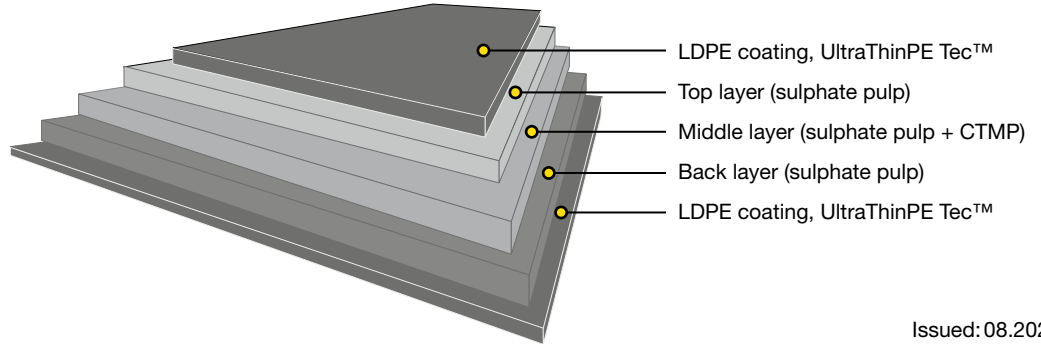


Cupforma Natura™ 2PE

Bleached cup board with PE coating, UltraThinPE Tec™

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



Issued: 08.2023
Cancels: -

Technical specification

| Polymer coated board: | Tolerance | 11+170+11 | 11+184+11 | 11+195+11 | 11+214+11 | 11+232+11 | 11+260+11 | 11+295+11 | 11+330+11 | Standard |
|--------------------------------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-------------|
| | | | | | | | | | | |
| Grammage, g/m ² | ±5% | 192 | 206 | 217 | 236 | 254 | 282 | 317 | 352 | ISO 536 |
| LDPE topside, g/m ² | ±2 | 11 | 11 | 11 | 11 | 11 | 11 | 11 | 11 | Mill method |
| LDPE reverse, g/m ² | ±2 | 11 | 11 | 11 | 11 | 11 | 11 | 11 | 11 | |
| Thickness, µm | ±6% | 230 | 265 | 290 | 315 | 345 | 385 | 425 | 465 | ISO 534 |
| Corona treating, dyne/cm, top *) | min 39 | 42 | 42 | 42 | 42 | 42 | 42 | 42 | 42 | ASTM D 2578 |
| Baseboard: | | | | | | | | | | |
| Grammage, g/m ² | ±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



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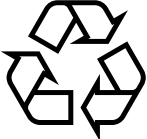
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Certificates

- 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 can be recycled

Key characteristics and main enduses

Cupforma Natura 2PE 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 delivers excellent results in flexographic, offset and digital printing. Combined with LDPE coating on both sides, Cupforma Natura is sealed easily into a cup, 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 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.