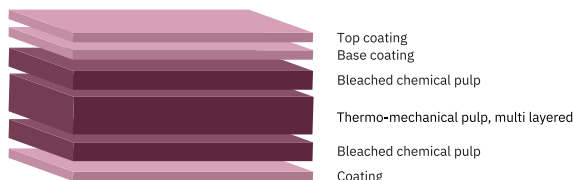


INCADA SILK



Folding Box Board

Incada is a folding box board (FBB) product based entirely on fresh fibres. It has a multi-layered fibre composition and construction designed to maximise its stiffness whilst having a low density. The outer layers consist of bleached chemical sulphate pulp, and the middle layers of thermo-mechanically separated fibres (TMP). Pigment coating can be applied to one or both sides, and its unique composition is designed to ensure that the product family meets different end-use printability requirements.

Product description

Incada Silk is a fully coated white-backed folding box board (FBB) designed for high quality packaging and graphics applications. The product has been developed and is produced to ensure a supremely smooth surface which is double coated with a unique and specially developed coating formulation. The reverse side of Incada Silk is single coated with a matt finish that provides consistent results in both solid print and halftone illustrations. This primary fibre paperboard consistently meets the requirements for high performance in quality printing and varnishing. The ink setting and drying properties ensure good runnability in high-speed offset litho processes. Incada Silk performs well in digital printing presses and is suitable for digital finishing technology.

Incada
Certifications & Standards

Product related		
FSC® Mix	Food safety	Toy safety
FSC-C008588 SA-COC-012971	EC 1935/2004 EC 2023/2006 FDA 21 CFR German BfR XXXVI Normpack	EN 71 Part 3 EN 71 Part 9
All fibres from sustainable and controlled sources in compliance with the UK Timber Regulation 01/01/2021.		
EcoVadis Platinum Medal awarded in 2023 (top 1% of all companies assessed).		
Recyclable according to CEPI Recyclability Test Method - Standard Paper Mill Version 2.		

Mill related
ISO 9001
ISO 14001
ISO 45001
ISO 50001
FSC®
FSSC 22000

For more detailed information about our certificates, visit holmen.com/boardandpaper/certifications.

Properties - Print side

		Tolerances	Methods/Remarks
Grammage (g/m ²)	220-350	+/-4%	ISO 536
Colour L* - PS	95.2	+/-0.8	ISO 5631-2
Colour a* - PS	1.4	+/-0.6	ISO 5631-2
Colour b* - PS	-7.2	+/-1.0	ISO 5631-2
Whiteness - PS	120	+/-2.5	ISO 11475
ISO Brightness R457 - PS (%)	91.5	+/-2.0	ISO 2470
Surface roughness PPS - PS (µm)	0.9	≤1.4	ISO 8791-4
Board gloss 75° - PS (%)	50	-10	ISO 8254-1
Surface strength IGT blister - PS (m/s)	1.0	≥0.85	ISO 3783
Surface strength IGT pick - PS (m/s)	1.0	≥0.85	ISO 3783
Cobb - PS (g/m ²)	30	-	ISO 535

Properties - Reverse side

		Tolerances	Methods/Remarks
Grammage (g/m ²)	220-350	+/-4%	ISO 536
Colour L* - RS	96.0	+/-0.8	ISO 5631-2
Colour a* - RS	0.9	+/-0.6	ISO 5631-2
Colour b* - RS	-5.2	+/-1.0	ISO 5631-2
Whiteness - RS	114	+/-5.0	ISO 11475
ISO Brightness R457 - RS (%)	90.5	+/-2.0	ISO 2470
Surface roughness PPS - RS (µm)	3.5	≤5.5	ISO 8791-4
Cobb - RS (g/m ²)	30	-	ISO 535

Common properties

	Tolerances		Tolerances		Tolerances		Tolerances		Methods/Remarks
Grammage (g/m²)	220-350	+/-4%	220	+/-4%	240-280	+/-4%	300-350	+/-4%	ISO 536
Moisture content (%)	-	-	6.5	+/-1.0	8.0	+/-1.0	8.5	+/-1.0	ISO 287
Ply bond (J/m²)	-	-	130	≥90	150	≥100	150	≥100	Tappi 569
Robinson taint	<0.6	-	-	-	-	-	-	-	EN 1230-2

Robinson taint value is below the detection limit of 0.6.

Grammage dependent properties

	Tolerances								Methods/Remarks
Grammage (g/m²)	220	240	260	280	300	325	350	+/-4%	ISO 536
Thickness (µm)	330	365	405	445	485	540	590	+/-4%	ISO 534
Caliper (pt)	13.0	14.4	15.9	17.6	19.1	21.3	23.2	-	-
Bending stiffness L&W 5° - MD (mNm)	18.3	25.2	33.0	42.0	52.2	65.8	80.5	-	ISO 5628
Bending stiffness L&W 5° - CD (mNm)	7.9	10.5	14.2	18.3	23.0	29.1	35.6	-	ISO 5628
Bending resistance L&W 15° - MD (mN)	218	271	351	442	544	683	831	-15%	ISO 2493-1
Bending resistance L&W 15° - CD (mN)	91	122	159	201	248	311	377	-15%	ISO 2493-1
Bending moment Taber 15° - MD (mNm)	10.5	13.1	16.9	21.3	26.3	33	40.2	-	-
Bending moment Taber 15° - CD (mNm)	4.4	5.9	7.7	9.7	12.0	15.0	18.2	-	-

Bending Moment Taber is a calculated value based on a correlation factor of 20.7.

Test methods

All properties are measured in test climate 23°C/50% RH at Workington Mill. Tolerances and max/min levels, when stated, are based upon a 95% confidence interval within each production run. Read more about testing methods in our [General Technical Information](#).

Latest version

Access the latest version of this spec sheet on:
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