

EXTRUSION COATING MANUFACTURING PARAMETERS

Film Weight:	to ¾ mil----- +/- 1#/3msf above ¾ mil ----- +/- 10% of nominal weight
Post-Treatment:	As per customers' specification, 42 dynes if not otherwise specified. Up to 46 dynes for treated matte surface. Up to 44 dynes for treated gloss surface.
Pinholes:	Pinhole free with film weights above 10.8#
Poly Bond:	Tight above .5 mil; minimum bond 450g
Roll Width:	+/-1/16 th inch
Roll Diameter:	+/- 2"
Splices:	Maximum two (2) splices per roll. None closer than 1" from outside of roll or core. Splices made with blue repulpable tape: Brown kraft, red, or others on request. Clearly identified on both roll sides (except for Cup Stock unless requested)
Lineal Footage:	+/- .5% per order
Roll Condition:	No sticking or blocking when unwinding rolls
Wrapping:	Crossett, AR: Poly body wrap with corrugated headers St Marys, GA: Poly wrap cocoon style

EXTRUSION COATING PROCESS CAPABILITIES

Poly One Side:	Minimum ----- 5#/3msf Maximum -----30#/3msf One pass; applied to either side of the board.
Poly Two Sides:	Minimum ----- 5#/3msf Maximum -----30#/3msf On each side
Available Finishes:	Gloss or Matte <i>Treated gloss finish is not recommended on the backside of clay-coated board due to potential COF (friction/sticking) issues</i>
Extruder Deckles: (incoming base stock width)	St. Marys #1: ----- 28" to 48" St. Marys #2: ----- 70" to 110" Crossett #8: ----- 40" to 85" Crossett #9: ----- 70" to 112"
Extruder Edge Trims:	Minimum: Crossett - ¾" -----St. Marys - ½" Maximum: ----- 4"
Substrates:	1.5 oz. Spun bonded polyolefin up to 45pt. board Crossett 40 pt max caliper.
Unwind Diameter:	Minimum ----- 30" Maximum ----- 72"
Slit Width:	Minimum----- 1 13/16" Maximum----- 112" Rolls with a diameter more then 4 times their width must be bundled. Some widths require rewinding.
Cores:	3", 4", 5", 6", 8", 10", 12"
Minimum Order Quantity:	Truckload quantities, minimum 10 tons per deckle

These are our normal product specifications. Changes to any of these must be accepted by us in writing and noted when each order is placed.

Our Extrusion facilities are located at St. Marys, Georgia and Crossett, Arkansas