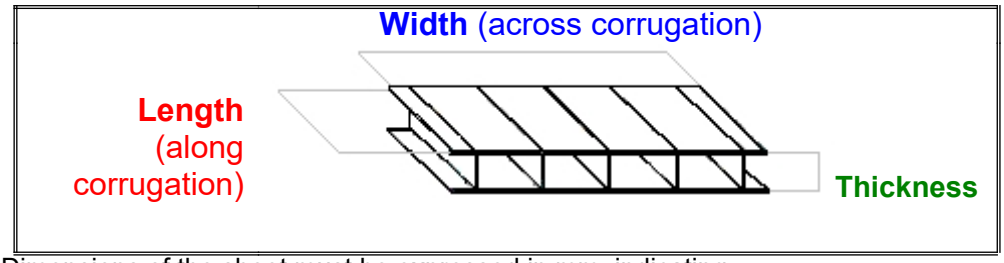
	INFORMATION DATA SHEET	Rev. 8 Date 23/06/2015 Pag. 1 di 4



Dimensions of the sheet must be expressed in mm, indicating:
Length X **Width** X **Thickness**
First dimension given is always flute direction

Basic component: Copolymer polypropylene (C_3H_6)n(C_2H_4)m

CHARACTERISTICS		FEASIBILITY	ACCEPTANCE CRITERIA	TESTING PROCEDURE NO:
Length (sheets)		From 600 to 6.000 mm *	+/- 1%	7
Length (rolls)		From 50 mt. to Ø max. roll 1 mt		
WIDTH	**Standard flute sheet**	From 400 to 2700 mm	+/- 3 mm	7
	Semilarga flute sheet	From 400 to 2050 mm		
	Triple wall sheet	From 400 to 2100 mm		
	Rolls without core	From 300 to 1200 mm		
	Rolls with core (internal diameter 152.4 mm 6'')	From 300 to 1300 mm		
	Rolls with core (internal diameter 201 mm)	From 300 to 2400 mm		
Diagonals difference		///	< 0.5 % up to max 10 mm	8
THICKNESS	**Standard flute sheet**	From 1.8 to 5.0 mm	+/- 0.1 mm	9
	Semilarga flute sheet	From 3.5 to 8.0 mm		
	Triple wall sheet	From 7.0 to 11,0 mm		
	(rolls)	From 1.8 to 2.5 mm		

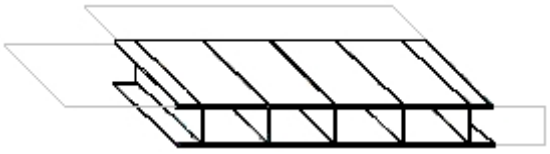
ISO 9001 BUREAU VERITAS Certification

ISO 22000 BUREAU VERITAS Certification

DENSITY	Standard flute sheet	From 240 to 1500 gsm	+/- 10% up to 1.000 gsm +/- 5% more then 1.000 gsm	10
	Semilarga flute sheet	From 450 to 2000 gsm		
	Triple wall sheet	From 800 to 3000 gsm		
	(rolls)	From 250 to 450 gsm		
Master opacity level		///	+/- 5 % by comparison with sample of reference	12
Planarity		///	Max. 1 wave and +/- 0.5% length / width	14
Appearance		Evaluation made by the quality control personnel in comparison with the sample of reference		18

Smaller dimensions can be achieved with further working after extrusion.

Density limits given by thickness and rib distance



Rib Distance

Standard flute – rib distance 3,2 – 3,5 mm								
Thickness mm		1.8	2.0	2.5	3.0	3.5	4.0	4.5	5
Density Gsm	Min	240	250	350	400	600	700	850	900
	Max	350	700	800	1.200	1.500	1.500	1.500	1.500

Semilarga flute – rib distance 4,5 mm							
Thickness mm		3.5	4,0	4.5	5.0	6.0	7.0	8.0
Density Gsm	Min	450	500	600	650	1.000	1.500	1.500
	Max	600	800	800	1.500	2.000	2.000	2.000

Triple Wall flute – rib distance 5,3 mm					
Thickness mm		7.0	8.0	10.0	11.0
Density Gsm	Min	800	1.450	1.750	2.400
	Max	1.500	2.500	3.000	3.000

Possible treatments – on Customer's request when asking for quotation

1) Printing treatment

- **>=** 46 dyne / cm for every kind of flute type and thickness except layer pads
- on both sides of the sheet
- Average duration 6 months under proper stocking conditions (i.e. packaged sheets properly stocked in dry places)

2) Antistatic / conductive treatment

	Feasibility	Resistivity (Ω)	Duration of treatment	Colour
Conductive sheets (volumetric)	All densities	$10^3 – 10^4$	Permanent	Black
Conductive sheets (superficial) *	Density > 700gsm	$10^3 – 10^4$	Permanent	Black
Dissipative sheets (volumetric)	All densities	$10^6 – 10^8$	Permanent	Black
Dissipative sheets (superficial) *	Density> 700gsm	$10^6 – 10^8$	Permanent	Black
Antistatic sheets**	All densities	$10^9 – 10^{11}$	1 year	Any colour

**The resistivity that could be obtained is influenced by the environmental humidity, that is necessary to obtain the resistivity level above-written. In order to have a duration of treatment of one year is necessary to avoid to wash and rub the surface of the sheet, because the additive would lose his effectiveness.

3) Anti UV treatment

- Depending on the duration of UV exposure, ask for adequate treatment grade.

4) Flame Retardant treatment

- The flame retardant treatment gives to the sheet flame retardant properties.

Other processes available

- Back trimming and die-cutting **performed under standard temperature conditions** (the tolerance on length and width of the sheets is reduced to +/- 1 mm during these procedures).
- Edge sealing (only for layer pads, the tolerances on length and width of the sheets are reduced to +/- 5 mm)
- Microperforation (only on one side of the sheet) for density<800gsm
- Print
    - Flexo printing on line 1 colour on both sides of the sheet. Max dimensions of printing 450x 90 mm
    - Positioned flexo printing off the line, up to 5 colours. Max dimensions of printing 1.500x1.900 mm
    - Screen printing off the line. Max dimensions of printing 1.500x1.900 mm

Packaging

- On wooden pallets, packed with shrinking film, strips and side corner protectors.

Basic technical conditions of supply

- Flute type and colour are features agreed with Customer by comparison with the sample of reference.
- Conformity of the material to particular laws (i.e. food contact, toys, etc.) can be certified and declared only on Customer's request white asking for quotation.
- Selling units of measurement: no. of pieces, possible requests in kilo are converted in pieces using density
- You have to keep the identification label of the product to go back easily over the product.
- All the processes and the controls on the product take place in standard temperature conditions.

- Instructions for further processes: before other processes make sure that all the material reach a temperature higher than 15°C in every part of it.