

THE FOLLOWING DATA REFER TO TWILL IVORY, CHAMOIS, NUDE, PEBBLE, RED AND GREY

| | METHOD | | +/- | 100 g/m ² | 120 g/m ² | 170 g/m ² | 200 g/m ² | 240 g/m ² | 300 g/m ² | 360 g/m ² | 400 g/m ² |
|------------------|----------|--------------------|-----|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|----------------------|
| BASIC WEIGHT | ISO 536 | g/m ² | 5% | 100 | 120 | 170 | 200 | 240 | 300 | 360 | 400 |
| CALIPER | ISO 534 | µm | 5% | 155 | 186 | 255 | 300 | 348 | 435 | 522 | 570 |
| BULK | ISO 534 | cm ² /g | - | 1,55 | 1,55 | 1,5 | 1,50 | 1,45 | 1,45 | 1,45 | 1,43 |
| OPACITY | ISO 2471 | % | > | 89 | - | - | - | - | - | - | - |
| STIFFNESS L/T | ISO 2493 | mN MD/CD | > | 80/35 (15°/15) | 140/60 (15°/15) | 40/20 (15°/50) | 80/35 (15°/50) | 110/50 (15°/50) | 240/110 (15°/50) | 380/170 (15°/50) | 550/240 (15°/50) |
| MOISTURE CONTENT | ISO 287 | % | 1,0 | 6,5 | 6,5 | 6,5 | 6,5 | 6,5 | 6,5 | 6,5 | 6,5 |

Special makings are available upon request.



Twill conforms to ISO 9706 requirements for permanence and is suitable for archival use or applications requiring "Acid Free" paper. It is fully biodegradable and recyclable.

THE FOLLOWING DATA REFER TO TWILL INDIGO AND BLACK

| | METHOD | | +/- | 120 g/m ² | 240 g/m ² | 360 g/m ² |
|------------------|----------|--------------------|-----|----------------------|----------------------|----------------------|
| BASIC WEIGHT | ISO 536 | g/m ² | 5% | 120 | 240 | 360 |
| CALIPER | ISO 534 | µm | 5% | 198 | 360 | 530 |
| BULK | ISO 534 | cm ² /g | - | 1,60 | 1,50 | 1,47 |
| STIFFNESS L/T | ISO 2493 | mN MD/CD | > | 160/70 (15°/15) | 150/60 (15°/50) | 480/200 (15°/50) |
| MOISTURE CONTENT | ISO 287 | % | 1,0 | 6,5 | 6,5 | 6,5 |

Special makings are available upon request.



PRINTING AND FINISHING RECCOMENDATIONS

- INKS** ■ To ensure good drying, Twill papers should be printed with oxidizing inks, preferably new and undiluted. The drying process can be slightly accelerated by adding extra desiccant.
- BLANKETS** ■ For a good graphic impression, use compressible blankets.
- SCREENS** ■ For the offset printing process a screen value of 150-163 lpi is recommended. For heavier graphic elements and higher densities, sufficient powder should be applied.
- DRYING TIME** ■ Make small sheet pallets and allow at least 24 hours drying time after printing.
- FINISHING** ■ Prescoring is recommended for board weights and when folding against the grain direction.
- PRINTABILITY AND RUNNABILITY** ■ Every method of printing, embossing, punching, die cutting, creasing, laminating and UV varnishing is possible.
- NOTE** ■ Due to its hygroscopic nature, paper can show curl issues if not conditioned properly. To avoid any issue, we recommend to store the paper closed in its original wrap inside the printing area for at least 24-48 hours. After this conditioning time, the wrapping can be open and the paper can be utilized.

> Please contact our technical department for further suggestions.

MILL ACCREDITATION | Rossano Veneto VI - Italy

CORPORATE QUALITY MANAGEMENT STANDARD | UNI EN ISO 9001

ENVIRONMENTAL MANAGEMENT STANDARD | UNI EN ISO 14001

OCCUPATIONAL HEALTH AND SAFETY MANAGEMENT STANDARD | UNI EN ISO 45001

ECO-MANAGEMENT AND AUDIT SCHEME CE 1221/2009 | EMAS

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