

Kunde (Customer): _____

Stand: 24.08.2011 (Änderungen vorbehalten)
 date: (subject to change)

Moritz J. Weig GmbH & Co. KG

Verkaufsabteilung (sales department):	Werksleitung (plant management):
Qualitätsabteilung (Quality department):	Qualitätsabteilung (Quality department):

Rollendaten - Specification of reels					
	Rollendurchmesser reel diameter	Rollengewicht reel weight	Gipsseite winding direction	Durchmesser Hülse core diameter	Rollenbreite reels width
	[mm]	[t]		[mm]	+/- 3 mm
	max.	max.			like ordert
Sichtseitenkarton top liner	2000	3,5	outside/inside	76/100/150	
Rückseitenkarton back liner	2000	3,5	outside/inside	76/100/150	

Notiz:	maximal 20 Flecken < 1,0 mm/m ² oder 8 Flecken < 3,0 mm/m ²
Note:	max. 20 spots < 1,0 mm/m ² pr 8 spots < 3,0 mm/m ²
Notiz:	maximal 2 Klebestellen pro Rolle
Note:	max. 2 paper splices per reel

All tests to be made at the mother reel (Tambour) and directly after production

Test methods, objective units of measurement, standards and specification parameters to be established, agreed and tested against physical standard samples held in both mill and wallboard plant laboratories.

The Plasterboard liner is treated by size press.

This specification has been compiled against known plant conditions and product end use, and is subject to change, with the customer's and supplier`s agreement, in line with changing plant conditions and/or finished product performance and according to the standard test method adopted.

If the Plasterboard liner NOT treaded by size press the paper tensile is -10%

Sichtseitenkarton-Top Paper [Gelb-Ivory (518), Gelb VE-Ivory VE (517), Green (530), Pink (531), Blue (533)]															
Flächen gewicht basis weight	+/- 2,0%		g/m ²			160	170	180	190	200	210	220			Norm/Standard EN ISO 536
Porosität Gurley			sec	<=		100								Norm/Standard ISO 5636-5	
Cobb		Top side	g/m ²		20-30								Norm/Standard EN 20535		
		Gyp. Side			20-50 (Agree with the plant)										
Moisture	+/- 1,0%		%			11,00	11,0	11,0	11,0	11,0	11,0	11,0			EN 20287
Festigkeit		MD	N	>=		180	190	200	210	215	220	225			Bone dry tensile method X
						175	185	195	205	210	215	220			
tensile strength		CD	N	>=		55	57	59	61	63	65	67			
						52	54	56	58	60	62	64			
Weisse				>=	50								DIN 53145 - 1		
Brightness															
Rutsch winkel sliding angle				>=	22										
Dennison		Top side		>=	12								ASTM D 2482 - 97		
		Gyp. Side													

Rückseitenkarton-Back Paper [Grau-Grey (510); Greengrey (532) Grey without size Press (508&509)]															
Flächen gewicht basis weight	+/- 2,0%		g/m ²			140	150	160	170	180	190	200			Norm/Standard EN ISO 536
Porosität Gurley			sec	<=		100								Norm/Standard ISO 5636-5	
Cobb		Top side	g/m ²		20-30								Norm/Standard EN 20535		
		Gyp. Side			20-50 (Agree with the plant)										
Moisture	+/- 1,0%		%		10,3	10,3	10,3	10,3	10,3	10,3	10,3	10,3			EN 20287
Festigkeit		MD	N	>=		145	150	155	160	165	170	175			Bone dry tensile method X
						140	145	150	155	160	165	170			
tensile strength		CD	N	>=		62	64	66	69	71	73	75			
						59	61	63	66	68	70	72			
Weisse				>=	n. m.								DIN 53145 - 1		
Brightness															
Rutsch winkel sliding angle				>=	18										
Dennison		Top side		>=	12								ASTM D 2482 - 97		
		Gyp. Side													

X 1) Bone dry tensile method: -Conditioning at 105°C
 - for 5 Minutes
 - Test sample 100 x 15mm stripe
 - Speed 50 mm/min

2) Minimum Tensile strength
 - This numbers are the minimum Average of the Motherreel!
 - No individual value for MD tensile will be outwith 5% of the minimum and CD tensile outwith 10% of the minimum.

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