


INTERNATIONAL 	IP - Luiz Antônio Mill		Code	EP.14.05.605
	Product Specification		Revision	00
	Title: Product: Cut Size, Laser and Inkjet 80 g/m²		Area	CPP/SO
	Place: Papermachine - Winder Product Code 02.06.00		Pages	1/2
Customer: Standard				

1) Main Characteristics


Characteristic		Unit of Measurement	Specification			Reference
			Nominal	Minimum	Maximum	
Grammage		g/m ²	80.0	76.8	83.2	ISO 536-2000
Thickness		mm	0.104	0.100	0.108	ISO 534-1988
Moisture		%	4.0	3.3	4.7	ISO 287-1985
HST Sizing	Felt	s	165	90	NA	TAPPI T530 om-96
Porosity Gurley		s/100 cc	12	8	NA	TAPPI T460-02
Roughness Bendtsen	Felt	mL/min	NA	NA	NA	ISO 8791-2:1990
	Wire	mL/min	NA	NA	NA	ISO 8791-2:1990
Formation Index - MK		nº	NA	NA	NA	--
Brightness ISO	Felt	-	98.0	95.9	NA	ISO 2469-1994
Opacity		%	91.0	89.0	NA	ISO 2471-1998
Whiteness CIE (D65/10º)		-	161.0	158.0	164.0	ISO 11475-1999
Stiffness	MD	gf.cm	2.8	2.2	NA	ISO 2493-1992
	CD	gf.cm	1.3	1.0	NA	ISO 2493-1992
Format Variation	Cut Size	mm	NA	-1	+1	ME.06.03.049
Folio - Format up to 1000 mm	CD	mm	NA	- 2	+ 2	ME.06.03.049
- Format over 1000 mm	CD	%	NA	- 2.0	+ 0.2	ME.06.03.049
	MD	mm	NA	- 2	+ 2	ME.06.03.049
Reels		mm	NA	-1	+1	NA
Diameter		mm	NA	-25	25	NA
Length		NA	NA	NA	NA	NA
Number of Splices		nº	NA	NA	2	NA

2) Accessory Characteristics

Characteristic		Unit of Measurement	Specification			Reference
			Nominal	Minimum	Maximum	
Porosity Gurley		s/100 cc	NA	NA	NA	TAPPI T460-02
Roughness Bendtsen	Felt	mL/min	180	130	230	ISO 8791-2:1990
	Wire	mL/min	190	140	240	ISO 8791-2:1990
Formation Index - MK		nº	28	18	NA	--
Dennison Wax	Felt	nº	18	16	NA	TAPPI T459 om-93
	Wire	nº	18	16	NA	TAPPI T459 om-93
Stiffness	MD	gf.cm	NA	NA	NA	ISO 2493-1992
	CD	gf.cm	NA	NA	NA	ISO 2493-1992
Tensile Strength	MD	kN/m	5.7	5.1	NA	ISO 1924/2-1994
	CD	kN/m	2.8	2.2	NA	ISO 1924/2-1994
Tearing Strength	MD	mN	575	495	NA	ISO 1974-1990
	CD	mN	625	545	NA	ISO 1974-1990
% of Splices		nº	85	70	NA	NA

COMPLETE REVISION OF DOCUMENT

Written by: José Alexandre Teixeira Piován	Confidentiality To be shared with interested parts	Approved by: Suzana Yuri Kaneco
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3) Observation:

- NA = Not Applicable
- Room conditioning for physical testing: Temperature: 23°C Relative Moisture: 50%

4) Additional inspection characteristics:

The product must be free of: Wrinkles, uneven surface starch application, moisture welts, creases, edge cracks, spots, holes, dusting, calander marks, crushs, shade variation, uneven roll hardness, uneven edge, telescoped roll, out of round roll, loose core and offset core, in accordance to ME.06.03.079

4.1. Number of splices in one order should be in accordance to the following criteria:

Without Splice - Minimum	70%
With 1 Splice - Maximum	20%
With 2 Splices - Maximum	10%

Curl:

Characteristic			Unit of Measurement	Specification			Test Method
				Nominal	Minimum	Maximum	
Curl Initial	WSMD	(2)	mm	NA	NA	10	ME.06.03.051
	WSCD	(2)	mm	NA	NA	10	ME.06.03.051
	FSMD	(2)	mm	NA	NA	10	ME.06.03.051
	FSCD	(2)	mm	NA	NA	10	ME.06.03.051
Simplex Curl - Wire Side	WSMD		mm	NA	NA	30	ME.06.03.051
	WSCD		mm	NA	NA	15	ME.06.03.051
	FSMD		mm	NA	NA	0	ME.06.03.051
	FSCD		mm	NA	NA	0	ME.06.03.051
Simplex Curl - Felt Side	WSMD		mm	NA	NA	10	ME.06.03.051
	WSCD		mm	NA	NA	5	ME.06.03.051
	FSMD		mm	NA	NA	25	ME.06.03.051
	FSCD		mm	NA	NA	10	ME.06.03.051
Duplex Curl	WSMD		mm	NA	NA	0	ME.06.03.051
	WSCD		mm	NA	NA	0	ME.06.03.051
	FSMD		mm	NA	NA	20	ME.06.03.051
	FSCD		mm	NA	NA	15	ME.06.03.051
Reactivity (1)			mm	NA	NA	25	ME.06.03.051
Center Point			mm	NA	-2.0	3.5	ME.06.03.051

Observation:

- (1) For individual test, maximum 18 mm.
- (2) WSMD: "Wire Side Machine Direction"
WSCD: "Wire Side Cross Direction"
FSMD: "Felt Side Machine Direction"
FSCD: "Felt Side Cross Direction"

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