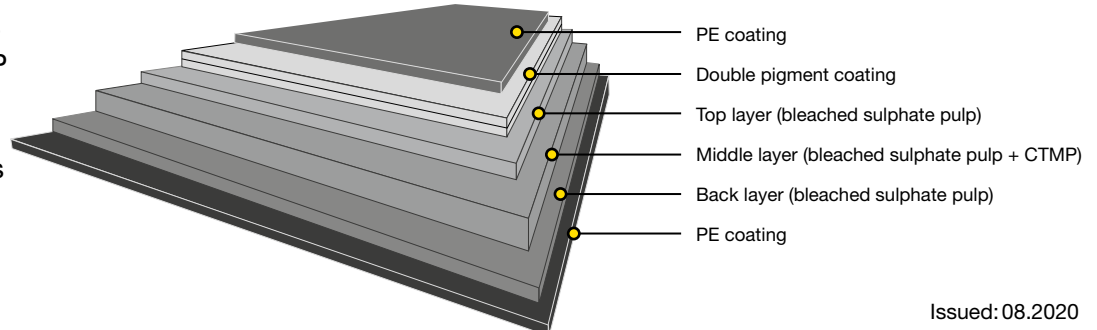


# Cupforma Special™ 2PE

## Pigment coated cup board

Cupforma Special 2PE is a board with a three layer fibre construction including CTMP (chemi-thermomechanical pulp) in the middle layer and a fully coated top side. It has a PE coating on both sides.



Issued: 08.2020  
Cancels: 08.2017

### Technical specification

Typical properties, US	Tolerance									Method
		2.5+38.9+3.1	2.5+43.0+3.1	2.5+47.1+3.1	2.5+52.2+3.1	2.5+55.3+3.1	2.5+60.4+3.1	2.5+65.5+3.1	2.5+71.7+3.1	
<b>Polymer coated board:</b>										
Nominal basis weight, lb/1000 sq. Ft.	±7%	45.5	48.5	52.6	57.8	60.8	65.9	71.1	77.2	
PE topside, lb/1000 sq. Ft.	±0.4	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	
PE reverse, lb/1000 sq. Ft.	±0.4	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	
Caliper, pts	±9%	10.9	11.7	13.3	14.5	16.1	17.6	19.2	20.8	
<b>Baseboard:</b>										
Nominal basis weight, lb/1000 sq. Ft.	±6%	39.9	43.0	47.1	52.2	55.3	60.4	65.5	71.7	
Caliper, pts	±8%	10.2	11.0	12.6	13.8	15.4	16.9	18.5	20.1	
<b>Typical properties, Metric</b>										
		12+195+15	12+210+15	12+230+15	12+255+15	12+270+15	12+295+15	12+320+15	12+350+15	
<b>Polymer coated board:</b>										
Nominal basis weight, g/m <sup>2</sup>	±7%	222	237	257	282	297	322	347	377	ISO 536
PE topside, g/m <sup>2</sup>	±2	12	12	12	12	12	12	12	12	Mill method
PE reverse, g/m <sup>2</sup>	±2	15	15	15	15	15	15	15	15	
Thickness, µm	±9%	278	298	338	368	408	448	488	528	ISO 534
Corona treating, dyne/cm, top *)	min 39	42	42	42	42	42	42	42	42	ASTM D 2578
<b>Baseboard:</b>										
Nominal basis weight, g/m <sup>2</sup>	±6%	195	210	230	255	270	295	320	350	ISO 536
Thickness, µm	±8%	260	280	320	350	390	430	470	510	ISO 534
Bending resistance L&W 15° MD, mN	min -20%	120	155	215	270	360	475	600	760	ISO 2493-1
Bending resistance L&W 15° CD, mN	min -20%	55	70	95	125	170	210	270	340	
Moisture %	min 5.0%	6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5	ISO 287
Brightness D65/10, Top		85	85	85	85	85	85	85	85	ISO 2470-2
Surface Smoothness, PPS 10, µm, Top	max 1.7	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	ISO 8791-4
Surface Smoothness, Bendtsen, ml/min	max 130	40	40	40	40	50	50	50	50	ISO 8791-2
Stretch CD, %		6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	ISO 1924-3

\*) Measured right after PE coating

All properties according to Imatra 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.



# Cupforma Special™ 2PE

Pigment coated cup board

## Certificates

Quality management ISO 9001  
 Environmental management ISO 14001  
 Product safety FSSC 22000  
 Product safety ISO 22000  
 Health and safety OHSAS 18001  
 Energy management ISO 50001



FSC and PEFC certified board available upon request.



Paperboard is recyclable

## Key characteristics and main enduses

Cupforma Special 2PE is a sustainable choice; a high-quality carton board specially designed for cups and for very high requirements on printing. 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. The fully pigment coated top side is very smooth, which ensures high-quality print results in flexographic, offset, and digital printing to showcase brands. Combined with PE coating, Cupforma Special is sealed easily into a cup and used for ice cream cups out-of-home and other packaging cups.

## 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. 68°F)		
	50°F	68°F	86°F
881 lbs	2 days	2 days	3 days
1763 lbs	2 days	3 days	4 days
2645 lbs	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 68-73.4°F.

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.