS 18001: 2007
FOOD CONTACT COMPLIANCE	
USFDA	CFR 21 176.170 CFR 21 176.180
REACH SVHCs	Article 57, EC1907/2006, ECHA
ROHS/BfR XXXVI	EC1907/2006 EU2015/863 RoHS-EU/65/2011
CALIFORNIA PROPOSITION 65	NOT REQUIRED
AfPS German Standards	AfPS GS 2014.01 PAK
QUALITY INSPECTION & SERVICE LABORATORIES	
Fully NABL Accredited	

NOTE
1. All Properties are according to ITC PSPD Measurements
2. Test Climate 23°C ± 1 & 50% ± 2 RH
3. Tolerances are based upon 95% Confidence limits of single mill measurements of conditioned random samples
4. KIT Levels - 8 & 12
5. In case of gluing with hot melt glue / cold glue it is recommend to serrate glue flap with atleast 0.2 mm depth and an inter - serration gap of 4 mm. For any further guidance regarding refrigeration / deep freeze application kindly write to us for guidance on type of glue to be used

CONSTRUCTION



KEY USAGE

TRAYS CARTONS FOOD STORAGE BOXES

Spec No : FILO SERVE/GEN/PSPD/BCM/007

Format No: F/QISD/1