



KAPSTONE
PAPER AND PACKAGING CORPORATION

Mill Specifications – Linerboard Grades
March 18, 2011

GRADE	26	31 HP	33	35 HP	38	42
--------------	-----------	--------------	-----------	--------------	-----------	-----------

BASIS WEIGHT

	Max.	27.3	32.5	34.7	36.7	39.9	44.1
	Target	26.0	31.0	33.0	35.0	38.0	42.0
	Min.	24.7	29.5	31.4	33.3	36.1	39.9

MULLEN (T-403)

	Target	60		80		90	100
	Reject	<51		<72		<84	<95

STFI

	Target		> 17.3		> 19.2		
	Reject		<16.3		< 18.6		

SMOOTHNESS (Emveco)

	Target	< 200	< 200	< 200	< 200	< 200	< 200
	Reject	>250	>250	>250	>250	>250	>250

ZDT (Plybond)

	Target	>70	>70	>70	>70	>70	>70
	Reject	<60	<60	<60	<60	<60	<60

2 MIN. COBB Top/Bot. (T-441) –

OVEN CURED	Target	50/60	50/50	50/60	50/50	50/60	50/60
	Reject	>85	>85	>85	>85	>85	>85

30 MIN. COBB Top/Bot.(T-441)

	Target		115/115		115/115		
	Reject		>140		>140		

SLIDE ANGLE (T-503)

	Target	24-26	24-26	24-26	24-26	24-26	24-26
	Reject	<23	<23	<23	<23	<23	<23

MOISTURE AVERAGE

	Max.	8.75	8.75	8.75	8.50	8.75	8.75
	Target	7.75	7.50	7.75	7.50	7.75	7.75
	Reject	6.75	6.75	6.75	6.50	6.75	6.75

MOISTURE VARIATION: ALL GRADES

Target 2-sigma < 1.5

Reject 2-sigma > 2.5

ROLL HARDNESS measured w/ a Schmidt Hammer

Reject if <30 hardness or if total roll variation is >10

CORE LENGTH

Cores will not be recessed inside the roll on either end. Cores will not protrude more than 1/8" outside the roll on either end.

** Approved By:

Joe Gasperetti

Bobby O'Neal

Michael McLean