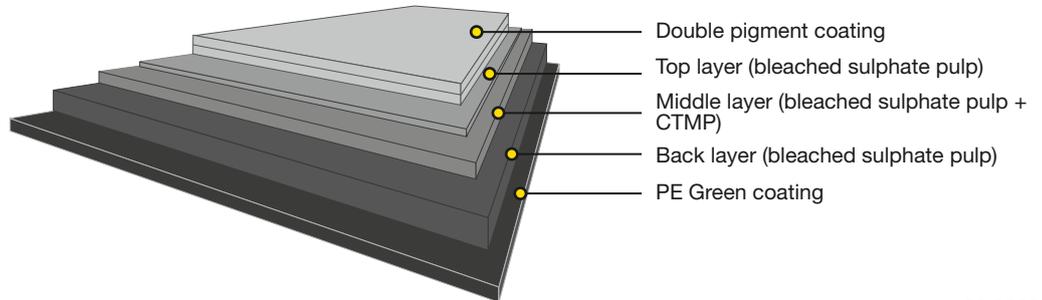


Cupforma Special™ PE Green

Pigment coated cup board with renewable coating

Cupforma Special PE Green 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 Green coating on the reverse side.



Issued: 06.2020
Cancels: 06.2018

Technical specification

| Property / Unit | Tolerance | 195+15 | 210+15 | 230+15 | 255+15 | 270+15 | 295+15 | 320+15 | 350+15 | Standards |
|--------------------------------------|-----------|--------|--------|--------|--------|--------|--------|--------|--------|-------------|
| Polymer coated board: | | | | | | | | | | |
| Grammage, g/m ² | ±7% | 210 | 225 | 245 | 270 | 285 | 310 | 335 | 365 | ISO 536 |
| PE Green reverse, g/m ² | ±2 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | 15 | Mill method |
| Thickness, µm | ±9% | 270 | 290 | 330 | 360 | 400 | 440 | 480 | 520 | 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 FSC 22000
Product safety ISO 22000
Occupational health and safety ISO 45001
Energy management ISO 50001



FSC and PEFC certified board available upon request.



Paperboard is recyclable

Key characteristics and main enduses

Cupforma Special PE Green 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. Cupforma Special PE Green is fully renewable cup board. Combined with PE Green coating, Cupforma Special is sealed easily into a cup and used for ice cream cups 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. 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.