



Wipex FSW

General purpose disposable wiper composed of paper and emulsion.

2.0 Physical Requirements:

		<u>Limits</u>
2.1	<u>White</u>	White with no off colors or shading
2.2	<u>Printed Material</u>	No off colors; defect free within standard Some minor streaking and infrequent "lacing"
2.3	<u>Odor</u>	No objectionable odor detectable wet or dry
2.4	<u>Appearance</u>	Color and formation uniform Contamination and damage free
2.5	<u>Hard Wrinkles</u>	No hard wrinkles wider than 0.25" (6.35 mm)
2.6	<u>Delamination</u>	No delamination as defined by a sheet that readily separates into layers when rubbed between the thumb and forefinger.
2.7	<u>Roll Width</u>	
2.7.1	<u>Trim Width</u>	Must sum up to 95" (242 cm) or 102" (259 cm).
2.7.2	<u>Minimum Roll Width</u>	Minimum roll width is 9" (23 cm)
2.7.3	<u>Maximum # of Rolls per Reel</u>	The maximum number of slit rolls per reel is eight (8).
2.7.4	<u>Tolerance</u>	+/- 0.125" (3.2 mm) on each individual roll
2.8	<u>Roll Diameter</u> (requested maximum diameter)	
2.8.1	<u>Domestic</u>	Minimum 48" (122 cm), Maximum 75" (191 cm)
2.8.2	<u>Export</u>	Minimum 47" (120 cm), Maximum 51" (130 cm)
2.8.3	<u>Tolerance</u>	Requested maximum, +0.0", -5.0" (+0.0 cm, -13.0 cm)
2.9	<u>Core</u> (inside diameter)	10" (25.4 cm)
2.10	<u>Core Condition</u>	No crushed or damaged cores +/- 0.5" (1.3 cm) alignment
2.11	<u>Roll Condition</u>	
2.11.1	<u>Sidewind</u>	+/- 1.0" (2.54 cm)
2.11.2	<u>Edges</u>	Edges must be neat and clean with no ragged cuts.
2.11.3	<u>Caliper at Core and Marked Breaks</u>	DRC may lose caliper at marked breaks and near the core of the parent roll. This caliper loss should be limited to no more than 3 mils (77 micrometers). Visual



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2.12 Roll Breaks

- a. DRC parent rolls do not have splices, they have marked breaks.
- b. No rolls to have more than 2 breaks
- c. Not more than 10% per shipment with 2 breaks
- d. Each break to be dressed and marked with visible color tape
- e. Number of breaks to be recorded on the roll tag

2.13 Testing Frequency

All physical parameters to be tested at the beginning of each parent roll of base paper. All physical property tests are performed under standard laboratory conditions.

2.14 Physical Properties

		Target	Minimum	Maximum	++
2.14.1	<u>Weight (gsm)**</u>	76.5	74.0	79.0	
2.14.2	<u>Caliper (micrometers, 1 ply)</u>	400	350	470	
2.14.3	<u>Tensile Dry MD (g/cm)</u>	1250	--	--	
2.14.4	<u>Tensile Dry CD (g/cm)</u>	850	700	--	
2.14.5	<u>Tensile Wet CD (g/cm)</u>	650	550	--	
2.14.6	<u>MD Stretch (%)</u>	20.0	--	--	

** Weight is based on a ream equal to 500 sheets measuring 2'x3' or 3000 sq. feet.

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3.0 Packaging

Roll Packages to be fully wrapped with cardboard header on top and bottom

4.0 Roll Identification

Each roll to have a unique identification number traceable back to its production.

5.0 Non-Conformance Policy

5.1 Process Control

The production process is managed to run to target. Individual tests (rolls) that fall within the minimum or maximum range are considered to be conforming to the specifications.

*Note this is a provisional specification, to be replaced by revision 1 by 12/31/2012