



# CORRUGATE PLASTIC BOARDS

STANDARD PRODUCTS AND TOLERANCE

## Standard Thickness and Weight of Polypropylene (PP)

Thickness	2 mm	3 mm	4 mm	5 mm	6 mm	7 mm	8 mm	10 mm	13 mm	16 mm	19 mm	25 mm
Unit Weight in g/m <sup>2</sup>	490	600	750	1,000	1,400	1,700	1,800	2,000	2,690	3,300	4,000	4,800
Unit Weight in lbs/msf	100	123	154	205	287	348	369	410	550	680	820	984

## Tolerance of Corrugate Products

(a) Width:

Mill-Run IntePro:  $\pm 1/8"$

Square-Cut IntePro:  $\pm 1/16"$

(b) Length variation is listed in the following table.

Length	Mill-Run	Square-Cut
0" to < 48"	0" to +3/4"	-1/16" to +1/8"
48" to < 96"	0" to +1 1/2"	-1/8" to +1/4"
$\geq 96"$	0" to $(1\ 1/2" + 1/4" \times N^*)$	$\pm 1/4"$

Note:  $N = (\text{Length of IntePro in inches} - 96") / 24"$

(c) Thickness:  $\pm 5\%$

(d) Unit Weight:  $\pm 5\%$

(e) Surface Treatment (ASTM D2578): > 46 dyne/cm (2 to 8 mm in thickness)

>42 dyne/cm (10 to 13 mm in thickness)

>40 dyne/cm (16 to 25 mm in thickness)

(f) Square Tolerance is the difference of the two diagonals of Corrugate board.

Length	Mill-Run	Square-Cut
0" to < 48"	0" to +3/8"	<1/16"
48" to < 96"	3/4"	<1/8"
$\geq 96"$	< $(3/4" + 1/4" \times N^*)$	<1/4"

Note:  $N = (\text{Length of IntePro in inches} - 96") / 24"$

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(g) Straightness: Corrugate Plastic Boards may slightly curve in along flute direction. The straightness is related to the ratio of length and width of IntePro board. The more slender the board is, the more obvious the curve is. The straightness can be obtained from measuring the maximum gap between a straight edge and an IntePro board when the two corners of IntePro board touch the straight edge. The tolerance of straightness of mill-run Corrugate Plastic Boards is listed in the following two tables.

Length of Corrugate Plastic Boards are < 96"

Ratio of Length to Width	0 to <3	$\geq 3$
Straightness Tolerance	< 1/8"	< 3/16"

Length of Corrugate Plastic Boards are  $\geq 96$ "

Ratio of Length to Width	0 to <3	3 to <4	$\geq 4$
Straightness Tolerance	< (3/16" + 1/16" x N*)	< (3/16" + 1/16" x N*)	< (1/4" + 1/16" x N*)

Note: N = (Length of IntePro in inches - 96") / 24"

(h) Warp is the height of the "hump" when an IntePro board is laid on a flat surface. The warp tolerance can be found out from the following table.

Length of Corrugate Plastic Boards are < 96"

Width	0" to <24"	24" to <48"	48" to <60"	$\geq 60$ "
Warp Tolerance	< 1/4"	< 1/2"	< 1"	< 1 1/4"

Length of Corrugate Plastic Boards are  $\geq 96$ "

Width	0" to <24"	24" to <48"	48" to <60"	$\geq 60$ "
Warp Tolerance	< (3/8" + 1/8" x N*)	< (3/4" + 1/4" x N*)	< (1 1/4" + 1/4" x N*)	< (1 1/2" + 1/4" x N*)

Note: N = (Length of IntePro in inches - 96") / 24"

(i) Shipment on Piece Count: - 0%, + 5% of order piece quantity

Note: The information is based on our current knowledge and is subjected to change without notice.