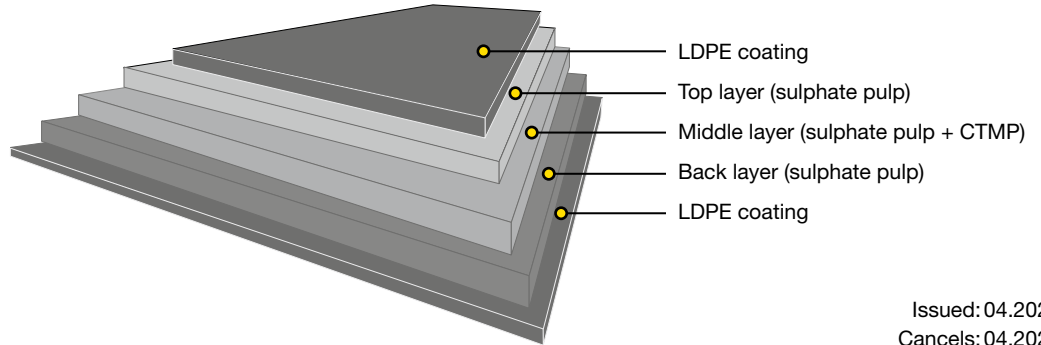


Cupforma Natura™ 2PE

Bleached cup board with PE coating

Cupforma Natura 2PE is a virgin-fibre bleached board with a three layer fibre construction and with CTMP (chemi-thermomechanical pulp) in the middle layer and LDPE coating on both sides.



Issued: 04.2023
Cancels: 04.2020

Technical specification

Polymer coated board:	Tolerance	12+170+15	12+184+15	12+195+15	12+214+15	12+232+15	12+260+15	12+295+15	12+330+15	Standard
Grammage, g/m ²	±5%	197	211	222	241	259	287	322	357	ISO 536
LDPE topside, g/m ²	±2	12	12	12	12	12	12	12	12	Mill method
LDPE reverse, g/m ²	±2	15	15	15	15	15	15	15	15	
Thickness, µm	±6%	235	270	295	320	350	390	430	470	ISO 534
Corona treating, dyne/cm, top *)	min 39	42	42	42	42	42	42	42	42	ASTM D 2578
Baseboard:										
Grammage, g/m ²	±4%	170	184	195	214	232	260	295	330	ISO 536
Thickness, µm	±5%	215	250	275	300	330	370	410	450	ISO 534
Bending resistance L&W 15° MD, mN	min -25%	65	105	130	160	215	290	380	500	ISO 2493-1
Bending resistance L&W 15° CD, mN	min -25%	28	43	55	75	95	130	170	230	
Moisture %	min 7.0%	9.0	8.0	8.0	8.0	8.0	8.0	8.0	8.0	ISO 287
Brightness D65/10, %, Top	min 80	84	84	84	84	84	84	84	84	ISO 2470-2
Surface Smoothness, Bendtsen, ml/min	max 400	150	200	250	250	300	300	300	300	ISO 8791-2
Stretch CD, %	min 4.5%	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	ISO 1924-3

*) Measured right after PE coating



Cupforma Natura™ 2PE

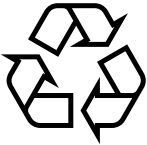
Bleached cup board with PE coating

Certificates

- Quality management ISO 9001
- Environmental management ISO 14001
- Product safety FSSC 22000
- Occupational health and safety ISO 45001
- Energy management ISO 50001



FSC and PEFC certified board available upon request.



Paperboard can be recycled

Key characteristics and main enduses

Cupforma Natura 2PE is a sustainable choice; a high-quality carton board designed especially for cups. It is food-safe, ecological, and works smoothly and consistently in cup converting. It is also economical as the board's structure provides the required stiffness; resulting in light, yet functional cups. Cupforma Natura delivers excellent results in flexographic, offset, and digital printing. Combined with LDPE coating on both sides, Cupforma Natura is sealed easily into a cup, and used for cold drinks, soups, chilled foods, and ice cream.

Printing and finishing techniques

The product can be used for different printing techniques such as offset, flexo and digital printing. It is important to check possible limitations of the printing and converting equipment and ensure that the basis weight of the board fits the tooling to be used. Since a wide variety of digital printing equipment is available in the market, it is important that a new commercial digital print job is always preceded by a trial run, including all required printing and converting process phases.

Storage recommendations

For optimal printing results, the moisture proof wrapping should not be removed until the board has reached the temperature of the press room.

Pallet/Reel Weight (kg)	Difference in temperature between board and press room (press room temp. approx. 20°C)		
	10°C	20°C	30°C
400 kg	2 days	2 days	3 days
800 kg	2 days	3 days	4 days
1200 kg	2 days	4 days	5 days

The product properties, according to the specifications, are guaranteed for 12 months after the production date. In order to ensure product safety, the product must be well wrapped and stored indoors, sheltered from rain and snow. The recommended storage conditions are 50-55% relative humidity and 20-23° C.

For the Corona treatment, we recommend using the board within 12 months of the production date; after this period, the treatment level should be tested before printing or gluing.