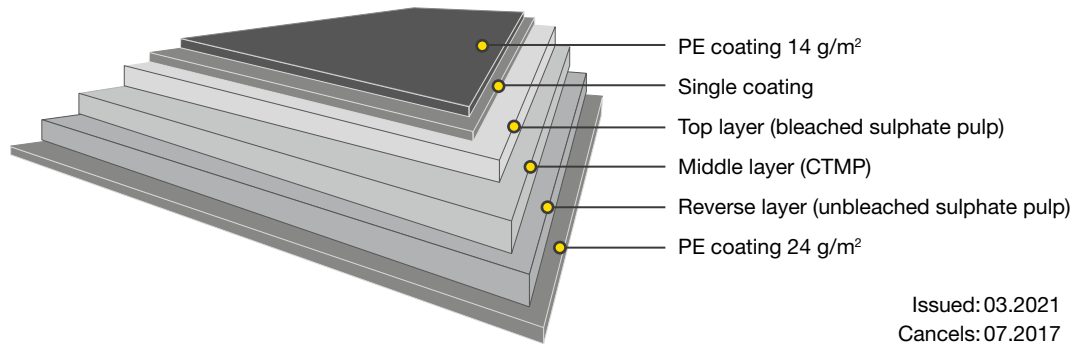


Natura™ Duo 2PE Board

Multilayer kraft back liquid packaging board

Natura Duo 2PE is a multilayer kraft-back liquid packaging board with a three-layer fibre construction, with the reverse layer made of unbleached sulphate pulp, the middle layer made of CTMP (chemi-thermomechanical pulp) and the top layer made of bleached sulphate pulp with a single layer of coating. Its top and reverse sides are PE coated.



Issued: 03.2021
Cancels: 07.2017

Specification from Skoghall Mill; Natura Duo 14PE+270+24PE (360mN)

Polymer coated board:	Min	Target	Max	Standard
Grammage, g/m ²	294	308	322	ISO 536
Thickness, µm	470	495	520	ISO 534
PE outside, g/m ²	12	14	16	Mill method 2.2.
PE Inside, g/m ²	22	24	26	Mill method 2.2.
Corona treating, dyn/cm *)	43	45	47	DIN 53364
Baseboard:				
Grammage, g/m ²	260	270	280	ISO 536
Bending resistance (L&W 15°) MD, mN	530	600	690	ISO 2493
Bending resistance (L&W 15°) CD, mN	178	216	256	
Bending resistance (L&W 15°) GM, mN		360		
Bending moment (Taber 15°) MD, mNm	25.6	29.0	33.3	ISO 2493
Bending moment (Taber 15°) CD, mNm	8.6	10.4	10.4	
Bending moment (Taber 15°) GM, mNm		17.4		
Scott Bond, J/m ²	170	220		Tappi 569
Moisture, %	5.2	6.5	7.8	ISO 287
Brightness (D65/10°) Top, %	76	78	80	ISO 2470-2
Colour L* (D65/10°) Top, %		92		ISO 5631-2
a* (D65/10°) Top, %		0.0		
b* (D65/10°) Top, %		2.2		
Roughness (Bendtsen) Top, ml/min		150	400	ISO 8791-2
Roughness (Bendtsen) Reverse, ml/min		1150		

*) Measured right after PE coating



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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 is recyclable

Key characteristics and main enduses

Natura Duo 2PE offers the best in product protection, in printing, converting and filling performance, and in economy and sustainability. Like all Stora Enso liquid packaging board qualities, it has an exceptionally high standard of odour and taint neutrality, which makes it especially suitable for packaging sensitive food products and keeping them fresh and hygienic, unchanged and untainted for their entire lifetime. The product range serves a wide array of packaging applications for dairy and juice products.

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.