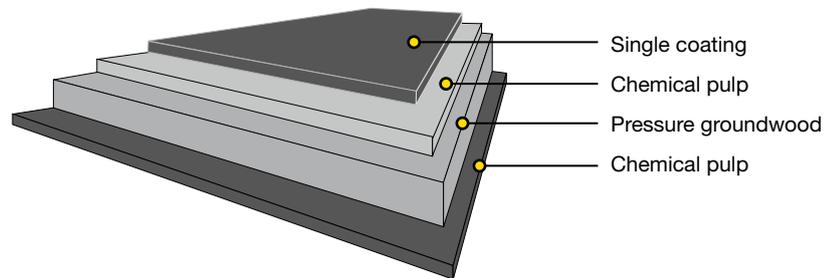


## Coated folding boxboard with cream uncoated reverse

Tamfold is a light coated GC2 board. The board has chemical pulp layers on both sides and pressure groundwood in the middle layer. The top is white and the reverse is cream. Tamfold is also available hard-sized (HS).



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### Technical specification

| Property/Unit                      | Tolerance         |  |      |      |      |      |      |      |      |      |      |      | Standards  |
|------------------------------------|-------------------|--|------|------|------|------|------|------|------|------|------|------|------------|
| Grammage, g/m <sup>2</sup>         | ±4%               | 190  | 200  | 210  | 220  | 230  | 240  | 250  | 260  | 275  | 300  | 325  | ISO 536    |
| Thickness, µm                      | ±4% or max. ±20µm | 350  | 375  | 400  | 420  | 440  | 460  | 480  | 500  | 540  | 600  | 650  | ISO 534    |
| Bending moment Taber 15° MD, mNm   | -10%              | 8.7  | 10.2 | 12.4 | 14.1 | 15.7 | 17.5 | 19.9 | 21.9 | 25.8 | 32.9 | 39.7 | ISO 2493   |
| Bending moment Taber 15° CD, mNm   | -10%              | 4.6  | 5.5  | 6.6  | 7.5  | 8.3  | 9.3  | 10.5 | 11.6 | 13.6 | 17.3 | 20.9 |            |
| Bending resistance L&W 15° MD, mN  | -10%              | 180  | 211  | 257  | 292  | 325  | 362  | 412  | 453  | 534  | 681  | 822  |            |
| Bending resistance L&W 15° CD, mN  | -10%              | 95   | 114  | 137  | 155  | 172  | 193  | 217  | 240  | 282  | 358  | 433  |            |
| Bending stiffness DIN 5° MD, mNm   | -10%              | 17.4   | 20.3 | 24.7 | 28.1 | 31.3 | 34.9 | 39.7 | 43.7 | 51.5 | 65.6 | 79.2 | DIN 53121  |
| Bending stiffness DIN 5° CD, mNm   | -10%              | 9.2  | 11.0 | 13.2 | 15.0 | 16.6 | 18.6 | 20.9 | 23.1 | 27.1 | 34.5 | 41.7 |            |
| Moisture, %                        | ±1                | 7.5  | 8.0  | 8.0  | 8.0  | 8.0  | 8.0  | 8.0  | 8.0  | 8.5  | 8.5  | 9.2  | ISO 287    |
| ISO Brightness C/2°, %, Top        | min. 78           | 80   | 80   | 80   | 80   | 80   | 80   | 80   | 80   | 80   | 80   | 80   | ISO 2470-1 |
| Surface Smoothness PPS 10, µm, Top |                   | 2.4  | 2.4  | 2.4  | 2.4  | 2.4  | 2.4  | 2.4  | 2.4  | 2.4  | 2.4  | 2.4  | ISO 8791-4 |
| Scott Bond, J/m <sup>2</sup>       | min. 100          | 130  | 130  | 130  | 130  | 130  | 130  | 130  | 130  | 130  | 130  | 130  | TAPPI 569  |
| Edge wicking*, g/mm.m              |                   | <1.0   | <1.0 | <1.0 | <1.0 | <1.0 | <1.0 | <1.0 | <1.0 | <1.0 | <2.0 | <2.0 |            |
| Robinson chocolate test            |                   | max. 0.5 for one year storage in reels/pallets |      |      |      |      |      |      |      |      |      |      | EN 1230-2  |

OBA not added

\*) For hardsized

All properties according to Ingerois 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.

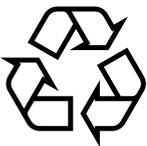
## Coated folding boxboard with cream uncoated reverse

### 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

Tamfold offers excellent value, runnability and performance in pharmaceutical packaging, food packaging and chocolate packaging. Tamfold is also particularly well suited for food service, such as clamshells used for fast-food packaging, since there is no added OBA (Optical Brightening Agents). The continuous product development of Tamfold has resulted in excellent stiffness and bulk attributes, and the board also performs well in printing and converting processes, including digital printing, laser and inkjet coding, as well as Braille embossing.

### Printing and finishing techniques

The product can be used with different printing techniques such as offset, flexo, rotogravure 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 105/2013 and PTS-DF 103/2011 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.