

## Info sheet of M-real Äänekoski

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### Äänekoski Board

#### 1. Production and machine information

Capacity of board machine 210 000 tonnes

Trim width: 3620 mm

#### 2. Reel sizes

Width 500<sup>(\*)</sup> - 2200 mm ( 0...+2 mm )  
Diameter 1500, 1800 mm  
Core diameter 306, 153 mm, (or 102 only for liner)  
Recommendation: Grammage  $\geq 210$  g/m<sup>2</sup> → Core 306 mm  
Weight max 5000 kg

\* If diameter 1800 mm, reels widths less than 600 mm are packed two reels together due to safety factor on reel packing line.

#### 3. Sheet and pallet sizes

Sheet width 300 - 1600 mm ( 0...+ 0,2 % )  
Sheet length 400 - 1600 mm ( 0...+ 0,3 % )  
Sheet squareness  $\pm 1$  mm, max

Pallet size min 500 x 500 mm max 1600 x 1600 mm

Pallet height 700 - 1800 mm, including pallet  
Pallet weight max 1500 kg

Sheet number tolerance  $\pm 1\%$

(Separate information concerning Express Board Baj-Pros)

#### 4. Quantity tolerances

	<b>Permitted deviation</b>
< 3 tonnes	+/- 15 %
< 5 tonnes	+/- 10 %
< 10 tonnes	+/- 5 %
< 50 tonnes	+/- 4 %
$\geq 50$ tonnes	+/- 2 %

## 5. Packing

### 5.1 Reels

Wrapping and covers	Until December 2011	From December 2011 onwards
Wrapping	Kraft paper 100 - 125 g/m <sup>2</sup> and testliner 100 - 125 g/m <sup>2</sup> , laminated together with extruded polyethylene (LDPE) 25 g/m <sup>2</sup> .	PE stretch plastic wrapping.
End cover	Inner end cover: corrugated board 450 g/m <sup>2</sup> .  Outer end cover: kraft paper 200 g/m <sup>2</sup> coated with LDPE 25 g/m <sup>2</sup> .	Corrugated board 720 g/m <sup>2</sup> including extruded polyethylene (LDPE) 20 g/m <sup>2</sup> .

#### Labels

Two labels on the wrapping. Both labels contain the information shown in appendix 1.

All packing materials are recyclable.

### 5.2 Sheets

#### Wrapping

Pallets are wrapped by plastic shrink-wrap, stretch film or curtain wrap, according to the packaging line of the sheeting plant.

#### Pallets

Standard pallet is wooden non-stop pallet, short side free. Other pallet types on request. No wooden topboards. All pallets are heat treated and marked according to the ISPM 15 standard.

#### Labels

Two labels on adjacent sides. Both labels contain the information shown in appendix 2.


## 6. Management systems

### 6.1 Management systems

Äänekoski Board	Certified	System in use
ISO 9001	X (25.3.1994)	
ISO 14001	X (31.5.2001)	
OHSAS 18001	X (1.6.2011)	
ISO 22000	X (31.1.2008)	
PEFC Chain of Custody	X (4.12.2000)	
PEFC logo licence PEFC/02-31-92	X (27.1.2006)	
FSC Chain of Custody	X (16.11.2007)	

APPENDIX 1.

ÄÄNEKOSKI REEL LABEL

m·real		Äänekoski Board	
1. Sales grade			
2. Sales order			
3. Shipping mark 1 / Cust. Art			
4. Shipping mark 2			
5. Shipping mark 3			
6. Shipping mark 4			
7. Customer reference number			
Production order		No.	Gross
37. - 40. Production order number		9. Reel number	12. Weight
Code		Net	
10. - 11. Machine reel and set position number		13. Weight	
Size		Sheets/length	
14. Reel width		15. Reel length	
g/m <sup>2</sup>		Micron	
16. Grammage		17. Thickness	
Package ID		22. Customer name (short)	
45. SAP unit		44. Customer bar code	
24. Unwinding direction (arrow)		Codes available	
25. In/Out		Code 39	
43. Double reel packing warning (reel symbol)		Code 128	
19. -20. Heavy load warning		Other codes need to be checked with mill	
18. UIC-code		41. Customer bar code	
		 <small>PEFC/02-31-92</small>	
		21. Max clamp pressure	

APPENDIX 2.

ÄÄNEKOSKI SHEET LABEL

m·real		Äänekoski Board	
1. Sales grade			
2. Sales order			
3. Shipping mark 1 / Cust. Art			
4. Shipping mark 2			
5. Shipping mark 3			
6. Shipping mark 4			
7. Customer reference number			
Production order		No.	Gross
37. - 40. Production order number		9. Pallet number	12. Weight
Code		Net	
10. - 11. Machine reel and set position number		13. Weight	
Size		Sheets/length	
14. Width x Length		15. Sheet no.	
26. Packing date			
g/m <sup>2</sup>	Micron	22. Customer name (short)	
16. Grammage	17. Thickness		
Package ID		44. Customer bar code	
45. SAP unit		Codes available Code 39 Code 128	
24.	25. In/Out	Other codes need to be checked with mill	
43.		41. Customer bar code	
19. -20.		18. UIC-code	
		21.	

