Performa Natura™

Performa Natura is a board with a three layer fibre construction and with CTMP (chemi-thermomechanical pulp) in the middle layer and a double-pigment-coated top side.

Double pigment coating
Chemical pulp
Chemical pulp + CTMP
Chemical pulp
Surface sizing
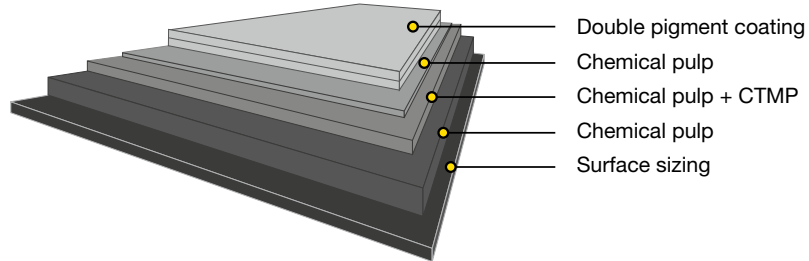
Issued: 02.2024
Cancels: 09.2017

Technical specification

Property / Unit	Tolerance									Standard
Grammage, g/m²	±4%	195	210	230	255	270	295	320	350	ISO 536
Thickness, µm	±4%	260	280	320	350	390	430	470	510	ISO 534
Bending resistance L&W 15° MD, mN	-15%	120	155	215	270	360	475	600	760	ISO 2493
Bending resistance L&W 15° CD, mN	-15%	55	70	95	125	170	210	270	340	
Bending moment Taber 15° MD, mNm	-15%	5.8	7.5	10.4	13.0	17.4	22.9	29.0	36.7	
Bending moment Taber 15° CD, mNm	-15%	2.7	3.4	4.6	6.0	8.2	10.1	13.0	16.4	
Bending stiffness DIN 5° MD, mNm	-15%	10.2	13.2	18.3	23.0	30.6	40.4	51.0	64.6	
Bending stiffness DIN 5° CD, mNm	-15%	4.7	6.0	8.1	10.6	14.5	17.9	23.0	28.9	
Moisture, %		6.5	6.5	6.5	6.5	6.5	6.5	6.5	6.5	ISO 287
ISO Brightness C/2°, %, Top		85	85	85	85	85	85	85	85	ISO 2470-1
Brightness D65/10°, %, Top		85	85	85	85	85	85	85	85	ISO 2470-2
Surface Smoothness, PPS 10, µm, Top		1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	ISO 8791-4
Gloss 75°, %		45	45	45	45	45	45	45	45	ISO 8254-1
Scott Bond, J/m²		200	200	200	200	200	200	200	200	TAPPI 569
Robinson chocolate test		max 0.5 for one year storage in reels/pallet								EN 1230-2

OBA not added

All properties according to Imatra 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.
Bending moment Taber 15° and Bending resistance L&W 15° are binding, Bending stiffness DIN 5° are indicative.
Bending moment Taber 15° calculated from Bending resistance L&W 15°.

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Fully coated CTMP board with 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
www.fsc.org
MIX
Board | Supporting responsible forestry
FSC® C127282

PEFC
PEFC/02-31-247
PEFC Certified
www.pefc.org

FSC and PEFC certified board available upon request.

OK compost
TÜV AUSTRIA
INDUSTRIAL
S0249

Industrially compostable according to EN 13432 standard.

OK compost
TÜV AUSTRIA
HOME
S0249

For grammages ≤ 320g/m² home compostable according to TÜV Austria's Home composting certification scheme.
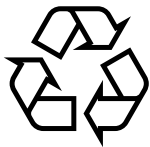
Paperboard can be recycled

Key characteristics and main enduses

Performa Natura features a technically advanced structure for material efficiency, toughness, bulk and runnability. No optical brightening additives are used in production of Performa Natura. As an OBA non-added board Performa Natura is highly suitable for pharmaceuticals, food and chocolate packaging. This product is compostable in industrial and home composting and can be collected together with food waste in most collecting schemes.

Printing and finishing techniques

The product can be used with different printing techniques such as offset, flexo and digital printing. In digital printing, the product is suitable for several different sheet- or web-fed presses. 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. It is suitable for laser coding. Certificate according to PTS-DF 105/2019 is 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.

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