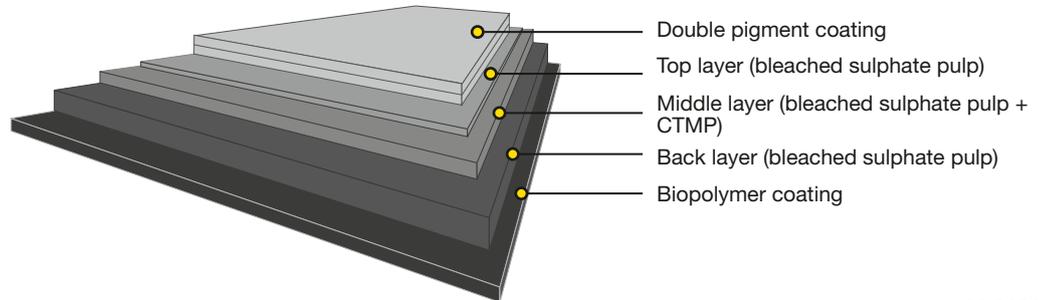


Cupforma Special™ Bio

Pigment coated cup board

Cupforma Special Bio 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 biopolymer coating on the reverse side.



Issued: 06.2020
Cancels: 06.2018

Technical specification

Property / Unit	Tolerance	195+25	210+25	230+25	255+25	270+25	295+25	320+25	350+25	Standards
Polymer coated board:										
Grammage, g/m ²	±7%	220	235	255	280	295	320	345	375	ISO 536
Bio reverse, g/m ²	±2	25	25	25	25	25	25	25	25	Mill method
Thickness, µm	±9%	280	300	340	370	410	450	490	530	ISO 534
Baseboard:										
Grammage, g/m ²	±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



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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 Bio 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 extremely high-quality printing results in flexographic, offset, and digital printing to showcase brands. Combined with Bio coating, Cupforma Special is sealed easily into a cup and used for ice cream cups and other packaging cups. This product is 100% compostable in industrial composting and can be collected together with food waste in most collecting schemes.

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.

