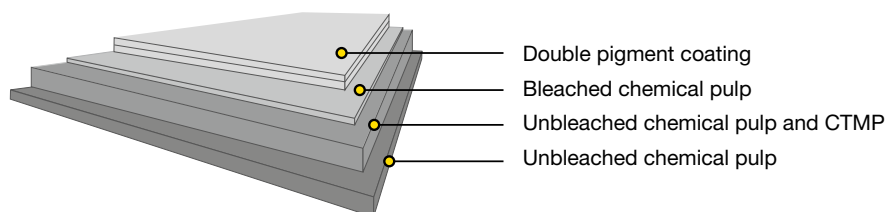


Multilayer kraft back board

CKB is a fully pigment coated multilayer kraft back board with a bleached chemical pulp layer on the top side and other layers made of CTMP and unbleached chemical pulp. The board has a double pigment coating on the top side. The top side is white and the reverse side is brown.



Issued: 03.2025
Cancels: 01.2024

Technical specification

| Property / Unit | Tolerance | | | | | | | | | | | Standard |
|---|-----------|--|------|------|------|------|------|------|------|-------|-------|------------|
| Grammage, g/m ² | ±4% | 195 | 220 | 235 | 255 | 270 | 290 | 315 | 350 | 380 | 415 | ISO 536 |
| Thickness, µm | ±5% | 300 | 360 | 400 | 435 | 450 | 490 | 540 | 600 | 665 | 710 * | ISO 534 |
| Caliper, pt | | 11.8 | 14.2 | 15.7 | 17.1 | 17.7 | 19.3 | 21.3 | 23.6 | 26.2 | 28.0 | |
| Bending moment Taber 15° MD, mNm | -15% | 7.8 | 12.0 | 15.3 | 20.2 | 24.0 | 29.5 | 37.4 | 46.9 | 56.4 | 77.0 | TAPPI 489 |
| Bending moment Taber 15° CD, mNm | -15% | 3.7 | 5.7 | 7.3 | 9.6 | 10.0 | 12.8 | 16.2 | 20.4 | 24.5 | 31.0 | |
| Bending resistance L&W 15° MD, mN | -15% | 160 | 250 | 319 | 416 | 495 | 611 | 775 | 971 | 1168 | 1585 | ISO 2493 |
| Bending resistance L&W 15° CD, mN | -15% | 76 | 119 | 152 | 198 | 210 | 266 | 336 | 422 | 508 | 635 | |
| Bending stiffness DIN 5° MD, mNm | | 14.0 | 22.0 | 28.0 | 38.0 | 43.0 | 56.0 | 71.0 | 96.0 | 109.0 | 163.0 | DIN 53121 |
| Bending stiffness DIN 5° CD, mNm | | 7.0 | 10.0 | 14.0 | 18.0 | 19.0 | 24.0 | 31.0 | 40.0 | 47.0 | 65.0 | |
| Moisture, % | ±1 | 7.0 | 7.0 | 7.5 | 7.5 | 7.5 | 8.0 | 8.5 | 9.0 | 9.5 | 9.5 | ISO 287 |
| ISO Brightness C/2, %, Top | min. 78 | 80 | 80 | 80 | 80 | 80 | 80 | 80 | 80 | 80 | 80 | ISO 2470-1 |
| Surface Smoothness, PPS 10, µm, Top | max. 2.5 | 1.5 | 1.5 | 1.5 | 1.5 | 1.5 | 1.5 | 1.5 | 1.5 | 1.5 | 1.5 | ISO 8791-4 |
| Surface Smoothness, Bendtsen, ml/min, Reverse | max. 2000 | 1000 | 1000 | 1000 | 1000 | 1000 | 1000 | 1000 | 1000 | 1000 | 1000 | ISO 8791-2 |
| Gloss 75°, % | | 35 | 35 | 35 | 35 | 30 | 30 | 30 | 30 | 30 | 30 | ISO 8254-1 |
| Scott Bond, J/m ² | min. 100 | 175 | 175 | 175 | 175 | 175 | 175 | 175 | 175 | 175 | 175 | TAPPI 569 |
| Edge wicking, kg/m ² | max. 1.0 | 0.5 | 0.5 | 0.5 | 0.5 | 0.5 | 0.5 | 0.5 | 0.5 | 0.5 | 0.5 | |
| Tearing resistance GM, mN | | 2400 | 3000 | 3300 | 3700 | 4150 | 4600 | 5100 | 5700 | 6400 | 6500 | ISO 1974 |
| Cobb 60, g/m ² , Top | | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | ISO 535 |
| Cobb 60, g/m ² , Reverse | | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | 30 | |
| Robinson chocolate test | | < 1 for one year storage in reels/pallet | | | | | | | | | | EN1230-2 |

Produced with RaZoR concept.
*) +5%/-3.5% tolerance

All properties according to Skoghall Mill measurements from board machine production.
Laboratory test climate 23°C/50% RH (According to ISO 187).
Tolerances based upon 95% confidence limits, apply to delivered reel/pallet average.

Bending moment Taber 15° and Bending resistance L&W 15° are binding, Bending stiffness DIN 5° are indicative.
Bending moment Taber 15° calculated from Bending resistance L&W 15°.
Wet tearing resistance is typically 25-30% of dry tearing resistance, except for wet strength (WS) qualities, where the wet tearing resistance is 60% of dry tearing resistance.

Following qualities can be ordered with or without WS: CKB 235 g/m², 315 g/m² and 350 g/m². Following qualities are only produced with WS: 380 g/m² and 415 g/m².

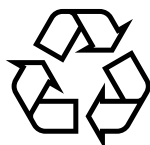
Multilayer kraft back board

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

CKB is all about strong character, strong brands and strong messages. It is an ideal packaging material for folding cartons for dry, chilled and frozen food, chocolate, wine and spirits. CKB also makes great multipacks – the eye-catching pack is light and strong and easy to buy, carry, open and recycle. The material's exceptional stiffness and strength, combined with great runnability and printing quality, make CKB a world-class choice for a wide range of applications. One of the most important reasons to choose CKB, however, is its proven food safety.

Printing and finishing techniques

The product can be used with different printing techniques such as offset, flexo and digital printing. In digital printing, the product is suitable for several different sheet- or web-fed presses. Inkjet, dry or liquid toner technology can be used, although in some cases, pretreatment of the substrate might be required. The latest certification status can be verified on the press manufacturer's website or with local Stora Enso representatives. It is important to check the limitations of the equipment, particularly because of the exceptional difference in the thickness and stiffness of board compared with paper in the same grammages. When running thicker substrates, the press manufacturer's recommendations should be referred to for optimal grain direction. Essentially all of the same finishing processes apply to both digitally printed and offset printed work. Since a wide variety of digital printing equipment is available in the market, it is important that a new commercial print job is always preceded by a trial run, including all required printing and converting process phases. The product works very well with different finishing techniques, such as embossing, hot foil stamping and others. It is suitable for laser coding and ink jet marking. Certificates according to PTS-DF 105/2019 and PTS-DF 103/2022 are available upon request.

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.