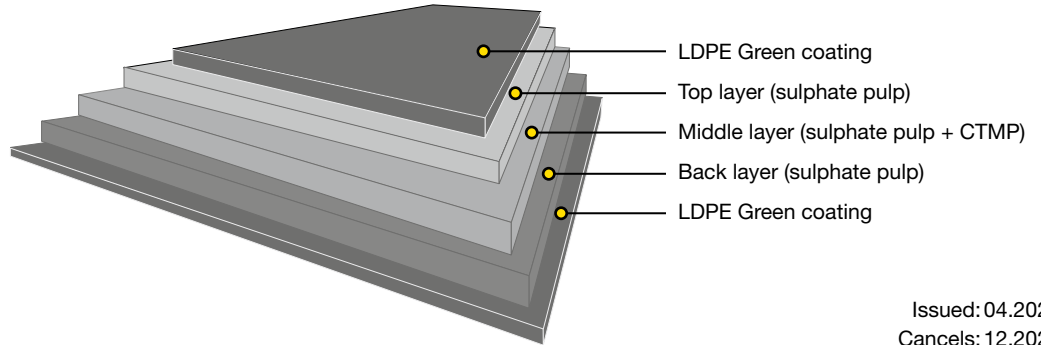# Cupforma Natura™ 2PE Green

Bleached cup board with renewable coating

Cupforma Natura 2PE Green is a virgin-fibre bleached board with a three layer fibre construction and with CTMP (chemi-thermomechanical pulp) in the middle layer and renewable LDPE coating on both sides.

LDPE Green coating
Top layer (sulphate pulp)
Middle layer (sulphate pulp + CTMP)
Back layer (sulphate pulp)
LDPE Green coating

Issued: 04.2023
Cancels: 12.2021

Technical specification

Polymer coated board:	Tolerance	12+170+15	12+184+15	12+195+15	12+214+15	12+232+15	12+260+15	12+295+15	12+330+15	Standard
Grammage, g/m²	±5%	197	211	222	241	259	287	322	357	ISO 536
LDPE Green topside, g/m²	±2	12	12	12	12	12	12	12	12	Mill method
LDPE Green reverse, g/m²	±2	15	15	15	15	15	15	15	15	
Thickness, µm	±6%	235	270	295	320	350	390	430	470	ISO 534
Corona treating, dyne/cm, top *)	min 38	42	42	42	42	42	42	42	42	ASTM D 2578
Baseboard:										
Grammage, g/m²	±4%	170	184	195	214	232	260	295	330	ISO 536
Thickness, µm	±5%	215	250	275	300	330	370	410	450	ISO 534
Bending resistance L&W 15° MD, mN	min -25%	65	105	130	160	215	290	380	500	ISO 2493-1
Bending resistance L&W 15° CD, mN	min -25%	28	43	55	75	95	130	170	230	
Moisture %	min 7.0%	9.0	8.0	8.0	8.0	8.0	8.0	8.0	8.0	ISO 287
Brightness D65/10, %, Top	min 80	84	84	84	84	84	84	84	84	ISO 2470-2
Surface Smoothness, Bendtsen, ml/min	max 400	150	200	250	250	300	300	300	300	ISO 8791-2
Stretch CD, %	min 4.5%	6.0	6.0	6.0	6.0	6.0	6.0	6.0	6.0	ISO 1924-3

*) Measured right after PE coating
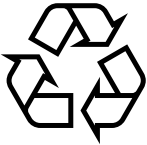
Cupforma™
by Stora Enso

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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
www.fsc.org
MIX
Board | Supporting
responsible forestry
FSC® C127282

PEFC
PEFC/02-31-71
Promoting
Sustainable Forest
Management
www.pefc.fi

FSC and PEFC certified board available upon request.

Paperboard can be recycled

Key characteristics and main enduses

Cupforma Natura 2PE Green is a sustainable choice; a high-quality carton board designed especially for cups. 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. Cupforma Natura 2PE Green delivers excellent results in flexographic, offset, and digital printing. Cupforma Natura 2PE Green is produced with renewable LDPE coating. It can be sealed as easy as with traditional LDPE, and used for cold drinks, soups, chilled foods, and ice cream.

Printing and finishing techniques

The product can be used for different printing techniques such as offset, flexo anddigital printing. It is important to check possible limitations of the printing and convertingequipment 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 importantthat a new commercial digital print job is always preceded by a trial run, including allrequired 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.

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